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(54) **APPARATUS AND METHOD OF FABRICATING A DOOR**

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B23P 15/12 (2006.01)
B21D 39/03 (2006.01)
E06B 3/964 (2006.01)
E04C 2/54 (2006.01)
B32B 3/00 (2006.01)

(52) **U.S. Cl.** **29/897.31**; 29/897; 29/428; 52/204.62; 52/784.1; 52/784.15; 52/784.16; 428/71

(58) **Field of Classification Search** 29/897, 29/897.31, 428; 52/204.62, 309.9, 455, 784.1, 52/784.15, 784.16; 72/453.13; 428/71

See application file for complete search history.

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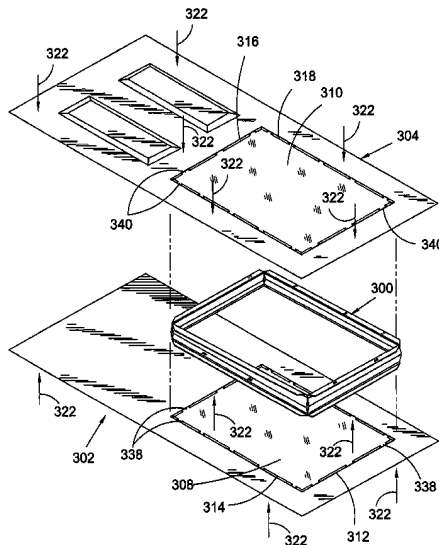
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(57) **ABSTRACT**

A method for fabricating a door having a window, the door having a first door skin and a second door skin, the method including the following steps in the order named: forming a first door light opening perimeter having a first plurality of tabs arranged about the first door light opening perimeter, wherein the first door light opening perimeter defines a first door light portion; forming a second door light opening perimeter having a second plurality of tabs arranged about the second door light opening perimeter, wherein the second door light opening perimeter defines a second door light portion; positioning the first door skin on a first press; positioning an insert in aligned registration with the first plurality of tabs; positioning the second door skin over the insert, wherein the second plurality of tabs are in aligned registration with the insert, and the first door light opening perimeter is aligned with the second door light opening perimeter; applying pressure with the first press to secure the first and second door skins with the insert; injecting a foam into a first cavity formed between the first skin outside the first door light portion, the second door skin outside the second door light portion and the insert; and, removing the first and second door light portions.

9 Claims, 17 Drawing Sheets



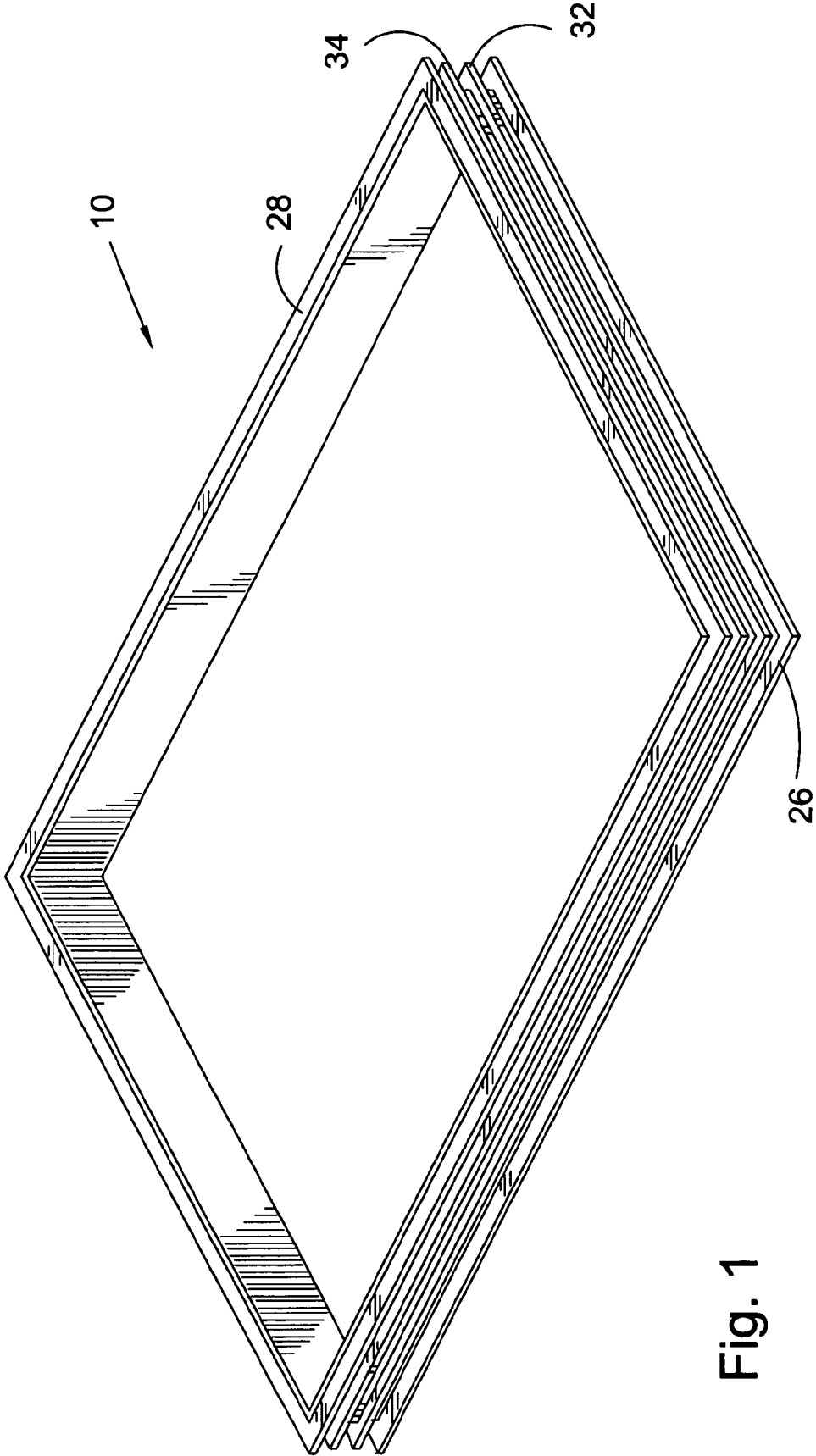


Fig. 1

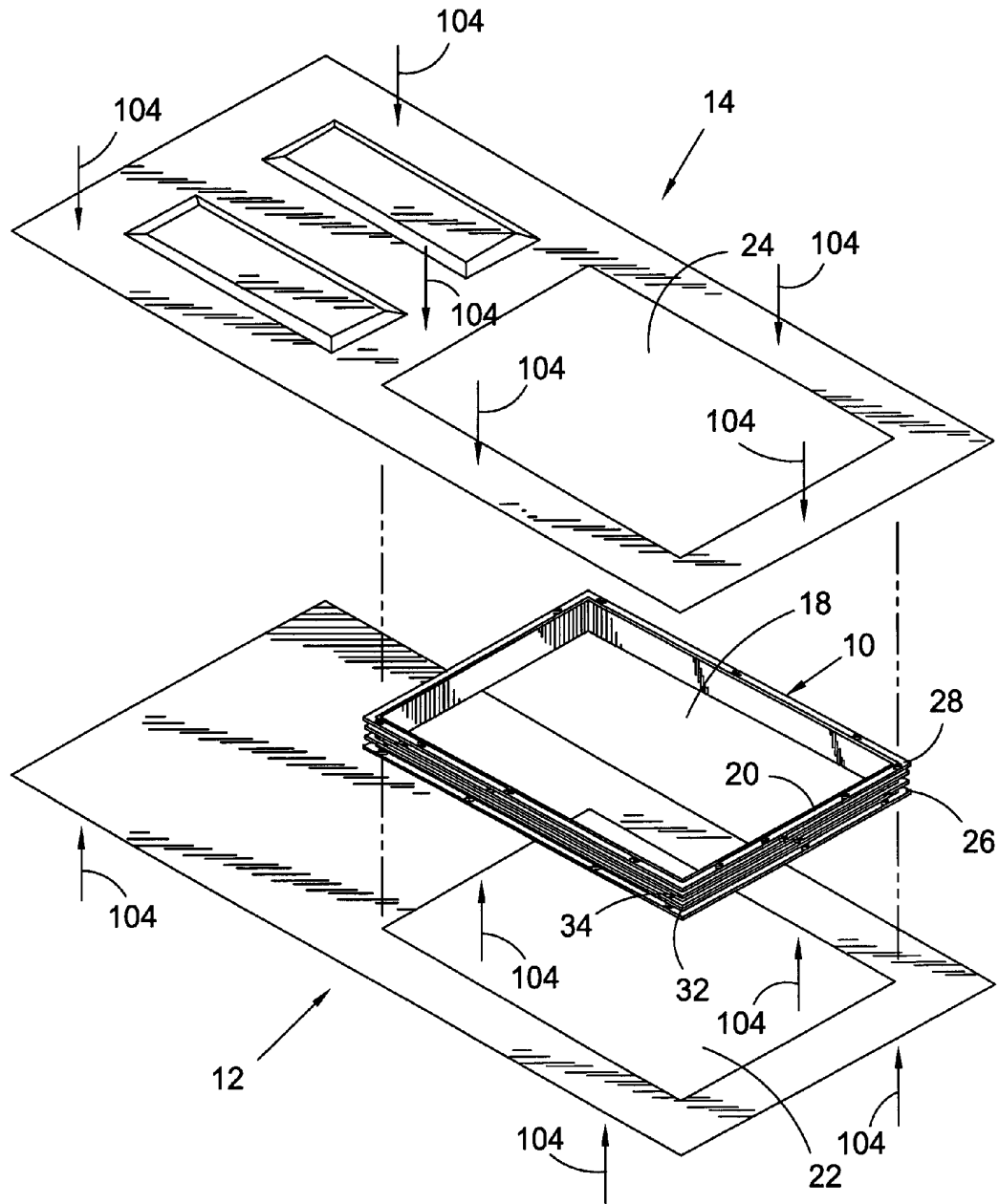


Fig. 2

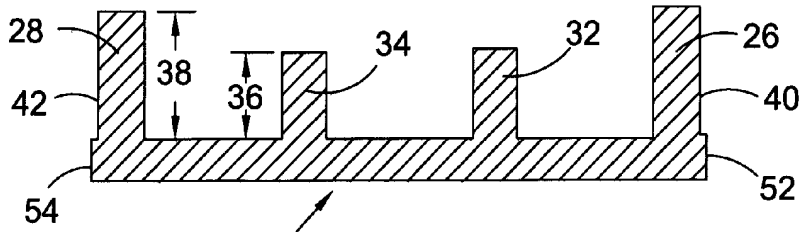


Fig. 3

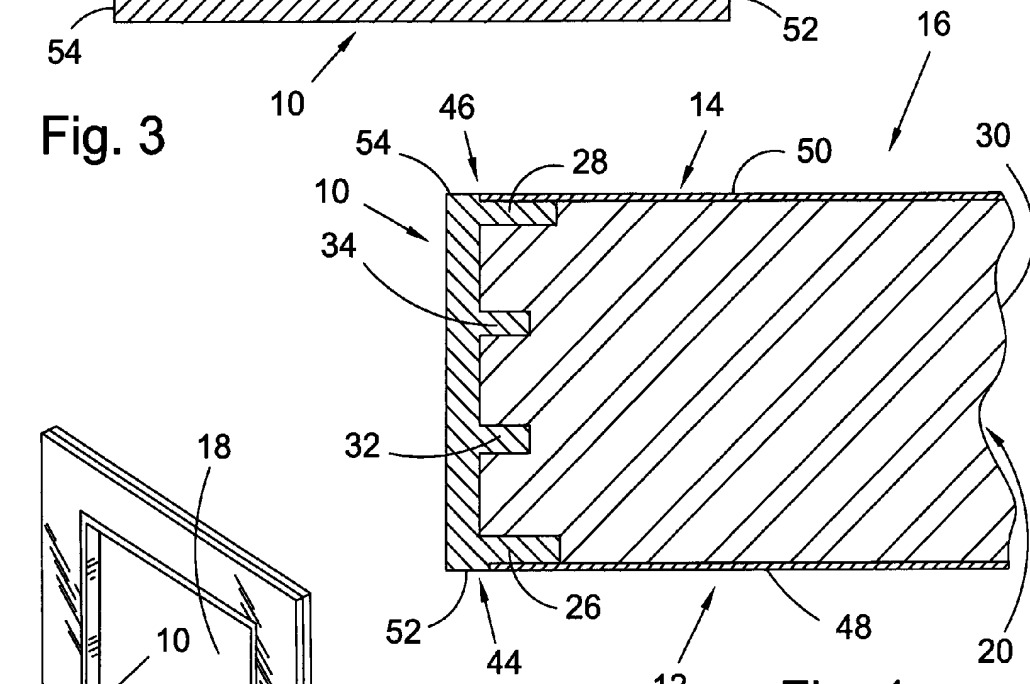


Fig. 4

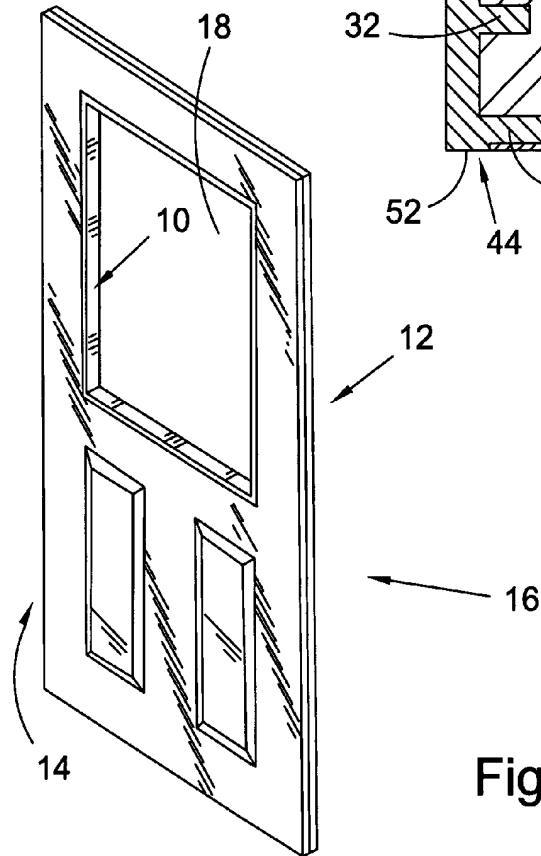


Fig. 5

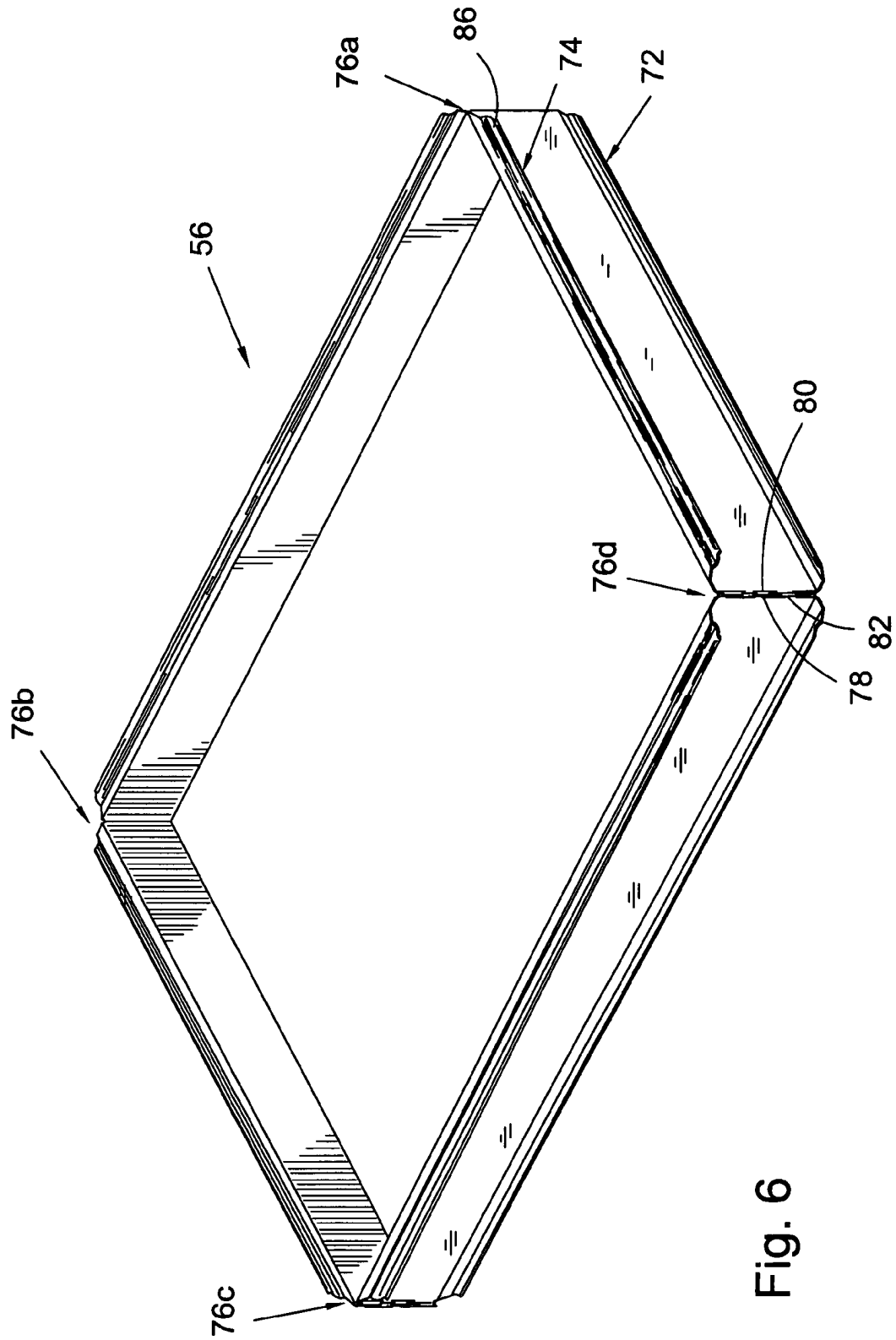


Fig. 6

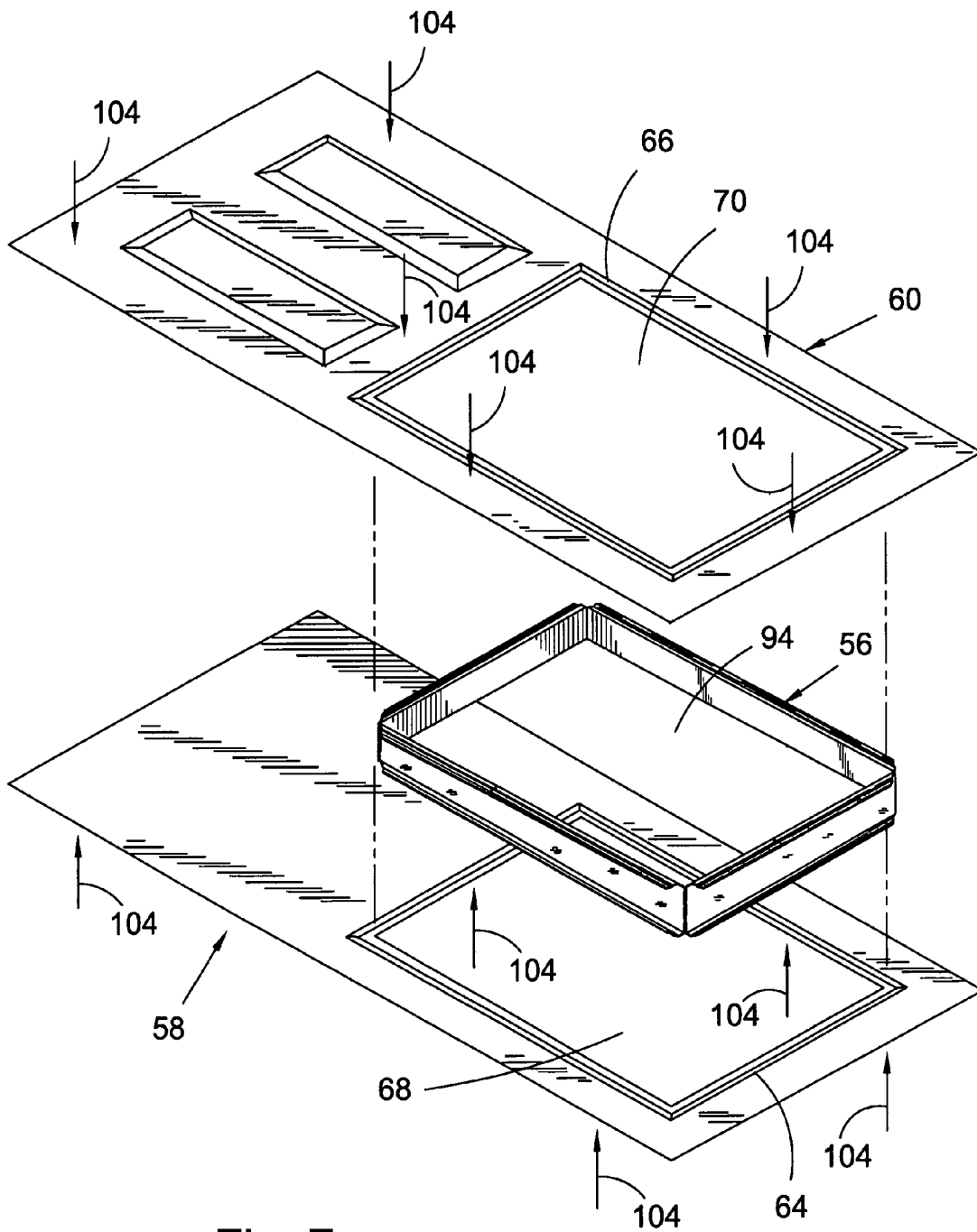


Fig. 7

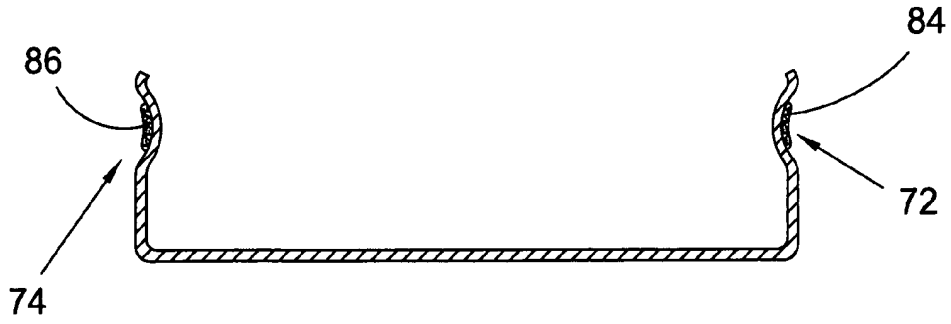


Fig. 8

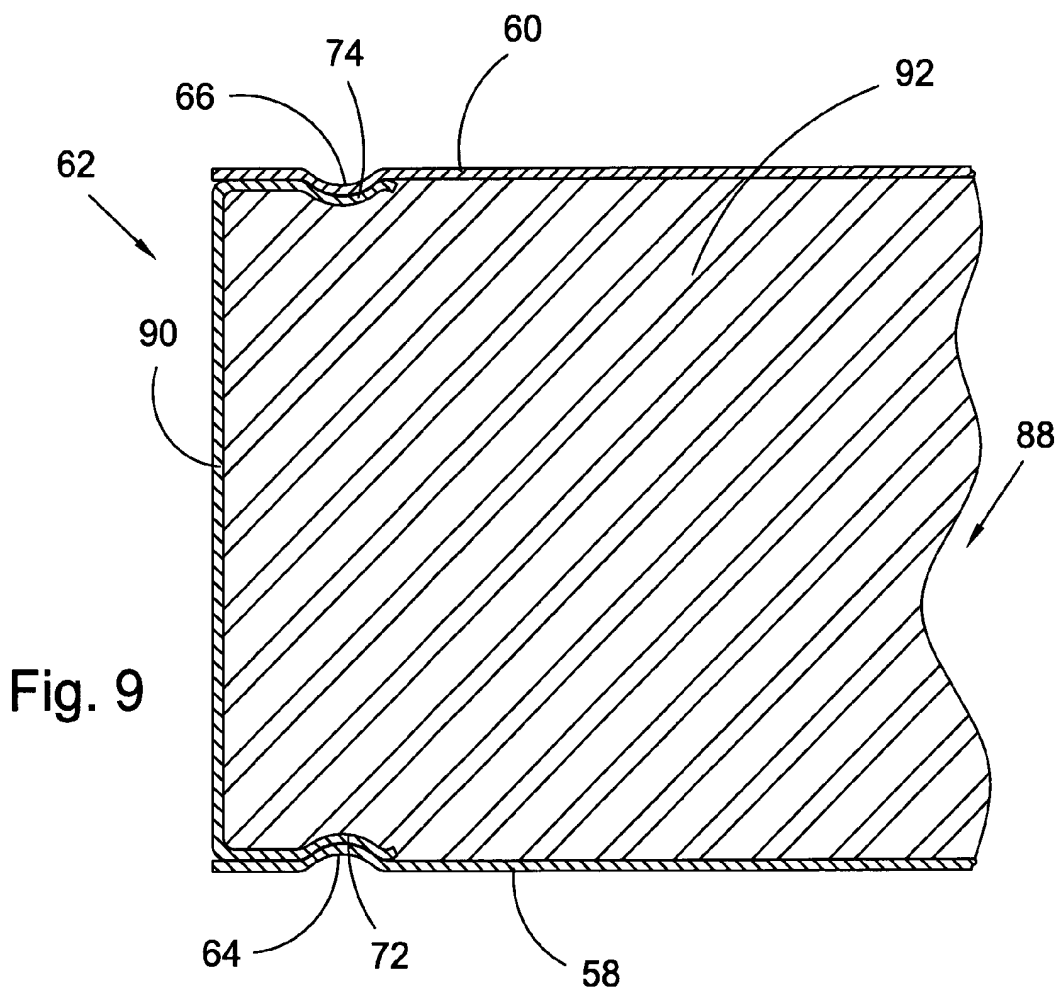


Fig. 9

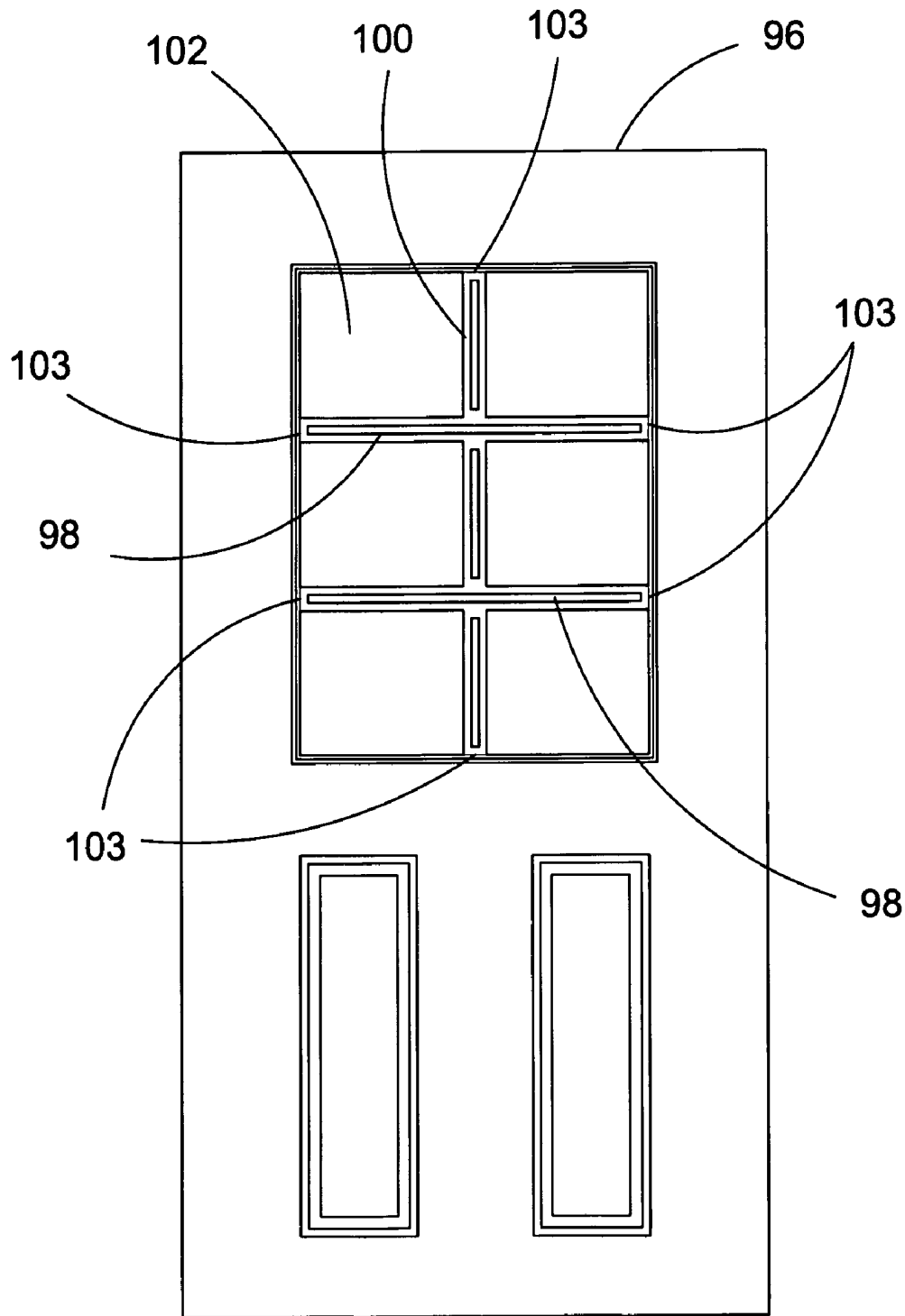


Fig. 10

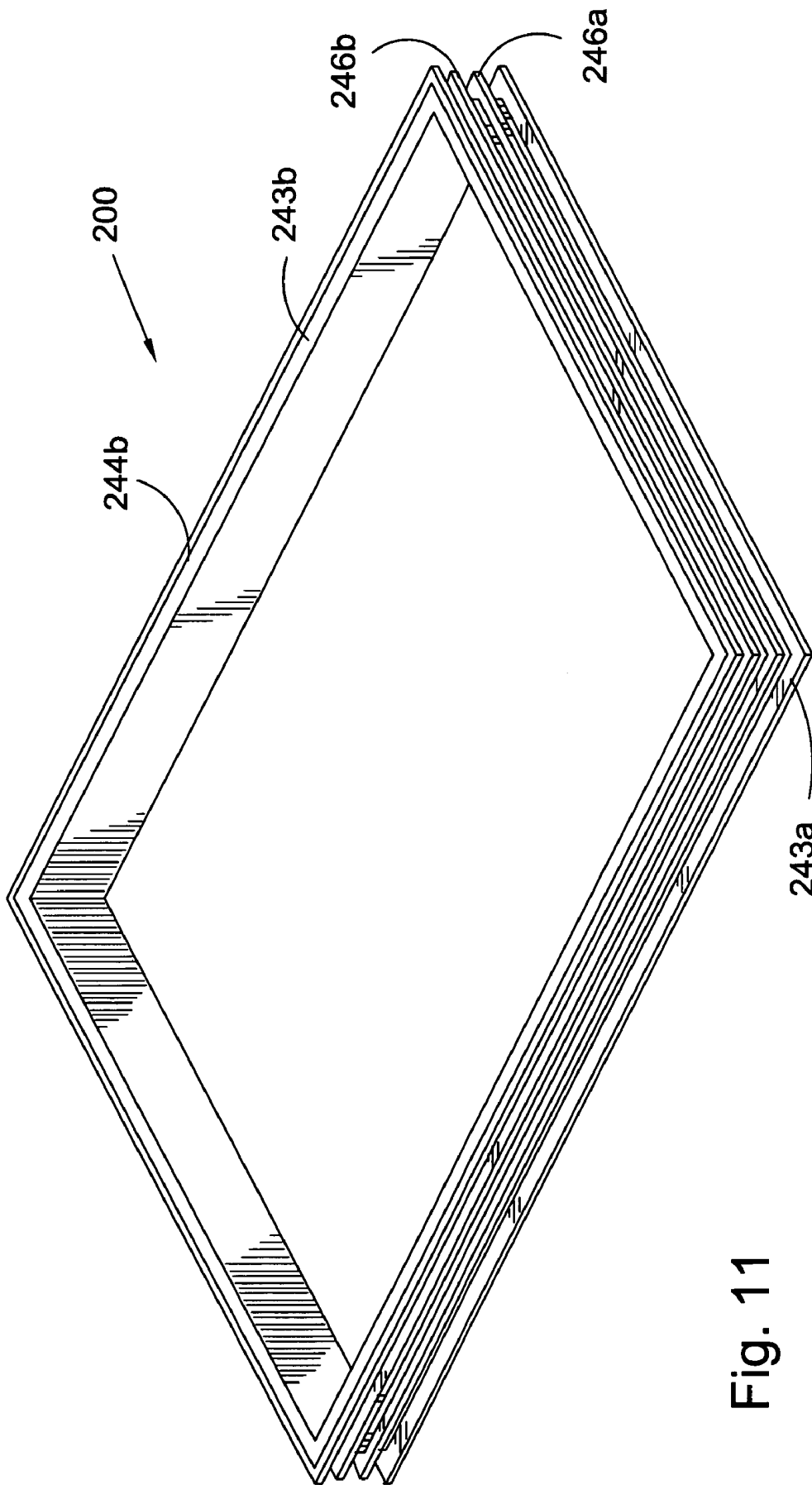


Fig. 11

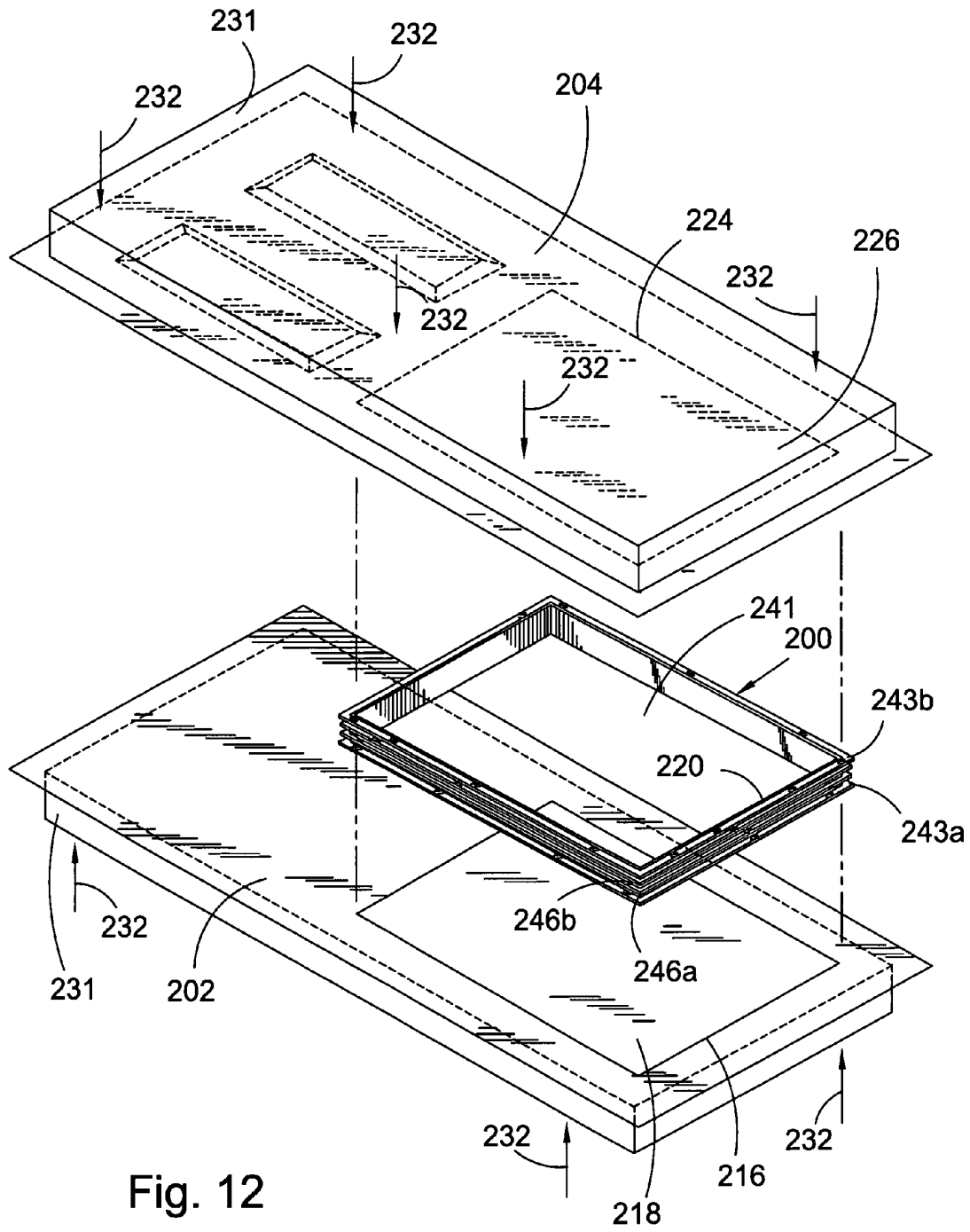


Fig. 12

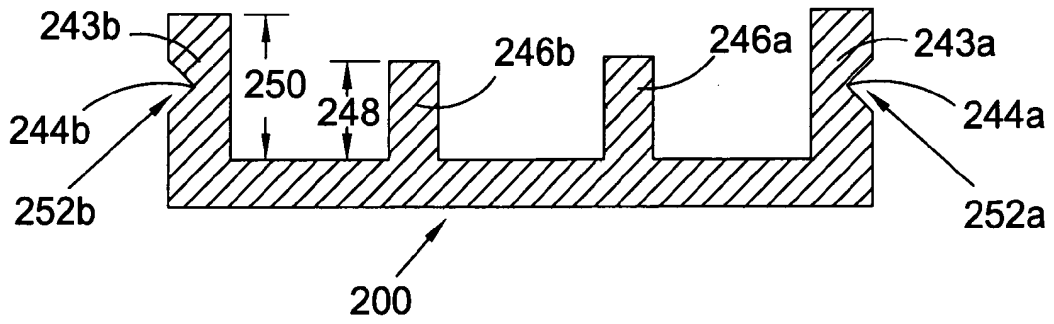


Fig. 13

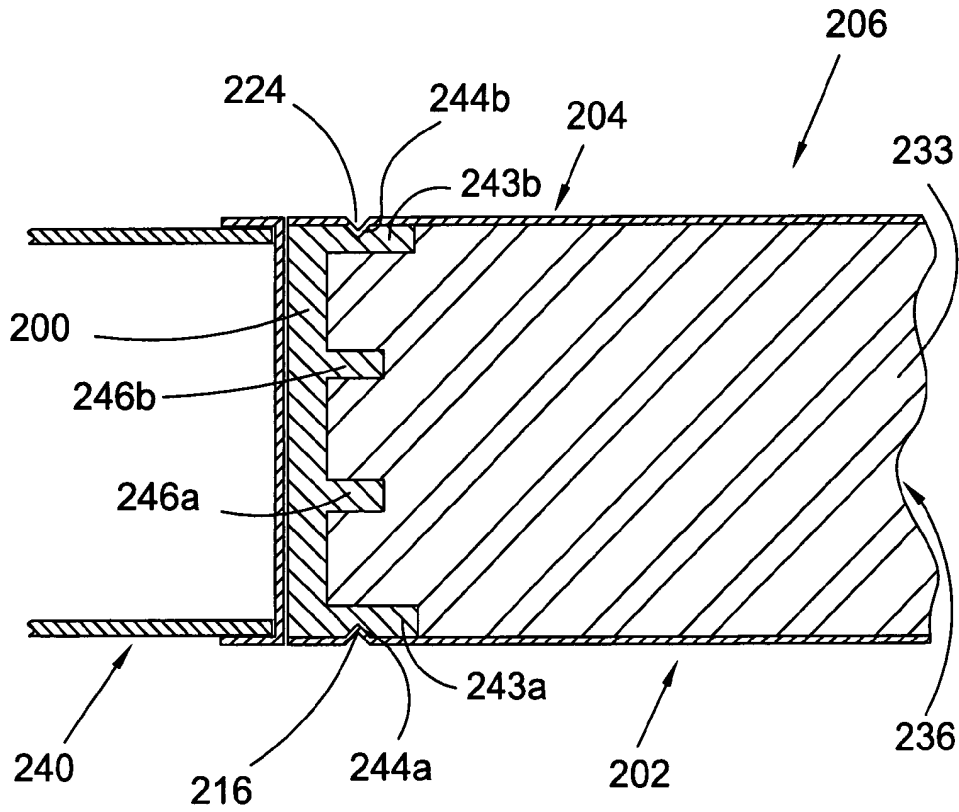


Fig. 14

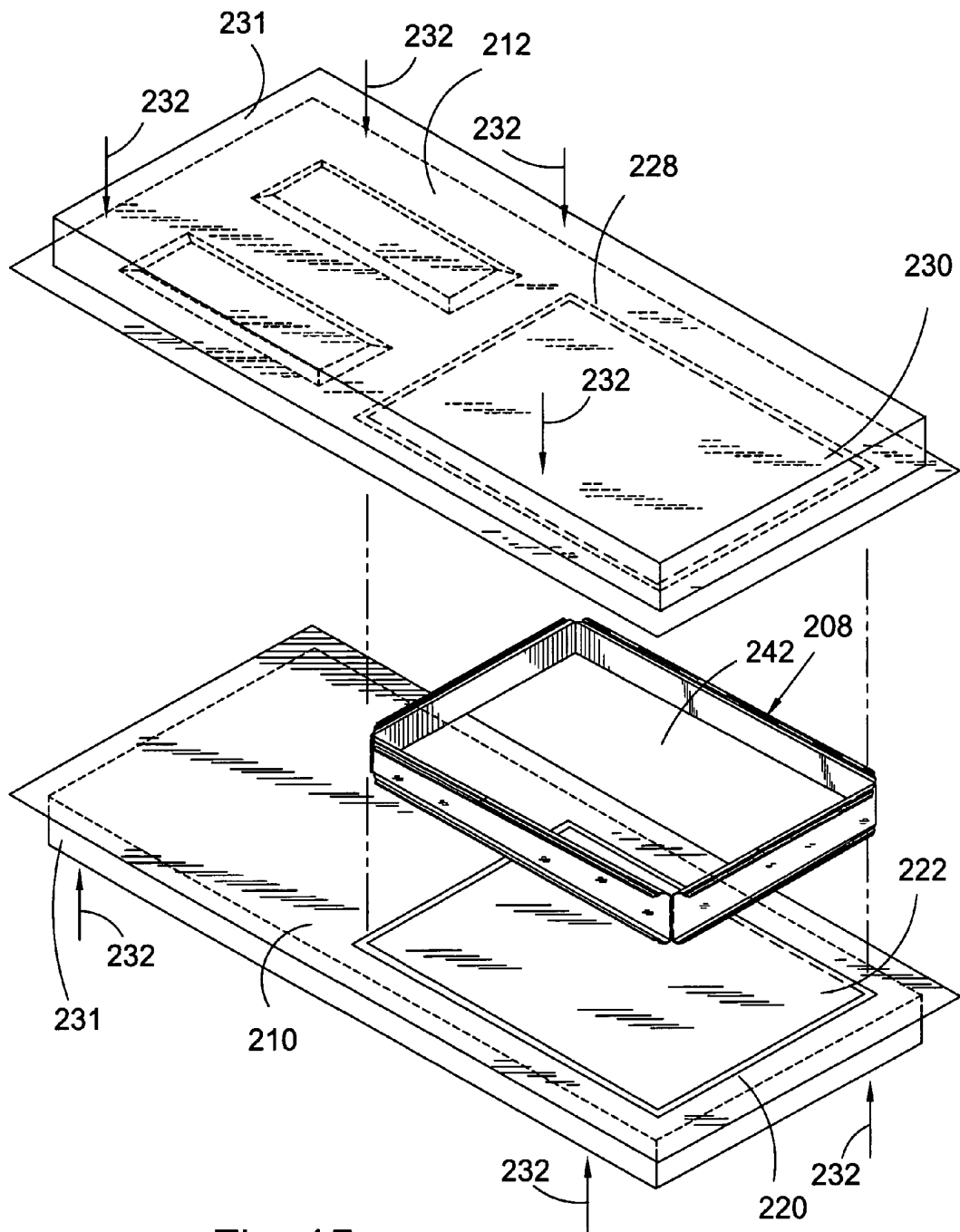


Fig. 15

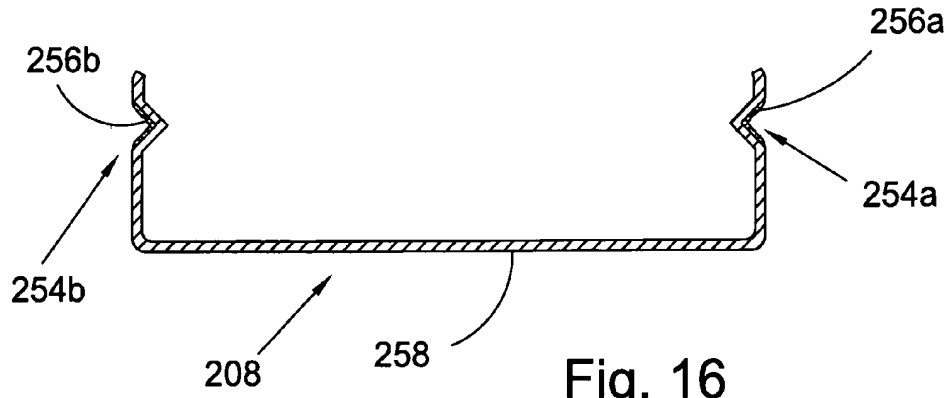


Fig. 16

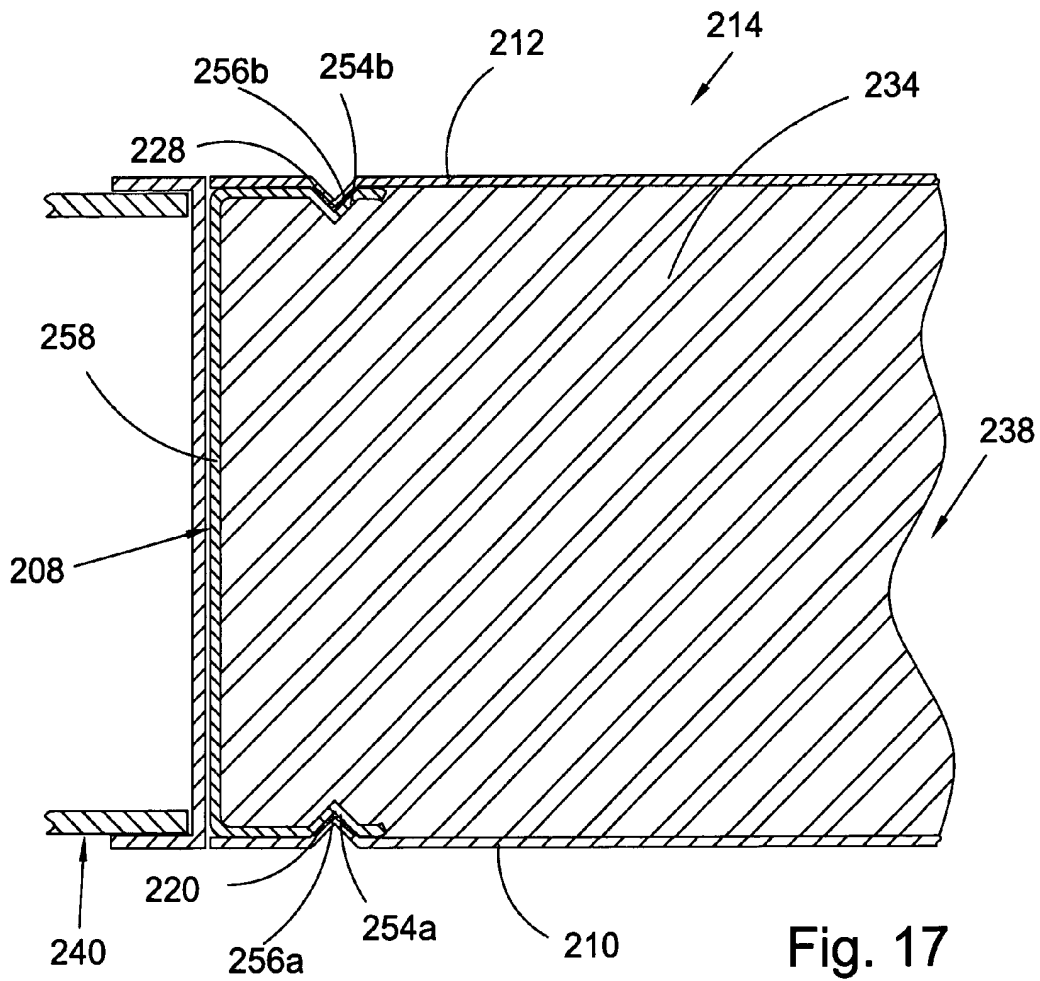


Fig. 17

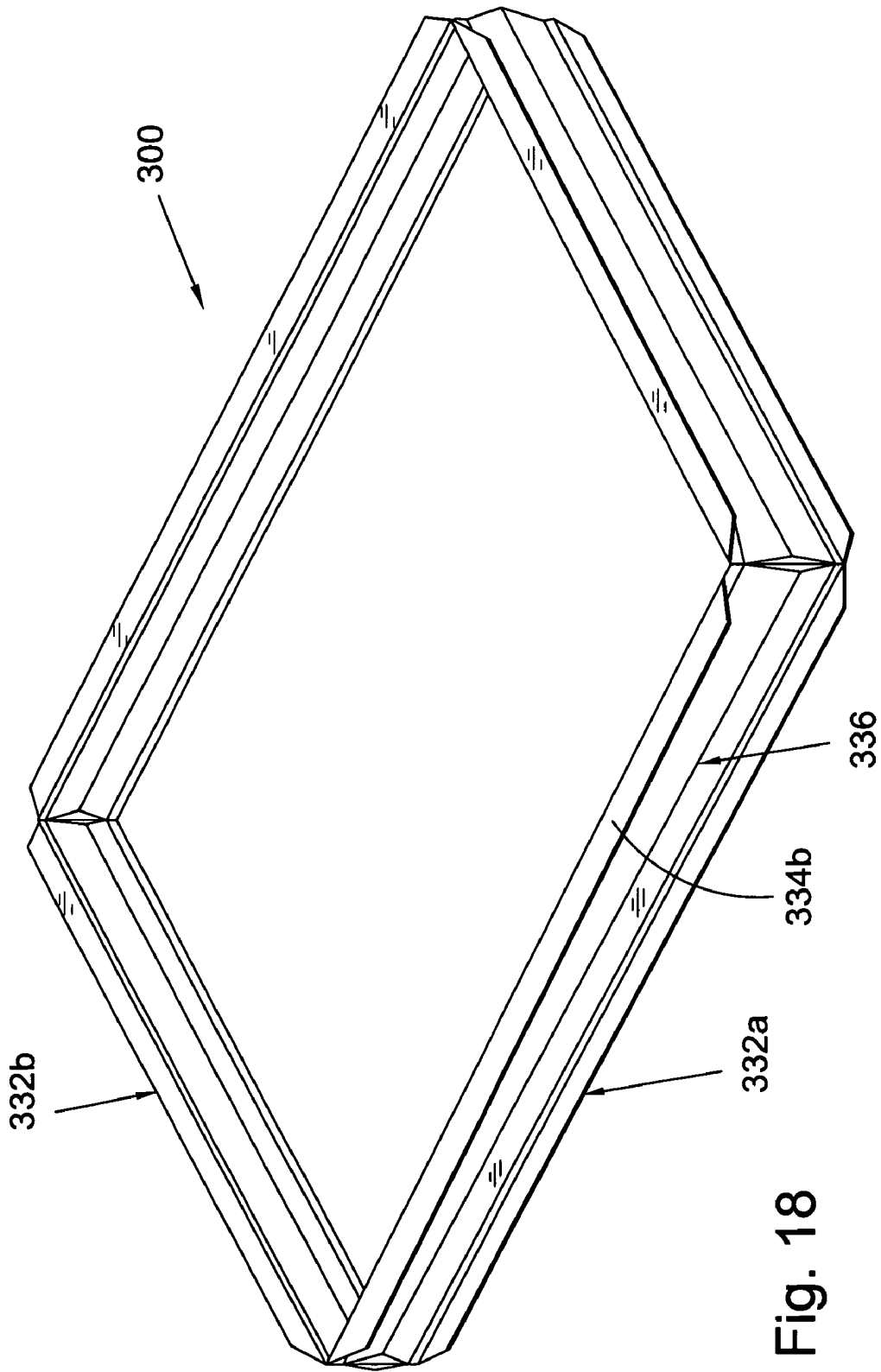


Fig. 18

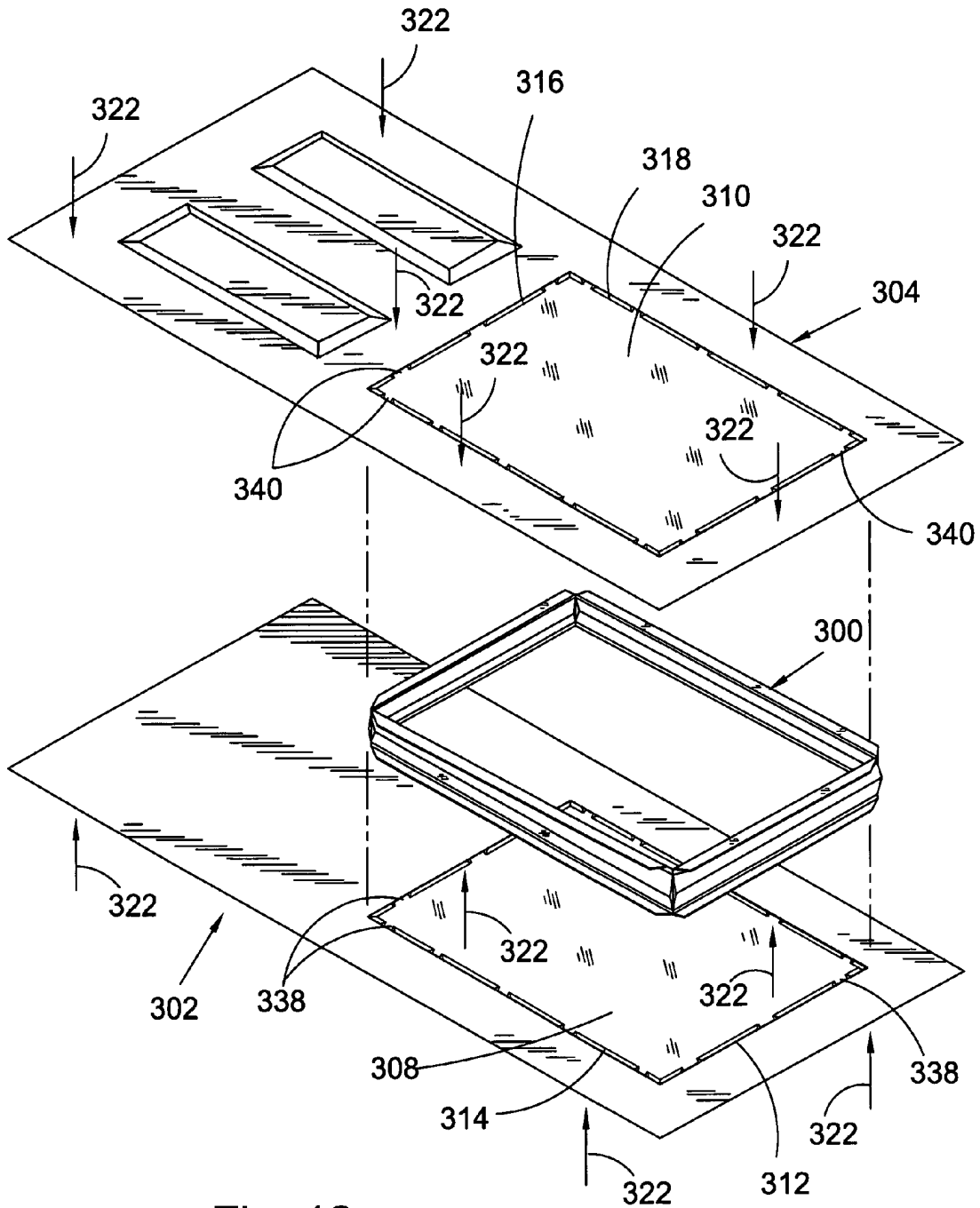


Fig. 19

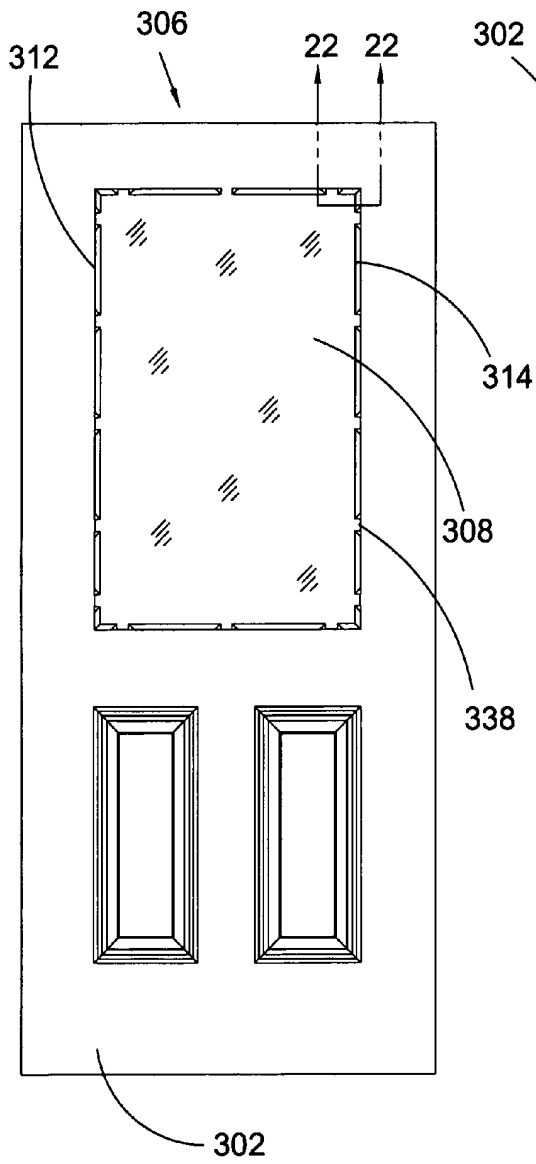


Fig. 20

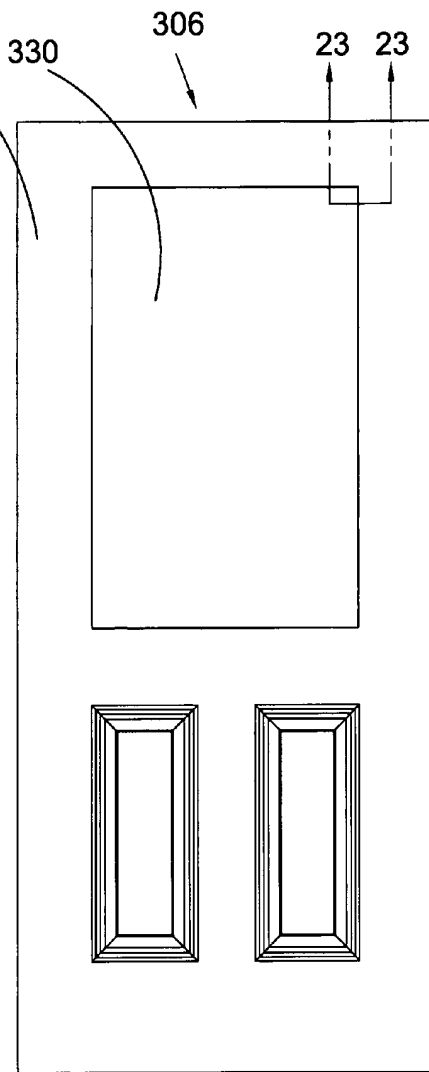


Fig. 21

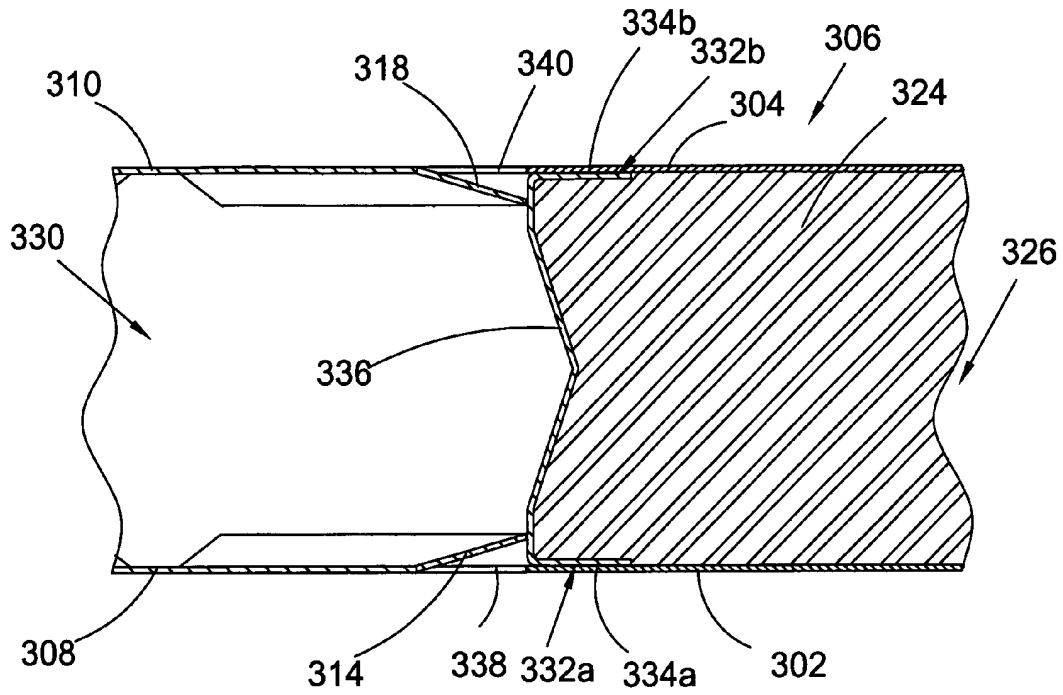


Fig. 22

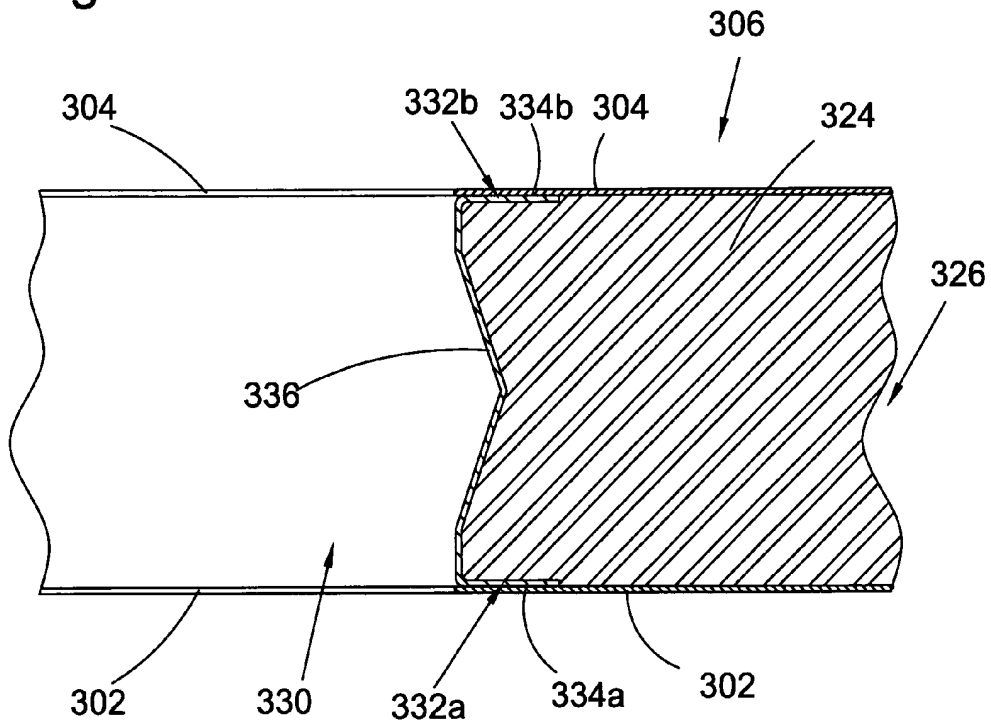


Fig. 23

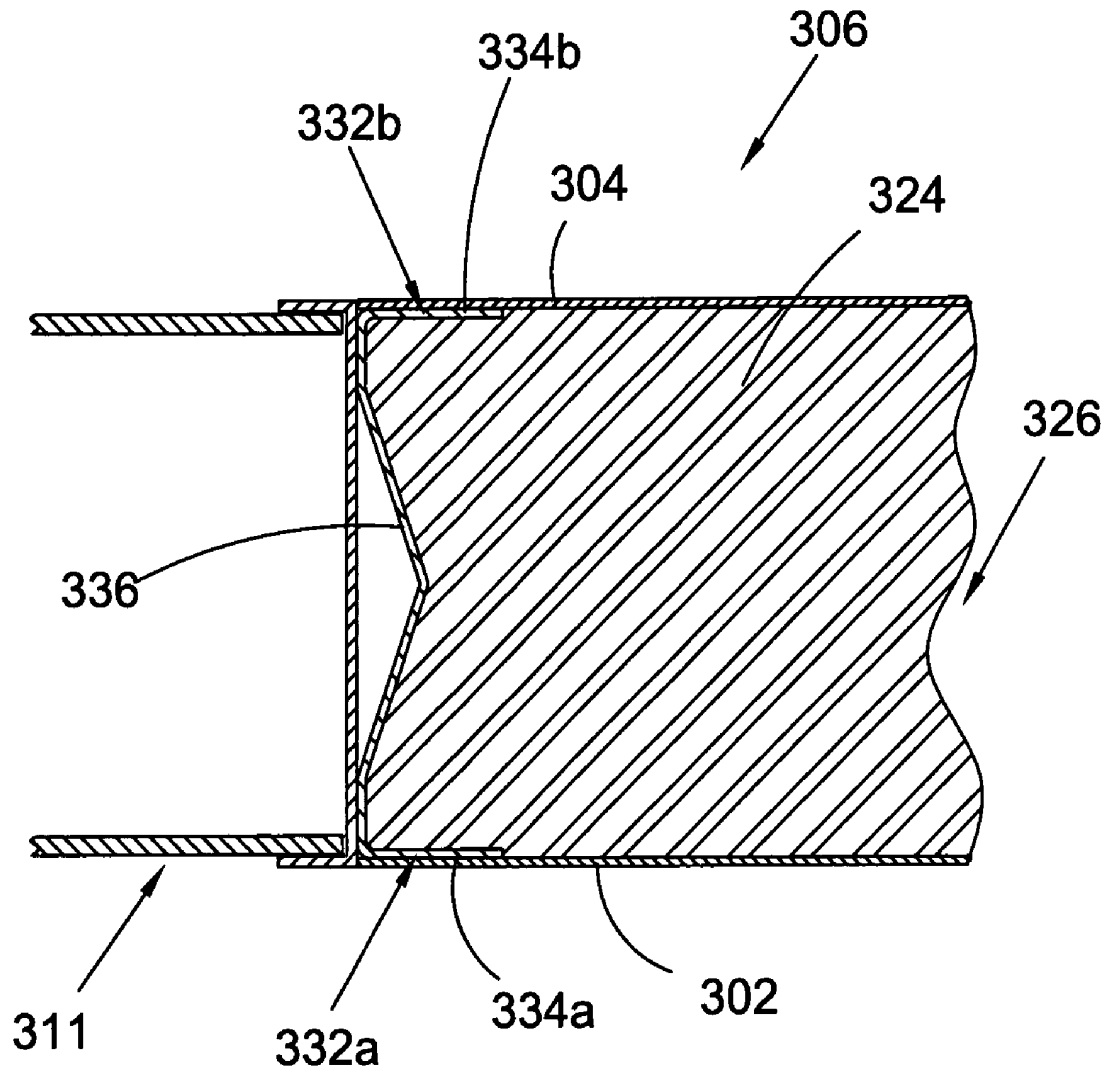


Fig. 24

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APPARATUS AND METHOD OF FABRICATING A DOOR

CROSS-REFERENCE TO RELATED APPLICATIONS

This application is a Continuation-in-Part of application Ser. No. 11/786,919, filed on Apr. 13, 2007 now abandoned, which application is incorporated herein by reference.

FIELD OF THE INVENTION

The invention broadly relates to doors, more specifically to lights for doors, and even more particularly to lights for doors constructed from complimentary door skins. The invention also broadly relates to a method of fabricating a door with a door light perimeter defined within the door skins before assembly and arranged to accommodate a window. The invention also relates to an apparatus for carrying out the method of fabrication.

BACKGROUND OF THE INVENTION

Typically, doors constructed of steel or fiberglass comprise two molded door skins forming the front and back surfaces of the door. The door skins are joined together and filled with an expanding foam core which provides insulation, e.g., thermal and sound, and increases structural integrity. Reinforcing and mounting strips, made typically of wood, are sometimes used to provide additional structural and internal integrity when needed.

Each door skin generally has rolled edges to define a perimeter edge used to secure the door skins together when assembled. The door skins are aligned and positioned within a press which forces the perimeter edges together and locks them in place. After the door skins are secured together, synthetic insulation foam is injected between the skins filling the cavity formed therebetween.

For example, contemporary metallic doors are constructed of thin metallic door skins that form the exterior of the door. Door skins are formed from hot dipped galvanized deep drawn steel that is stamped into a desired door shape. The door skins form the exterior of the door and can be joined at the perimeter of the skins by flanges, as previously described, or the door skins can be joined to a frame, e.g., a wood frame, between the skins. Subsequently, a foam core is used to fill the internal cavity left between the door skins, as described supra.

If the door is intended to have a window opening, commonly known to those of ordinary skill in the art as a door light, an additional fabrication step is required. The opening must be cut out to remove the respective door skin areas, and includes the foam core therebetween. The cut out, including both the metal skins and foam, subsequently becomes a waste product that must be disposed of as there is no further use that can be made of the cut out. In fact, waste products of this type are typically considered hazardous waste due to the presence of the foam, and therefore, special waste disposal considerations must be taken into account.

Although the finished door does not include the above described waste material, the finished door cost does include the cost of these materials. Thus, end users must pay more for a door having less material, i.e., after the window opening is formed. In some instances, manufacturers of finished doors cut the window opening in their facility as opposed to having the raw door manufacturer perform this operation. Thus, an uncut door which includes all the additional waste material must be shipped to the finishing manufacturer. The uncut

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doors weigh more than cut doors and therefore shipping costs are also increased thereby raising the final cost to an end user.

As can be derived from the variety of devices and methods directed at forming doors and in particular forming doors having a light, many means have been contemplated to accomplish the desired end, i.e., constructing a low cost, high quality door with at least one light. Heretofore, tradeoffs between material waste generated during manufacture and cost were required. Thus, there is a long-felt need for a door constructed from door skins having a door light perimeter defined therein prior to filling the door with insulating foam. There is a further long-felt need for a door having a door light and a reduced overall weight. There is also a long-felt need for a door having a door light which generates a reduced amount of waste during assembly. There is yet also a long-felt need for a door having a door light which generates recyclable waste during assembly.

BRIEF SUMMARY OF THE INVENTION

The present invention broadly comprises a method for fabricating a door having a window, the door having a first door skin and a second door skin, the method including the following steps in the order named: a) forming a first door light opening perimeter and a second door light opening perimeter in the first and second door skins, respectively, wherein the first and second door light opening perimeters define a first portion and a second portion, respectively; b) positioning the first door skin on a first press; c) positioning an insert in aligned registration with the first door light opening perimeter of the first door skin; d) positioning the second door skin over the insert, wherein the second door light opening perimeter is in aligned registration with the insert and the first door light opening perimeter; e) applying pressure with the first press to secure the first and second door skins with the insert; f) injecting a foam into a first cavity formed between the first and second door skins and the insert; and, g) removing the first and second portions. In an embodiment, the method further includes the step of: h) inserting the window within a second cavity formed by the insert.

In an embodiment, the insert includes a pair of engagement flanges for aligned registration and engagement with the first and second door skins, each of the pair of engagement flanges includes a groove arranged for receipt of one of the first or second door light opening perimeters therein. In an embodiment, the insert further includes a secondary pair of flanges positioned substantially parallel and between the pair of engagement flanges, the secondary pair of flanges are encapsulated by the foam within the cavity during the injection step. In an embodiment, the secondary flanges are equal in length but shorter in length than either of the engagement flanges. In an embodiment, each of the grooves includes a V-shaped cross-section. In an embodiment, the insert is a molded plastic article. In an embodiment, the insert is a metal article formed by a second press, the insert including first and second bent portions. In an embodiment, the first and second bent portions of the insert are operatively arranged to matingly engage the first and second door light opening perimeters, respectively.

In an embodiment, the present invention broadly comprises a door fabricated according to the method including the following steps in the order named: a) forming a first door light opening perimeter and a second door light opening perimeter in the first and second door skins, respectively, wherein the first and second door light opening perimeters define a first portion and a second portion, respectively; b) positioning the first door skin on a first press; c) positioning an

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insert in aligned registration with the first door light opening perimeter of the first door skin; d) positioning the second door skin over the insert, wherein the second door light opening perimeter is in aligned registration with the insert and the first door light opening perimeter; e) applying pressure with the first press to secure the first and second door skins with the insert; f) injecting a foam into a first cavity formed between the first and second door skins and the insert; and, g) removing the first and second portions.

In an embodiment, the present invention broadly comprises a method for fabricating a door having a window, the door including a first door skin and a second door skin, the method including the following steps in the order named: a) forming a first door light opening perimeter having a first plurality of tabs arranged about the first door light opening perimeter, wherein the first door light opening perimeter defines a first door light portion; b) forming a second door light opening perimeter having a second plurality of tabs arranged about the second door light opening perimeter, wherein the second door light opening perimeter defines a second door light portion; c) positioning the first door skin on a first press; d) positioning an insert in aligned registration with the first plurality of tabs; e) positioning the second door skin over the insert, wherein the second plurality of tabs are in aligned registration with the insert, and the first door light opening perimeter is aligned with the second door light opening perimeter; f) applying pressure with the first press to secure the first and second door skins with the insert; g) injecting a foam into a first cavity formed between the first door skin outside the first door light portion, the second door skin outside the second door light portion and the insert; and, h) removing the first and second door light portions. In some embodiments, the present invention further includes the step of: i) inserting the window within a second cavity formed by the insert.

In some embodiments, the insert includes a pair of sealing flanges arranged to provide seals about the first and second door light opening perimeters, each of the pair of sealing flanges includes a substantially planar surface arranged for engagement with the first and second door skins. In other embodiments, the insert further includes a connection portion integral to and between the pair of sealing flanges, the connection portion engaged by the foam within the cavity during the injection step. In yet other embodiments, the connection portion is substantially V-shaped. In still yet other embodiments, the pair of sealing flanges and the connection portion are substantially W-shaped. In some embodiments, the insert is a molded plastic article, while in other embodiments, the insert is a metal article formed by a second press, the insert includes a pair of sealing flanges and a connection portion integral to and between the pair of sealing flanges. In some embodiments, the pair of sealing flanges are operatively arranged to provide seals about the first and second door light opening perimeters. The present invention broadly comprises a door fabricated according to the above method.

In an embodiment, the present invention broadly comprises a door including a first door skin having a first door light opening perimeter, the first door light opening perimeter includes a first plurality of tabs arranged about the first door light opening perimeter, a second door skin having a second door light opening perimeter, the second door light opening perimeter includes a second plurality of tabs arranged about the second door light opening perimeter, wherein the first and second door skins are oppositely disposed and arranged to form a first cavity therebetween. The first and second door light opening perimeters are in registered alignment. The present invention door further includes an insert having a pair

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of sealing flanges and a connection portion integral to and between the pair of sealing flanges, the sealing flanges arranged to provide seals about the first and second door light opening perimeters, each of the pair of sealing flanges includes a substantially planar surface arranged for engagement with the first and second door skins to close the first cavity between the first and second door skins to prevent an infill of a foam into a second cavity during fabrication of the door, wherein the second cavity is defined by the first and second door light opening perimeters and the insert. In some embodiments, the first door light opening perimeter further includes a first plurality of breakaway connectors arranged to permit the removal of a first door light portion of the first door skin within the first door light opening perimeter, and the second door light opening perimeter further includes a second plurality of breakaway connectors arranged to permit the removal of a second door light portion of the second door skin within the second door light opening perimeter.

It is a general object of the present invention to provide a door having a door light at a low cost which is easy to manufacture.

It is another general object of the present invention to minimize the labor and waste created by cutting out a door light from a door after door skins have been assembled and foam insulation has been injected into a cavity formed between the door skins, wherein the waste is a recyclable product.

It is yet another object of the present invention to minimize associated shipping costs for shipping a door from raw door manufacturers to finished door manufacturers by providing a door having a lower weight.

These and other objects and advantages of the present invention will be readily appreciable from the following description of preferred embodiments of the invention and from the accompanying drawings and claims.

BRIEF DESCRIPTION OF THE DRAWINGS

The nature and mode of operation of the present invention will now be more fully described in the following detailed description of the invention taken with the accompanying drawing figures, in which:

FIG. 1 is a perspective view of an embodiment of a present invention door light insert;

FIG. 2 is a perspective view of the door light insert of FIG. 1 shown during installation between first and second door skins;

FIG. 3 is a cross sectional view of the door light insert of FIG. 1;

FIG. 4 is a cross sectional view of a completed door including the door light insert of FIG. 1 after fabrication;

FIG. 5 is a perspective view of a completed door including the door light insert of FIG. 1;

FIG. 6 is a perspective view of an embodiment of a present invention door light insert;

FIG. 7 is a perspective view of the door light insert of FIG. 6 shown during installation between first and second door skins;

FIG. 8 is a cross sectional view of the door light insert of FIG. 6;

FIG. 9 is a cross sectional view of a completed door including the door light insert of FIG. 6 after fabrication;

FIG. 10 is a front plan view of a door skin including horizontal and vertical break away strips;

FIG. 11 is a perspective view of an embodiment of a present invention door light insert;

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FIG. 12 is a perspective view of the door light insert of FIG. 11 shown during installation between first and second door skins;

FIG. 13 is a cross sectional view of the door light insert of FIG. 11;

FIG. 14 is a cross sectional view of a completed door including the door light insert of FIG. 11 after fabrication;

FIG. 15 is a perspective view of an embodiment of a present invention including a door light insert shown during installation between first and second door skins;

FIG. 16 is a cross sectional view of the door light insert of FIG. 15;

FIG. 17 is a cross sectional view of a completed door including the door light insert of FIG. 15 after fabrication;

FIG. 18 is a perspective view of an embodiment of a present invention door light insert;

FIG. 19 is a perspective view of the door light insert of FIG. 18 shown during installation between first and second door skins;

FIG. 20 is a front plan view of a door assembled according to the arrangement of FIG. 19 prior to removing first and second door light portions;

FIG. 21 is a front plan view of a door assembled according to the arrangement of FIG. 19 after removing first and second door light portions;

FIG. 22 is a cross sectional view taken generally along line 22-22 of FIG. 20;

FIG. 23 is a cross sectional view taken generally along line 23-23 of FIG. 21; and,

FIG. 24 is a cross sectional view of a door assembled according to the arrangement of FIG. 19 after removing first and second door light portions and inserting a window into the assembled door.

DETAILED DESCRIPTION OF THE INVENTION

At the outset, it should be appreciated that like drawing numbers on different drawing views identify identical, or functionally similar, structural elements of the invention. While the present invention is described with respect to what is presently considered to be the preferred aspects, it is to be understood that the invention as claimed is not limited to the disclosed aspects.

Furthermore, it is understood that this invention is not limited to the particular methodology, materials and modifications described and as such may, of course, vary. It is also understood that the terminology used herein is for the purpose of describing particular aspects only, and is not intended to limit the scope of the present invention, which is limited only by the appended claims.

Unless defined otherwise, all technical and scientific terms used herein have the same meaning as commonly understood to one of ordinary skill in the art to which this invention belongs. It should be appreciated that the term "light" is synonymous with terms such as "window", "opening", "portal", "aperture", "orifice", "porthole", etc., and such terms may be used interchangeably as appearing in the specification and claims. Although any methods, devices or materials similar or equivalent to those described herein can be used in the practice or testing of the invention, the preferred methods, devices, and materials are now described.

Adverting now to the figures, FIG. 1 shows a perspective view of an embodiment of present invention door light insert 10, while FIG. 2 shows a perspective view of door light insert 10 during installation between first and second door skins 12 and 14, respectively. FIG. 3 shows a cross sectional view of door light insert 10, FIG. 4 shows a cross sectional view of

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completed door 16 including door light insert 10 after fabrication and FIG. 5 shows a perspective view of completed door 16 including door light insert 10. The following discussion is best understood in view of FIGS. 1 through 5.

Door light insert 10 is used for fabrication of door light 18 in door 16. Door 16 comprises a pair of interlocking and oppositely disposed door skins 12 and 14 which, when assembled, form cavity 20 therebetween. Door skins 12 and 14 further comprise door light openings 22 and 24, respectively. During assembly of door 16, door light opening 22 is registerably aligned with opposing door light opening 24. In the embodiments shown in FIGS. 1 through 5, insert 10 comprises engagement flanges 26 and 28 for engagement with door skins 12 and 14, respectively, within cavity 20. Insert 10 is engageable within door light openings 22 and 24, and closes cavity 20, i.e., the volume formed between door skins 12 and 14, and prevents infill of foam 30 into door light openings 22 and 24, and hence door light 18, during fabrication.

In some embodiments, insert 10 further comprises secondary flanges 32 and 34 positioned substantially parallel to and between engagement flanges 26 and 28. Secondary flanges 32 and 34 are substantially encapsulated in foam 30 within cavity 20 during fabrication of door 16. In some of these embodiments, secondary flanges 32 and 34 are equal in length but shorter in length than either of engagement flanges 26 or 28. In other words, secondary flanges 32 and 34 have first lengths 36, while engagement flanges 26 and 28 have second lengths 38, and first lengths 36 are less than second lengths 38. In yet other embodiments, engagement flanges 26 and 28 each comprise offset engagement surfaces 40 and 42, respectively, so that outer interfaces 44 and 46 between first and second door skins 12 and 14, respectively, and insert 10 are substantially flush. Outer interfaces 44 and 46 are created by the combination of outer surfaces 48 and 50 of door skins 12 and 14, respectively, and steps 52 and 54 of insert 10, respectively. In the embodiments shown in FIGS. 1 through 5, insert 10 is a molded plastic article. However, as one of ordinary skill in the art will recognize, other materials may also be used, e.g., wood, metal, ceramic or polymers, and such variations are within the spirit and scope of the claimed invention. A second embodiment of a present invention door light insert is discussed in detail infra, wherein the insert is constructed from metal.

FIG. 6 shows a perspective view of an embodiment of the present invention, i.e., door light insert 56, while FIG. 7 shows a perspective view of door light insert 56 during installation between first and second door skins 58 and 60, respectively. FIG. 8 shows a cross sectional view of door light insert 56, while FIG. 9 shows a cross sectional view of completed door 62 including door light insert 56 after fabrication. The following discussion is best understood in view of FIGS. 6 through 9.

In the embodiments shown in FIGS. 6 through 9, door skins 58 and 60 comprise beads 64 and 66, respectively, arranged proximate door light openings 68 and 70, respectively. Although beads 64 and 66 are primarily used for the alignment and securing of insert 56, beads 64 and 66 also provide the added benefit of increasing the rigidity of first and second door skins 58 and 60, respectively. This increased rigidity allows for easier handling of door skins during the assembly process. Although the embodiments shown in FIGS. 6 through 9 comprise stamped metal door skins, one of ordinary skill in the art will recognize that other materials of construction for the door skins are also possible, e.g., molded fiberglass, molded polymer or wood, and such variations are within the spirit and scope of the claimed invention. Additionally, in these embodiments, insert 56 is a metal article

formed by a press (not shown), for example, a roll press. Insert **56** comprises first and second bent portions **72** and **74**, respectively, operatively arranged to matingly engage beads **64** and **66**, respectively. After insert **56** exits the press, the areas where corners are required are cut or notched so that insert **56** may be bent to form the desired shape. For example, corners **76a**, **76b**, **76c** and **76d** are cut and subsequently bent to form approximately ninety degree angles. First and second ends **78** and **80**, respectively, are joined by means generally known in the art, e.g., welding, overlapping, dovetailing or bonding. In the embodiment shown in FIG. **6**, first and second ends **78** and **80**, respectively, are joined with weld **82**. Although in the embodiments shown in FIGS. **6** through **9**, bent portions **72** and **74** are arranged to matingly engage beads **64** and **66**, respectively, one of ordinary skill in the art will recognize that other means of interfacing insert **56** and door skins **58** and **60** are also possible, e.g., as described supra relative to insert **10**, and such variations are within the spirit and scope of the claimed invention. Similarly, although beads **64** and **66** and bent portions **72** and **74** are shown as generally curved shapes, other shapes are also possible, e.g., V-shaped or square shaped, and these variations are also within the spirit and scope of the claimed invention.

In some embodiments, bonding agents **84** and **86** are deposited on bent portions **72** and **74**, respectively, as insert **56** exits the press, or are subsequently deposited as secondary operations after forming insert **56**. Bonding agents **84** and **86** may for example be an adhesive, a pressure sensitive adhesive, a glue, an epoxy or a weld. Thus, during assembly, bent portion **72** having bonding agent **84** deposited thereon is pressed against bead **64** of first door skin **58** thereby securing insert **56** to first door skin **58**. Subsequently, bead **66** of second door skin **60** is pressed against bent portion **74**, having bonding agent **86** deposited thereon, thereby securing second door skin **60** to insert **56**. One of ordinary skill in the art recognizes that bonding agents **84** and **86** serve a variety of purposes which include but are not limited to: providing bonding strength to hold door skins **58** and **60** and insert **56** together during assembly and thereafter; and, providing a thermal break within the assembly to reduce heat transfer between door skins **58** and **60** and insert **56**. Subsequent to assembling door skins **58** and **60** and insert **56**, cavity **88**, i.e., the volume formed between first and second door skins **58** and **60**, respectively, and wall **90** of insert **56**, is filled with foam **92**. As can be seen in the figures, in these embodiments, wall **90** prevents any inflow of foam **92** within cavity **94**, i.e., the opening for a window.

One of ordinary skill in the art recognizes that although not described above, engagement flanges **26** and **28** of insert **10** may also have a bonding agent deposited thereon for purposes of assembly, and such variations are within the spirit and scope of the claimed invention. Additionally, one of ordinary skill in the art will recognize that all embodiments described herein may also be practiced without the presence of bonding agents, and such variations are also within the spirit and scope of the claimed invention.

FIG. **10** shows a front plan view of door skin **96** including horizontal and vertical break away strips **98** and **100**, respectively. Due to the thickness of the door skins, bending and distortion may occur during the assembly process thereby decreasing the aesthetic quality of the assembled door. Therefore, in some embodiments, door skin **96** includes horizontal and vertical break away strips **98** and **100**, respectively, operatively arranged within door light opening **102**. Although in the embodiment shown in FIG. **10** door skin **96** includes two horizontal break away strips **98** and one vertical break away strip **100**, one of ordinary skill in the art will recognize that

other arrangements are also possible, e.g., one horizontal break away strip, one vertical break away strip, one diagonal break away strip, a plurality of horizontal break away strips, a plurality of vertical break away strips, a plurality of diagonal break away strips or combinations thereof, and such variations are within the spirit and scope of the invention as claimed. Subsequent to door assembly, the break away strips may be removed by bending weakened portions **103** until the break away strips separate from the door skin, or alternatively, the break away strips may be left in to provide further structural support during shipping of an assembled door to a manufacturer of finished doors, and in those instances, the break away strips are removed after shipping but prior to the final installation of a window.

The following discussion is best understood in view of FIGS. **1** through **9**, and in particular FIGS. **2** and **7**. The present invention also broadly comprises a method for fabricating doors, for example doors **16** and **62** having door light insert **10** and **56**, respectively. As described supra, door **16** comprises first and second door skins **12** and **14**, respectively, having first and second door light openings **22** and **24**, respectively, while door **62** comprises first and second door skins **58** and **60**, respectively, having first and second door light openings **68** and **70**, respectively. A first door skin, e.g., first door skin **12** or **58**, is positioned on a press (not shown). Then, an insert, e.g., insert **10** or **56**, is positioned in aligned registration with a first door light opening of the first door skin, e.g., first door light opening **22** or **68**. Next, a second door skin, e.g., second door skin **14** or **60**, is positioned over the insert, wherein a second door light opening, e.g., second door light opening **24** or **70**, is in aligned registration with the insert and the first door skin. Then, pressure is applied in the direction of arrows **104** with the press to secure the first and second door skins with the insert. Subsequently, a foam, e.g., foam **30** or **92**, is injected into a cavity formed between the first and second door skins and the insert, e.g., cavity **20** or **88**.

Depending on the needs and/or requirements of the purchaser of a door assembled by the method described supra, in some embodiments, the method further comprises inserting a window (not shown) within a second cavity formed by the insert, e.g., cavity **18** or **94**.

FIG. **11** shows a perspective view of an embodiment of the present invention, i.e., door light insert **200**, while FIG. **12** shows a perspective view of door light insert **200** during installation between first and second door skins **202** and **204**, respectively. FIG. **13** shows a cross sectional view of door light insert **200**, and FIG. **14** shows a cross sectional view of completed door **206** including door light insert **200** after fabrication. FIG. **15** shows a perspective view of an embodiment of a present invention including door light insert **208** shown during installation between first and second door skins **210** and **212**, respectively. FIG. **16** shows a cross sectional view of door light insert **208**, while FIG. **17** shows a cross sectional view of completed door **214** including door light insert **208** after fabrication. The following discussion is best understood in view of FIGS. **11** through **17**.

It has been found that a door may be manufactured using a modified present invention insert, e.g., inserts **200** or **208**, and a modified method of assembly as described herebelow. The modified method for fabricating a door having a window, begins with first and second door skins which do not include door light openings, e.g., first and second door skins **202** and **204**, respectively, or first and second door skins **210** and **212**, respectively. The method comprises the following steps in the order set forth herein. First, a door light opening perimeter is formed in each door skin, wherein each door light perimeter defines a portion. For example, first door skin **202** includes

first door light opening perimeter **216** formed therein, and defining first portion **218**; first door skin **210** includes first door light opening perimeter **220** formed therein, and defining first portion **222**; second door skin **204** includes second door light opening perimeter **224** formed therein, and defining second portion **226**; and, second door skin **212** includes second door light opening perimeter **228** formed therein, and defining second portion **230**. Second, the first door skin, e.g., first door skin **202** or **210**, is positioned on a first press, e.g., first press **231**. Third, an insert, e.g., door light insert **200** or **208**, is positioned in aligned registration with the first door light opening perimeter, e.g., first door light opening perimeter **216** or **220**. Fourth, the second door skin, e.g., second door skin **204** or **212**, is positioned over the insert, e.g., door light insert **200** or **208**, wherein the second door light opening perimeter, e.g., second door light opening perimeter **224** or **228**, is in aligned registration with the insert and the first door light opening perimeter. Fifth, the first press applies pressure, as shown by unidirectional arrows **232**, to secure the first and second door skins with the insert. Sixth, a foam, e.g., foam **233** or **234**, is injected into a first cavity formed between the first and second door skins and the insert, e.g., first cavity **236** or **238**. Seventh, the first portion, e.g., first portion **218** or **222**, and the second portion, e.g., second portion **226** or **230**, are removed. In an embodiment, the method further comprises the eighth step of inserting a window, e.g., window **240**, within a second cavity, e.g., second cavity **241** or **242**, formed by the insert.

In the above described embodiment, the insert, e.g., insert **200**, comprises pair of engagement flanges **243a** and **243b** for aligned registration and engagement with first and second door skins, e.g., door skins **202** and **204**, each of engagement flanges **243a** and **243b** comprises a groove, e.g., groove **244a** and **244b**, respectively, arranged for receipt of one of first or second door light opening perimeters **216** and **224** therein. In an embodiment, the insert, e.g., insert **200**, further comprises secondary pair of flanges **246a** and **246b** positioned substantially parallel and between pair of engagement flanges **243a** and **243b**. It should be appreciated that secondary pair of flanges **246a** and **246b** are encapsulated by foam, e.g., foam **233**, within the cavity, e.g., cavity **236** formed between the first and second door skins and the insert, during the above described injection step. In an embodiment, secondary flanges **246a** and **246b** are equal in length but shorter in length than either of engagement flanges **243a** and **243b**. In other words, secondary flanges **246a** and **246b** comprise length **248**, while engagement flanges **243a** and **243b** comprise length **250**, and length **248** is less than length **250**. It should be appreciated that other combinations of lengths and arrangements are also possible, e.g., the secondary flanges may be longer than the engagement flanges or the secondary flanges may be unequal in length relative to each other, and such variations are within the spirit and scope of the claimed invention.

In an embodiment, the grooves, e.g., grooves **244a** and **244b**, comprise a V-shaped cross-section, e.g., V-shaped sections **252a** and **252b**, respectively. Furthermore, in an embodiment, the insert, e.g., insert **200**, is a molded plastic article. Moreover, in an embodiment, the insert, e.g., insert **208**, is a metal article formed by a second press (not shown), e.g., a roll press, the insert comprises first and second bent portions, e.g., bent portions **254a** and **254b**, respectively. It should be appreciated that insert **208** is formed according to the method described above relative to insert **56**. In an embodiment, the first and second bent portions are operatively arranged to matingly engage first and second door light opening perimeters, respectively, e.g., door light opening

perimeters **220** and **228**. Additionally, in an embodiment, the present invention broadly comprises a door, e.g., door **206** or **214**, fabricated according to the method described supra.

In an embodiment, bonding agents **256a** and **256b** are deposited on bent portions **254a** and **254b**, respectively, as insert **208** exits the press, or are subsequently deposited as secondary operations after forming insert **208**. Bonding agents **256a** and **256b** may for example be an adhesive, a pressure sensitive adhesive, a glue, an epoxy or a weld. Thus, during assembly, bent portion **254a** having bonding agent **256a** deposited thereon is pressed against first door light opening perimeter **220** of first door skin **210** thereby securing insert **208** to first door skin **210**. Subsequently, second door light opening perimeter **228** of second door skin **212** is pressed against bent portion **254b**, having bonding agent **256b** deposited thereon, thereby securing second door skin **212** to insert **208**. One of ordinary skill in the art recognizes that bonding agents **256a** and **256b** serve a variety of purposes which include but are not limited to: providing bonding strength to hold door skins **210** and **212** and insert **208** together during assembly and thereafter; and, providing a thermal break within the assembly to reduce heat transfer between door skins **210** and **212** and insert **208**. Subsequent to assembling door skins **210** and **212** and insert **208**, first cavity **238**, i.e., the volume formed between first and second door skins **210** and **212**, respectively, and wall **258** of insert **208**, is filled with foam **234**. As can be seen in the figures, wall **258** prevents any inflow of foam **234** within second cavity **242**, i.e., the opening for a window.

One of ordinary skill in the art recognizes that although not described above, engagement flanges **243a** and **243b** of insert **200** may also have a bonding agent deposited thereon for purposes of assembly, and such variations are within the spirit and scope of the claimed invention. Additionally, one of ordinary skill in the art will recognize that all embodiments described herein may also be practiced without the presence of bonding agents, and such variations are also within the spirit and scope of the claimed invention.

FIG. **18** shows a perspective view of an embodiment of a present invention door light insert, i.e., insert **300**, while FIG. **19** shows a perspective view of door light insert **300** shown during installation between first and second door skins **302** and **304**, respectively. FIG. **20** shows a front plan view of a door assembled according to the arrangement of FIG. **19**, i.e., door **306**, prior to removing first and second door light portions **308** and **310**, respectively, while FIG. **21** shows a front plan view of door **306** after removing first and second door light portions **308** and **310**, respectively. FIG. **22** shows a cross sectional view taken generally along line **22-22** of FIG. **20** and FIG. **23** shows a cross sectional view taken generally along line **23-23** of FIG. **21**. FIG. **24** shows a cross sectional view of door **306** after removing first and second door light portions **308** and **310**, respectively, and inserting window **311** is inserted into door **306**. The following discussion is best understood in view of FIGS. **18** through **24**.

It has also been found that a door, e.g., door **306**, may be manufactured using a further modified present invention insert, e.g., insert **300**, and a further modified method of assembly, as described herebelow. The further modified method for fabricating a door having a window, begins with first door skin **302** and second door skin **304**. Again, this embodiment of the method begins with first door skin **302** including first door light portion **308** and second door skin **304** including second door light portion **310** and first and second door light portions **308** and **310**, respectively, have not been removed. The method comprises the following steps in the order set forth herein. First, a first door light opening

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perimeter is formed, e.g., first door light opening perimeter **312**. The first door light opening perimeter comprises a first plurality of tabs, e.g., tabs **314**, arranged about the first door light opening perimeter, wherein the first door light opening perimeter defines a first door light portion, e.g., first door light portion **308**. Next, a second door light opening perimeter is formed, e.g., second door light opening perimeter **316**. The second door light opening perimeter comprises a second plurality of tabs, e.g., tabs **318**, arranged about the second door light opening perimeter, wherein the second door light opening perimeter defines a second door light portion, e.g., second door light portion **310**. Then, the first door skin, e.g., first door skin **302**, is positioned on a first press, e.g., first press **320**. Next, an insert, e.g., insert **300**, is positioned in aligned registration with the first plurality of tabs, e.g., tabs **314**. It should be appreciated that by positioning insert **300** in aligned registration with the first plurality of tabs, insert **300** is also positioned in aligned registration with the first door light opening perimeter, e.g., first door light opening perimeter **312**. Next, the second door skin, e.g., second door skin **304**, is positioned over the insert, e.g., insert **300**, wherein the second plurality of tabs, e.g., tabs **318**, are in aligned registration with the insert, and thus the first and second door light opening perimeters are aligned. Additionally, it should be appreciated that by positioning the second plurality of tabs in aligned registration with insert **300**, insert **300** is also positioned in aligned registration with the second door light opening perimeter, e.g., second door light opening perimeter **316**. Then, the first press applies pressure, as shown by unidirectional arrows **322**, to secure the first and second door skins with the insert. Next, a foam, e.g., foam **324**, is injected into a first cavity formed between the first door skin outside the first door light portion, the second door skin outside the second door light portion and the insert, e.g., first cavity **326**. Lastly, the first and second door light portions, e.g., first and second door light portions **308** and **310**, respectively, are removed. In an embodiment, the modified method further comprises the additional step of inserting a window, e.g., window **311**, within a second cavity, e.g., second cavity **330**, formed by the insert.

In the above described method, the insert, e.g., insert **300**, comprises a pair of sealing flanges, e.g., sealing flanges **332a** and **332b**, arranged to provide seals about first and second door light opening perimeters **312** and **316**, respectively. Each of sealing flanges **332a** and **332b** comprises a substantially planar surface, e.g., planar surfaces **334a** and **334b**, arranged for engagement with first and second door skins **302** and **304**. Insert **300** further comprises connection portion **336**. Connection portion **336** is integral to and between sealing flanges **332a** and **332b**. Connection portion **336** is engaged by foam **324** within first cavity **326** during the injection step. In the embodiment shown in the figures, connection portion **336** is substantially V-shaped. Thus, pair of sealing flanges **332a** and **332b** in combination with connection portion **336** is substantially W-shaped. One of ordinary skill in the art will recognize that although sealing flanges **332a** and **332b** are shown to be substantially planar surfaces, other configurations are also possible, e.g., curved surfaces or V-shaped grooves, and such variations are within the spirit and scope of the claimed inventions. It should be appreciated that with such variations complimentary mating features will also be present proximate the door light opening perimeters, e.g., curved surfaces or V-shaped grooves.

It should be appreciated that insert **300** may be constructed from a variety of materials. For example, insert **300** may be a molded plastic article, or insert **300** may be a metal article formed by a press, e.g., a roller press. As described above,

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such inserts comprise a pair of sealing flanges, e.g., sealing flanges **332a** and **332b**, and a connection portion, e.g., connection portion **336**, integral to and between the pair of sealing flanges. Similarly, the sealing flanges are operatively arranged to provide seals about the first and second door light opening perimeters, e.g., first and second door light opening perimeters **312** and **316**, respectively.

It should also be appreciated that the present invention broadly comprises a door, e.g., door **306**, fabricated according to the method described supra.

In view of the foregoing, a present invention door, i.e., door **306**, comprises a first door skin, e.g., first door skin **302**. The first door skin comprises a first door light opening perimeter, e.g., first door light opening perimeter **312**. The first door light opening perimeter comprises a first plurality of tabs arranged about the first door light opening perimeter, e.g., first plurality of tabs **314**. Additionally, the present invention door comprises a second door skin, e.g., second door skin **304**. The second door skin comprises a second door light opening perimeter, e.g., second door light opening perimeter **316**. The second door light opening perimeter comprises a second plurality of tabs arranged about the second door light opening perimeter, e.g., second plurality of tabs **318**. Thus, the present invention door comprises oppositely disposed first and second door skins which are arranged to form a first cavity therebetween, e.g., first cavity **326**. It should be appreciated that the above described arrangement results in the first and second door light opening perimeters being in registered alignment. The present invention door further comprises an insert, e.g., insert **300**. The insert comprises a pair of sealing flanges, e.g., sealing flanges **332a** and **332b**, and a connection portion integral to and between the pair of sealing flanges, e.g., connection portion **336**. The sealing flanges are arranged to provide seals about the first and second door light opening perimeters. Each of the pair of sealing flanges comprises a substantially planar surface, e.g., planar surfaces **334a** and **334b**, arranged for engagement with the first and second door skins to close the first cavity between the first and second door skins to prevent an infill of a foam, e.g., foam **324**, into a second cavity, e.g., second cavity **330**, during fabrication of the present invention door. The second cavity is defined by the first and second door light opening perimeters and said insert.

In the embodiment shown in the figures, the first door light opening perimeter further comprises a first plurality of breakaway connectors, e.g., first plurality of breakaway connectors **338**, arranged to permit the removal of a first area of said first door skin within said first door light opening perimeter, e.g., first door light portion **308**. Similarly, the second door light opening perimeter further comprises a second plurality of breakaway connectors, e.g., second plurality of breakaway connectors **340**, arranged to permit the removal of a second area of said second door skin within said second door light opening perimeter, e.g., second door light portion **310**. It should be appreciated that the side or sides of each tab **314** proximate first door light opening perimeter **312** is cut during the tab forming step, and then bent towards the cavity formed between the door skins. Contrarily, the portion of material which makes up each breakaway connector **338** remains connected to first door light opening perimeter **312**. Thus, subsequent to tab formation, first door light portion **308** is held to first door skin **302** by only breakaway connectors **338**. Similarly, the side or sides of each tab **318** proximate second door light opening perimeter **316** is cut during the tab forming step, and then bent towards the cavity formed between the door skins. Contrarily, the portion of material which makes up each breakaway connector **340** remains connected to second door light opening perimeter **316**. Thus, subsequent to tab forma-

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tion, second door light portion **310** is held to second door skin **304** by only breakaway connectors **340**.

Quite unexpectedly, it has been found that doors constructed according to the present invention method, i.e., doors which include the present invention door light insert, attain improved strength and rigidity, e.g., during hurricane strength testing. Additionally, as there is no foam within the inner cavity created by the first and second door skins and the insert, as the first and second door light portions are removed, such portions may be recycled and used for the manufacture of more door skins. Contrarily, as described supra, if foam were allowed to enter the inner cavity, the removal of the first and second door light portions would produce a hazardous waste which must be disposed of according to the local laws where the door is manufactured. In other words, merely having the first and second door light portions bound together by foam therebetween converts the first and second door light portions to hazardous waste.

One of ordinary skill in the art will recognize several additional aspects of the present invention, which aspects are within the spirit and scope of the claimed invention. For example, the door skins may also include decorative portions, e.g., embossments, and these portions may be formed during the same stamping operation as the door light openings are formed, or as a prior or subsequent operation. Additionally, the door skins may have decorative portions secured thereto, e.g., raised decorative embellishments. It should also be appreciated that a present invention insert may be sold individually, in combination with door skins or as a part of a completed door having a door light opening and/or a window installed therein. In like fashion, it should be appreciated that, although the present invention inserts described supra have rectangular or square shaped openings, other shapes are also possible, e.g., circular, hemispherical, triangular, polygon or octagon, and such variations are within the spirit and scope of the claimed invention. Additionally, although in the embodiments shown in the figures and described above include grooves and bent portions having V-shaped or arcuate cross sections, other shapes are also possible, e.g., square, rectangular, polygon, etc., and such variations are within the spirit and scope of the claimed invention.

Thus, it is seen that the objects of the present invention are efficiently obtained, although modifications and changes to the invention should be readily apparent to those having ordinary skill in the art, which modifications are intended to be within the spirit and scope of the invention as claimed. It also is understood that the foregoing description is illustrative of the present invention and should not be considered as limiting. Therefore, other embodiments of the present invention are possible without departing from the spirit and scope of the present invention.

What I claim is:

1. A method for fabricating a door having a window, said door comprising a first door skin and a second door skin, said method comprising the following steps in the order named:

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- a) forming a first door light opening perimeter comprising a first plurality of tabs arranged about said first door light opening perimeter, wherein said first door light opening perimeter defines a first door light portion;
- b) forming a second door light opening perimeter comprising a second plurality of tabs arranged about said second door light opening perimeter, wherein said second door light opening perimeter defines a second door light portion;
- c) positioning said first door skin on a first press;
- d) positioning an insert in aligned registration with said first plurality of tabs;
- e) positioning said second door skin over said insert, wherein said second plurality of tabs are in aligned registration with said insert, and said first door light opening perimeter is aligned with said second door light opening perimeter;
- f) applying pressure with said first press to secure said first and second door skins with said insert;
- g) injecting a foam into a first cavity formed between said first door skin outside said first door light portion, said second door skin outside said second door light portion and said insert; and,
- h) removing said first and second door light portions.

2. The method of claim **1** further comprising the step of:
i) inserting said window within a second cavity formed by said insert.

3. The method of claim **1**, wherein said insert comprises a pair of sealing flanges arranged to provide seals about said first and second door light opening perimeters, each of said pair of sealing flanges comprises a substantially planar surface arranged for engagement with said first and second door skins.

4. The method of claim **3**, wherein said insert further comprises a connection portion integral to and between said pair of sealing flanges, said connection portion engaged by said foam within said cavity during said injection step.

5. The method of claim **4**, wherein said connection portion is substantially V-shaped.

6. The method of claim **5**, wherein said pair of sealing flanges and said connection portion are substantially W-shaped.

7. The method of claim **1**, wherein said insert is a molded plastic article.

8. The method of claim **1**, wherein said insert is a metal article formed by a second press, said insert comprising a pair of sealing flanges and a connection portion integral to and between said pair of sealing flanges.

9. The method of claim **8**, wherein said pair of sealing flanges are operatively arranged to provide seals about said first and second door light opening perimeters.

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