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**Manderfeld**

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(54) **ROLL FORMED PONTOON AND METHOD OF MANUFACTURE**

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(\*) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 0 days.

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(21) Appl. No.: **12/165,926**

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(57) **ABSTRACT**

(51) **Int. Cl.**  
**B63B 1/00** (2006.01)

A method for making a pontoon for a pontoon boat and the pontoon made from the method. The method having an initial step of providing a sheet metal strip that has a width and a length. The strip is then formed longitudinally through successive rollers to provide a central portion having a closed cross section in which the lateral edges of the strip meet. After this stage of the process, end caps are formed at each end of the central portion. Typically, one of the end caps is a nose cone that is pointed and cuts the water as the boat moves forward. The end caps may be formed independently and separately of the strip or may be formed from material at the end of the formed strip.

(52) **U.S. Cl.** ..... **114/292**; 114/356  
(58) **Field of Classification Search** ..... 114/61.1, 114/61.2, 292, 356, 352, 357; 72/51; 228/147, 228/158

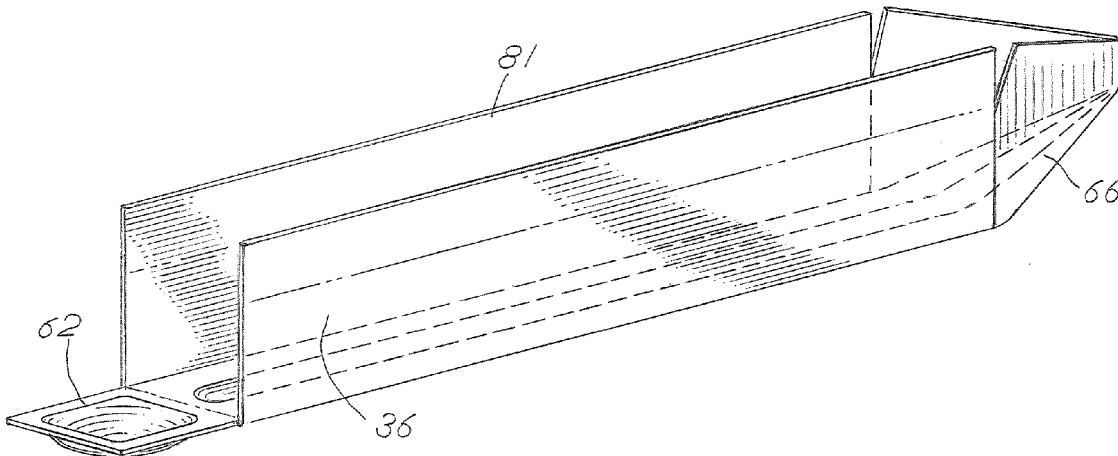
See application file for complete search history.

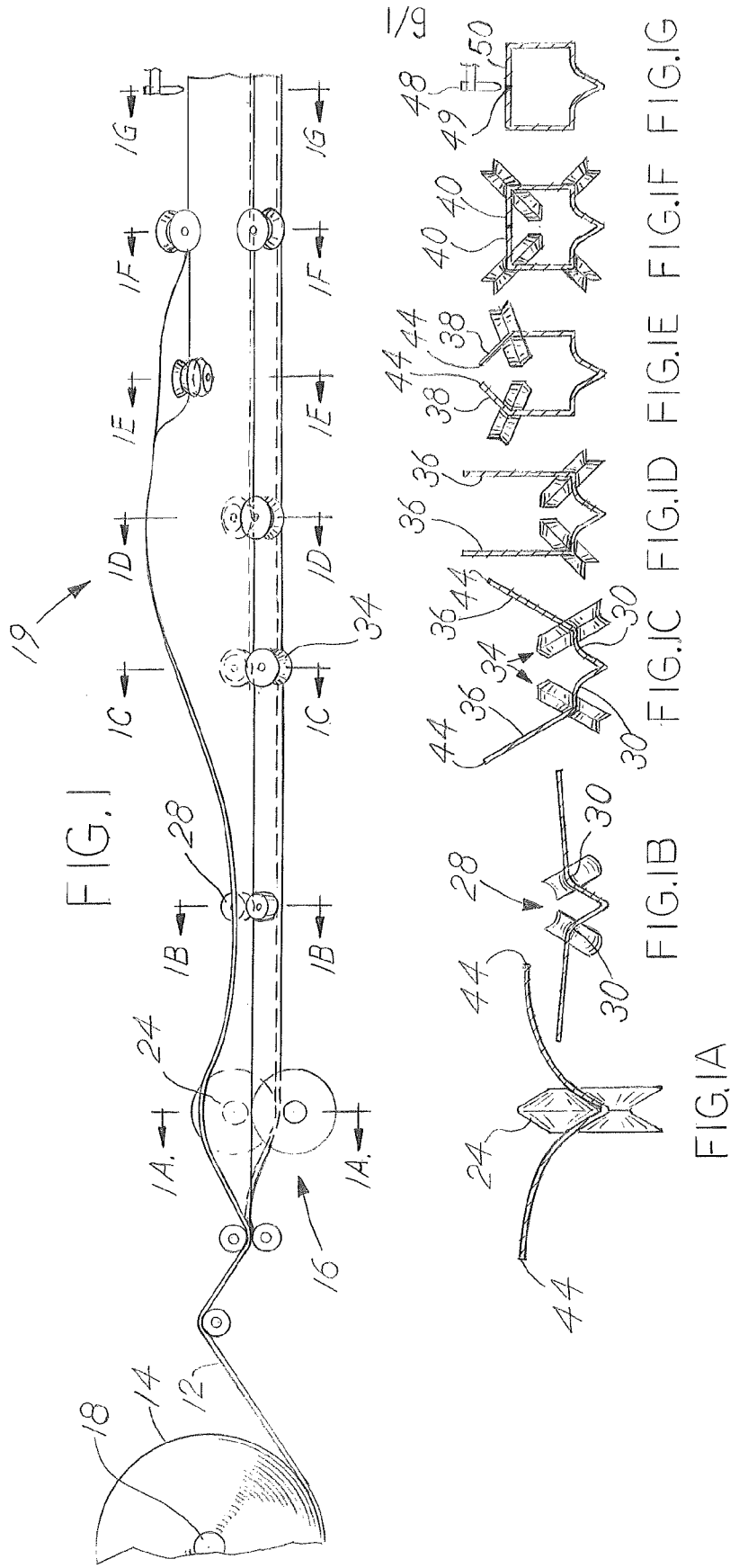
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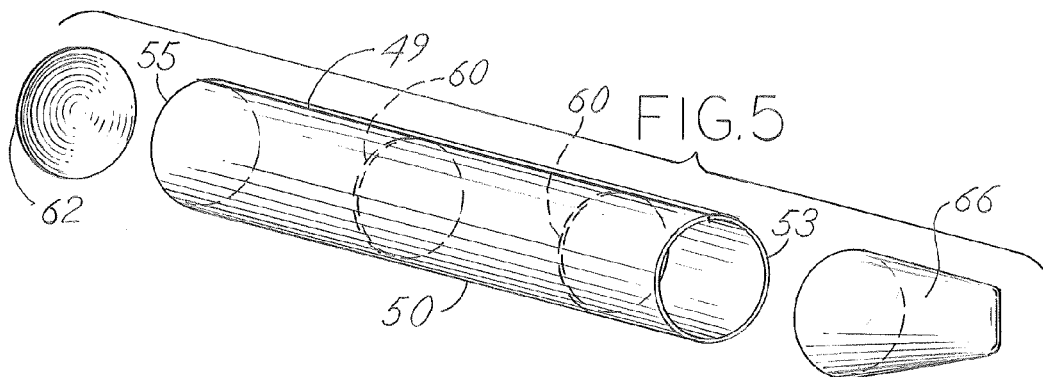
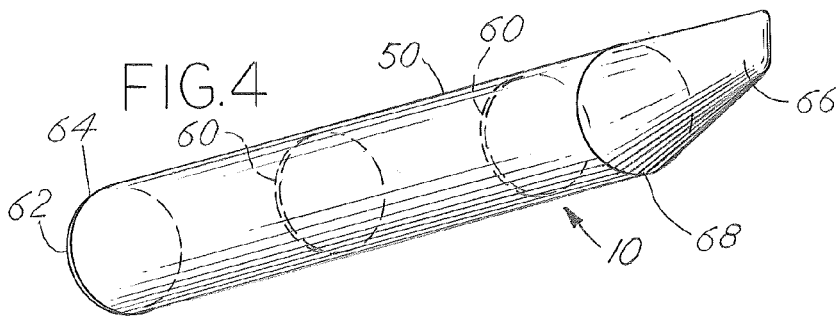
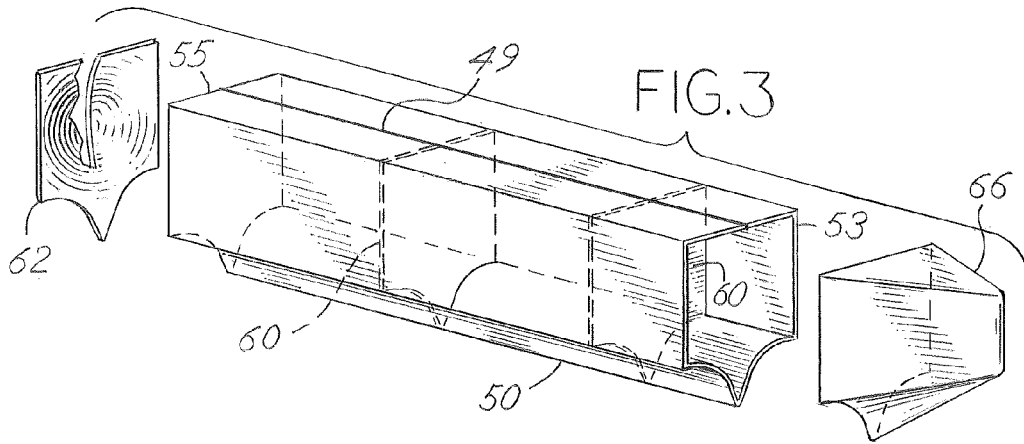
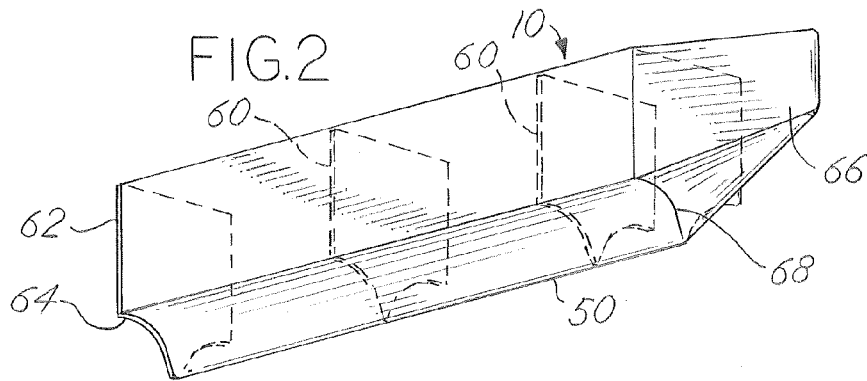
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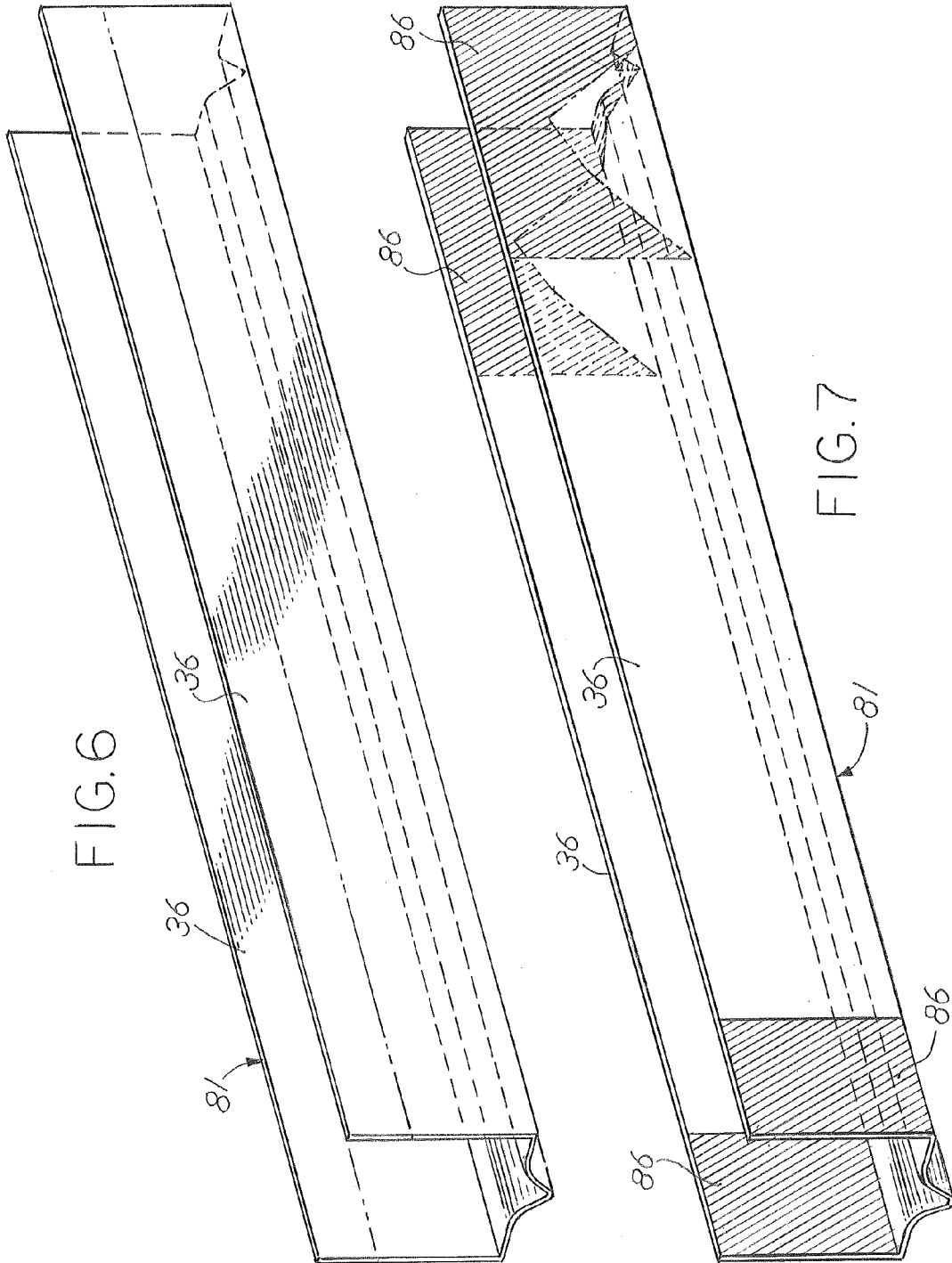
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**19 Claims, 9 Drawing Sheets**









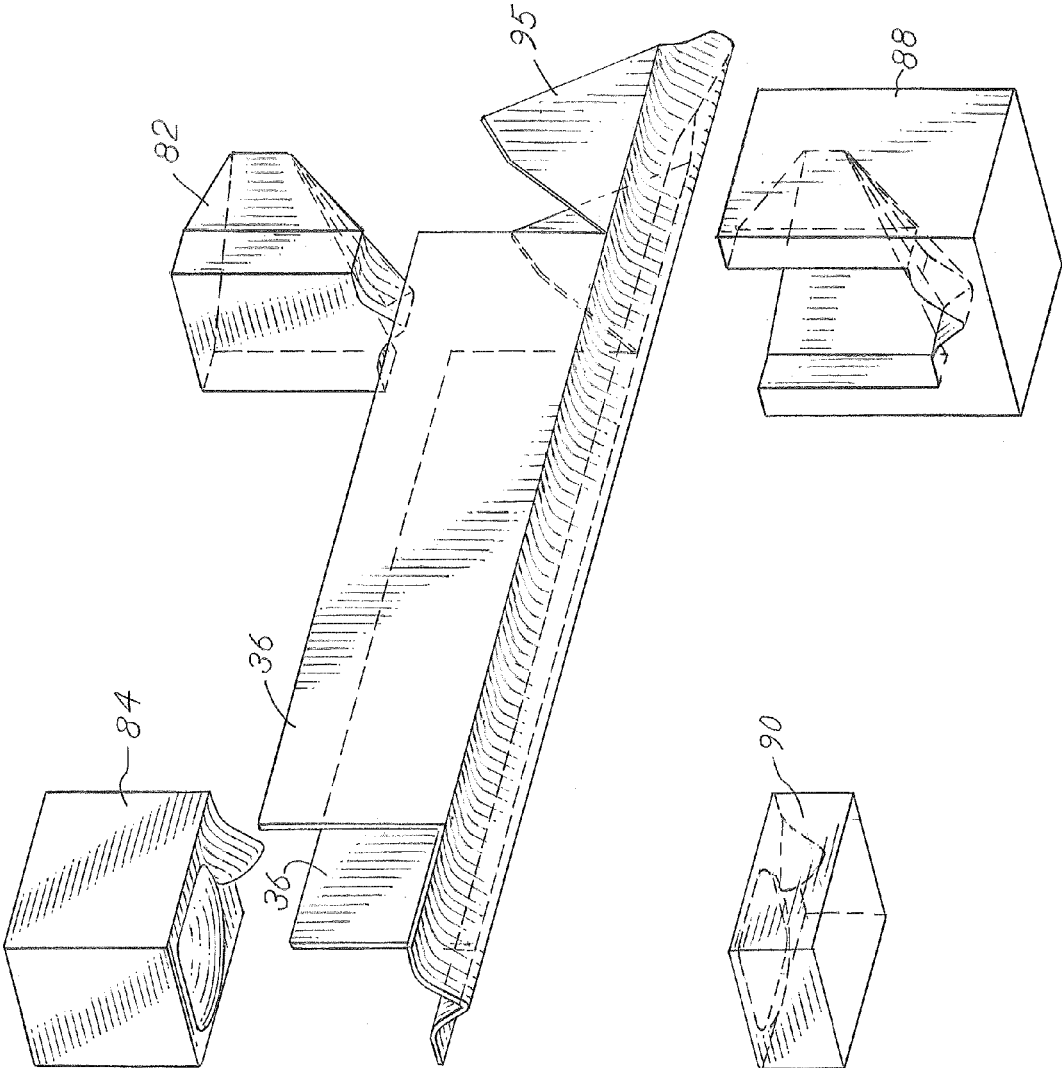
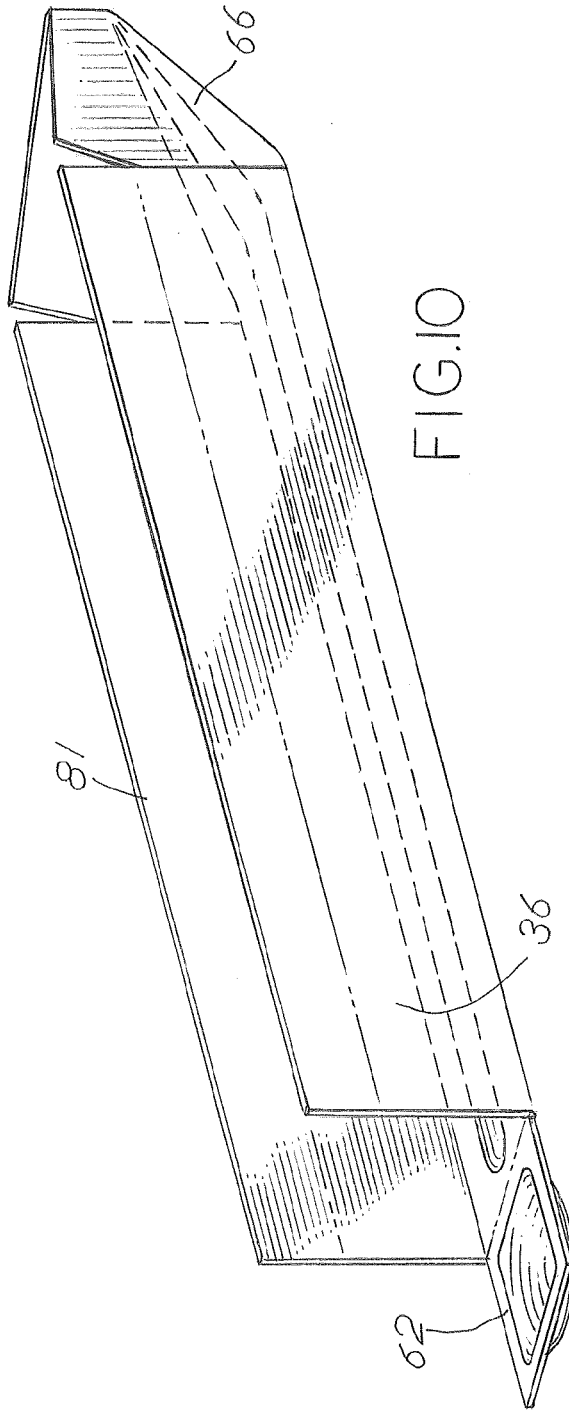
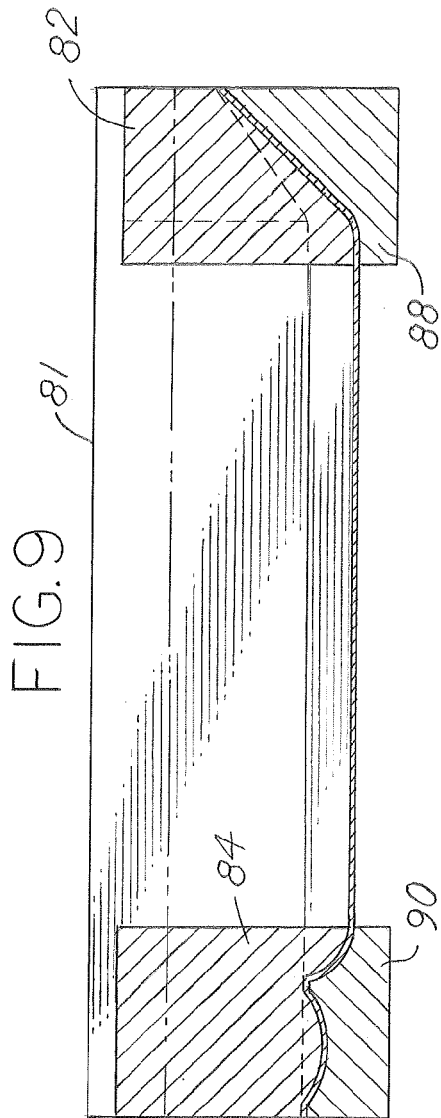


FIG. 8



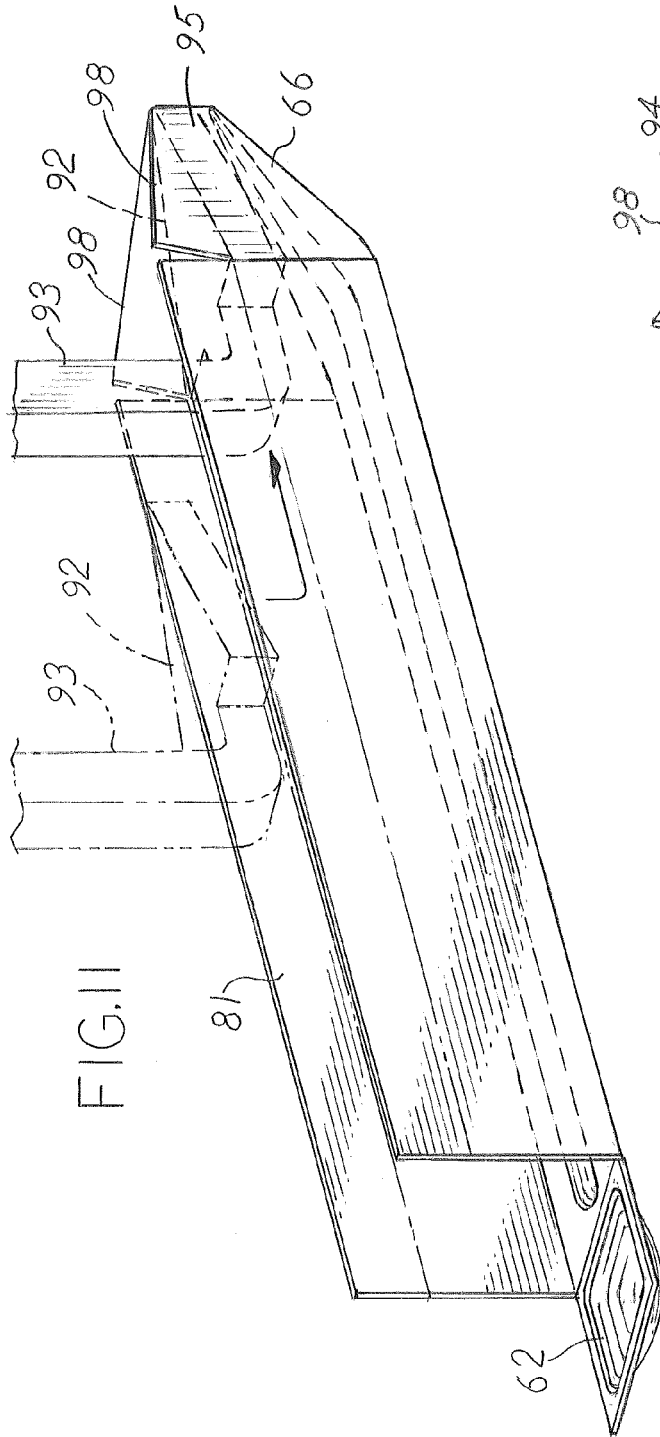


FIG. 11

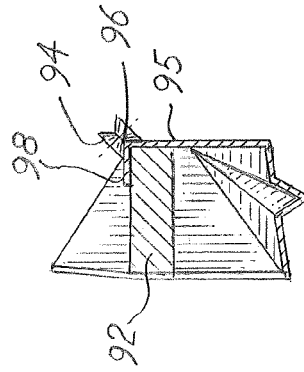


FIG. 13

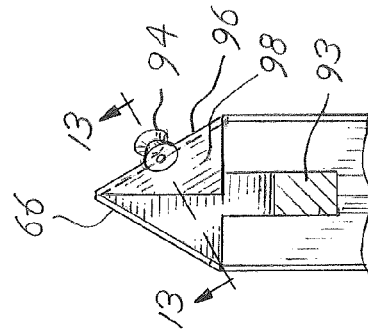
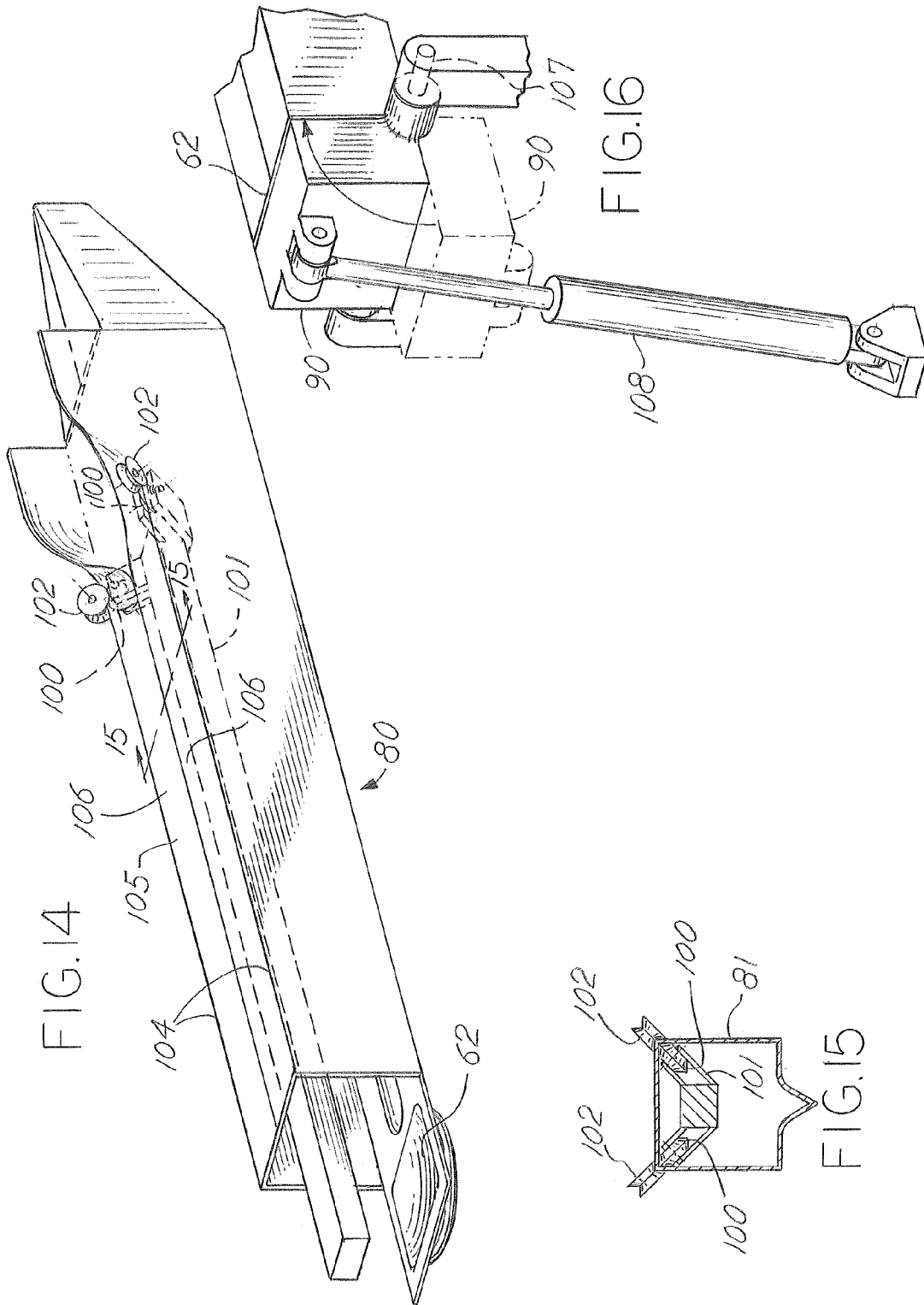


FIG. 12





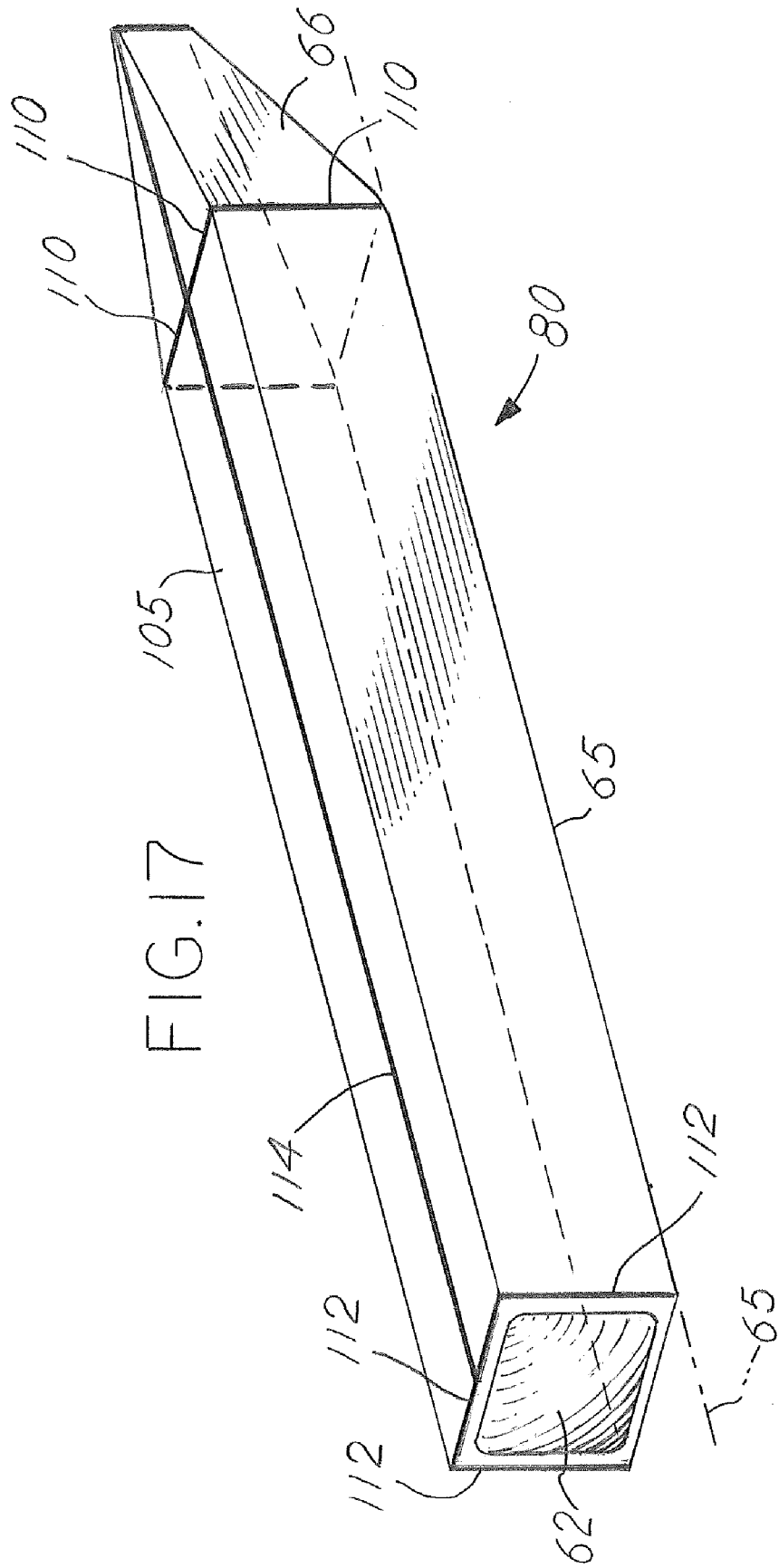
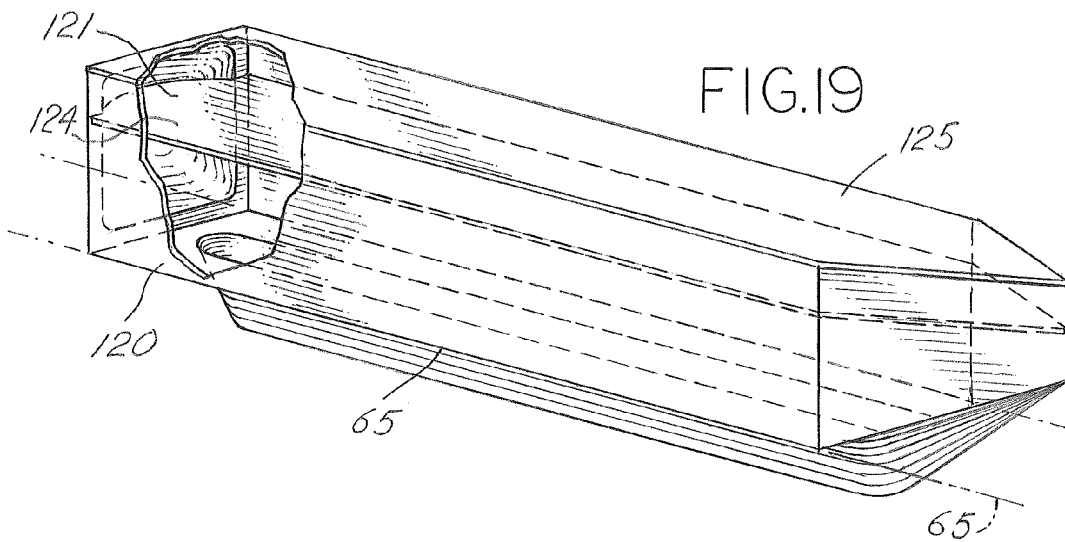
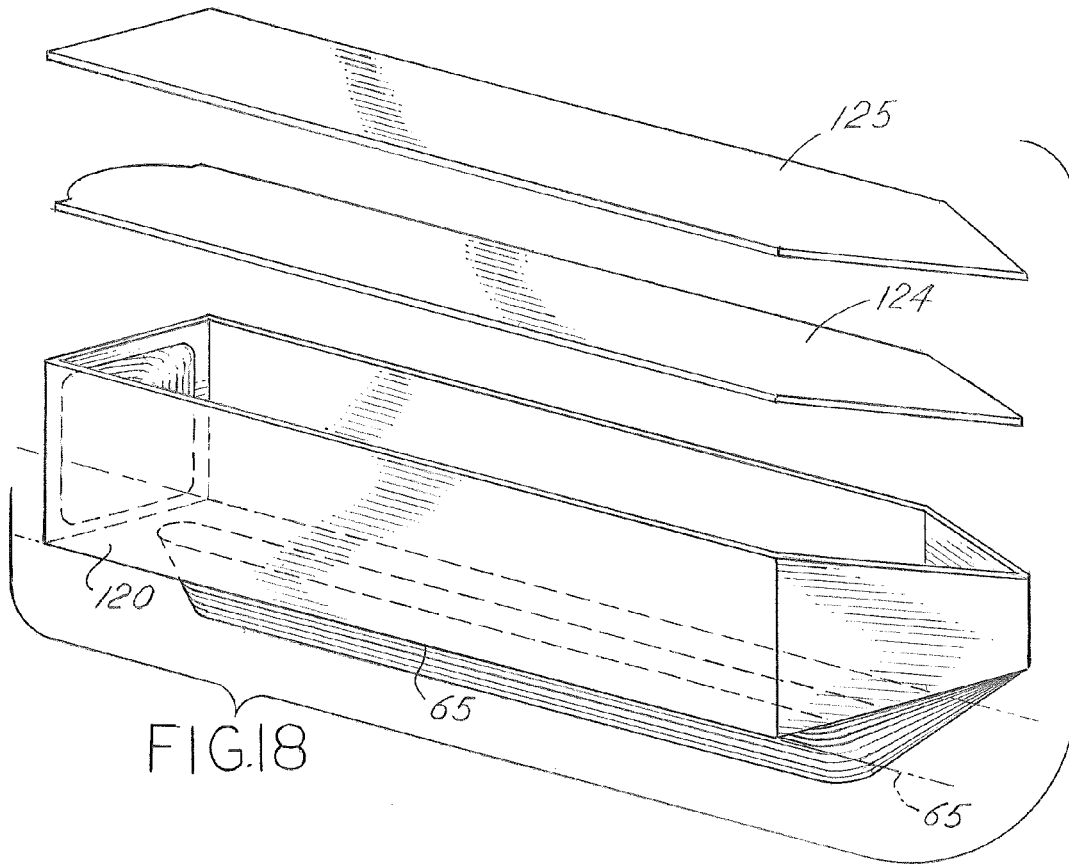


FIG. 17



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## ROLL FORMED PONTOON AND METHOD OF MANUFACTURE

### BACKGROUND OF THE INVENTION

Pontoon boats are a popular watercraft, and making the pontoons for them has been accomplished by several methods. Whichever method of making a pontoon is used, a pontoon will generally have a straight central portion that comprises most of the length of the pontoon, an end cap that will be a blunt cap attached to the back end of the central portion, and a tapered portion forming a nose cone attached to the front end of the central portion that cuts the water as the boat moves forward. A former method for making pontoons consisted of roll forming short pieces of sheet metal laterally to make short cylinders, and welding a number of short cylinders to make a central portion. In so doing, a number of circumferential welds were produced where each cylinder was welded to an adjacent cylinder. In addition to the welds in the central portion, the end cap and nose cone also require circumferential welds. All of the circumferential welds are potential leak points. If a weld is incomplete or has porosity, water can enter the interior of the pontoon. The circumferential welds also add drag since they are raised relative to the smooth portions of the pontoon.

A more advanced method of making pontoons having fewer circumferential welds is disclosed in U.S. Pat. No. 6,644,229. In this patent, a single piece of sheet metal is inserted into rollers and rolled laterally to form a cylindrical central portion. The central portion made by this method has no circumferential welds between its ends. The length of the cylindrical central portion formed in this process is limited to the width of the rollers. The shape of the central portion produced is also limited to a circular or oval shape due to the configuration of the rollers. Another drawback to this process is that the rollers will bow outward during the rolling process, and the bowing is greater in proportion to longer lengths of the rollers. When the rollers bow, this will produce a central portion that is slightly bowed, which is detrimental to the performance of the pontoon in the water. Ideally a pontoon would be straight along its length and have no circumferential welds below the waterline.

### SUMMARY OF THE INVENTION

The present invention is a method for making a pontoon for a pontoon boat and the pontoon made from the method. The method includes an initial step of providing a sheet metal strip that has a width and a length. The strip is then formed longitudinally through successive rollers to provide a central portion having a closed cross section in which the lateral edges of the strip meet. After this stage of the process, end caps are formed at each end of the central portion. Typically one of the end caps is a nose cone that is pointed and cuts the water as the boat moves forward. These end caps may be formed independently and separately of the strip, or may be formed from material at the end of the formed strip. The edges of the central portion are joined together, and the end caps are joined to the central portion. The joining is typically accomplished by welding.

The cross sectional area of the central portion may be a cylinder as is traditionally used in pontoons or a non-circular shape.

### BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a side view of the overall method of the invention;

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FIG. 2 is a perspective view of a pontoon made by the method of this invention;

FIG. 3 is an exploded perspective view of the pontoon shown in FIG. 2;

5 FIG. 4 is a perspective view of another embodiment of a pontoon made by the method of this invention;

FIG. 5 is an exploded perspective view of the pontoon shown in FIG. 4;

FIG. 6 is a perspective view showing the formed trough used in a second application of the method;

FIG. 7 is a perspective view of the formed trough shown in FIG. 6 with sections to be removed shaded;

FIG. 8 is a perspective view of the trough shown in FIG. 6 with punches and dies;

15 FIG. 9 is a sectional view of the punches and dies shown in FIG. 8 stamping the trough shown in FIG. 6;

FIG. 10 is a perspective view of a partially formed pontoon;

FIG. 11 is a perspective view of a partial die in the nose cone of the trough;

20 FIG. 12 is a view of a roller forming the trough against the partial die shown in FIG. 11;

FIG. 13 is a sectional view taken about the line 13-13 in FIG. 12;

FIG. 14 is a perspective view of a forming operation on the top of the trough shown in FIG. 6;

FIG. 15 is a sectional view taken about the line 15-15 in FIG. 14;

FIG. 16 is a perspective view of the end cap being formed onto the pontoon;

30 FIG. 17 is a perspective view of a finished pontoon made using a second application of the method;

FIG. 18 is an exploded perspective view of a pontoon made using a third application of the method; and

FIG. 19 is a perspective view of a finished pontoon using a third application of the method.

### DETAILED DESCRIPTION OF INVENTION

This invention relates to a process for making pontoons 10 for pontoon boats. The process has multiple applications that are similar. A first application of the process for making a pontoon 10 according to this invention is shown in FIGS. 2-5. In either application of the process, the pontoon 10 has a central portion 50, a nose cone 66, and an end cap 62. An exploded view of the pontoon 10 made by the first application method of this invention is shown in FIGS. 4 and 5. A strip 12 of aluminum sheet metal from a coiled roll 14 is fed into a series of rollers 16 longitudinally to form a continuous central portion 50 having a particular cross sectional shape. The roll 14 is supported on an axle 18 that is freely rotatable so that it may be drawn into a roll forming machine 19. FIG. 1 shows the overall process, which can be used to make various cross sectional shapes. Such roll forming machinery is well known in the art.

The roll forming machine 19 is used to produce a central portion 50 of the pontoon 10. FIG. 1 shows a non-circular cross sectional central portion 50 being produced with the method. The method of this invention proceeds from left to right with the beginning step as shown in FIG. 1A toward completion of a central portion 50 as shown in FIG. 1G. As the strip 12 enters the roll forming machine 19 from the coiled roll 14, it will reach a first set of rollers 24 that will bend the strip in a first operation. This is shown in FIG. 1A. This will put a bottom V-bend into the pontoon 10 that will ultimately have a bottom shape with a V-hull. A second set of rollers 28, shown in FIG. 1B, bends the strip outwardly to form a rounded bottom portion 30 on either side of the V-bend. A

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third set of rollers **34** begins bending sidewalls **36** upward as shown in FIG. 1C. The sidewalls **36** are completed in a subsequent operation shown in FIG. 1D. The upper portions **38** of the sidewalls **36** are folded inward toward each other as shown in FIG. 1E to begin forming what will become the top portions **40** of the pontoon **10**. The top of the pontoon **10** is formed in FIG. 1F as the top portions **40** are bent into their final shape.

Once the desired cross section is achieved as shown in FIG. 1F, the lateral edges **44** will meet because the width of the strip **12** is chosen to be the exact perimeter of the cross sectional shape. While the edges **44** are held together, a welder **48** will make a single continuous weld **49** to join the lateral edges **44** as shown in FIG. 1G. After the continuous weld **49** is made for a length that is needed, the formed strip **12** will be cut to form a central portion **50**. The central portion **50** may be cut to a desired length and the cross section may be any configuration that may be roll formed. The length of the central portion **50** may be twenty or more feet long and possibly much longer since there is no limit to the length of a central section **50** that may be produced. This is different than prior art roll formed pontoons in which the central sections are limited to the width of the rollers. A completed central portion having a front end **53** and a back end **55** is shown in FIGS. 3 and 5. The cross section may be a non-circular cross section, as shown in FIG. 3, or, if a cylindrical pontoon is desired, a circular cross section as shown in FIG. 5 may be used. When the shape of the pontoon **10** as shown in FIGS. 2 and 3 is used, a substantial savings in producing a pontoon boat can be realized since cross members supporting a deck can be attached directly to the top of the pontoon **10** as opposed to the use of brackets which must be used with cylindrical pontoons. Whichever cross sectional shape is desired, the process will proceed similarly to the one illustrated in FIG. 1 with successive bending operations occurring to form a final desired central portion.

After the forming operation described above, baffles **60** may be added to partition the central portion **50** into separate chambers. The baffles **60** are inset from the ends **53**, **55** of the central portion **50** a predetermined distance as shown in phantom in FIGS. 2-5. Each baffle **60** is placed with a watertight seal around its perimeter so that the pontoon **10** is divided into separate watertight chambers. The panels **60** may be welded around the perimeter, or held in place with a suitable epoxy adhesive. This is done as a means to prevent the entire pontoon **10** filling with water if it was punctured.

Once the baffles **60** are in place, an end cap **62** is welded to the back end **55** of the central portion **50** as shown in FIGS. 2 and 4. This requires a weld **64** around the perimeter of the central portion **50**. A tapered end cap or nose cone **66** is welded to the front end **53** of the central portion **50** with a weld **68** around the perimeter of the central portion **50**. The nose cone **66** need not be a conical shape or revolution, and may be any tapered shape that is streamlined so that the pontoon **10** more easily cuts the water in which it moves.

As the pontoon **10** floats, it will float at a particular depth depending on the weight placed on it, and the water will form a line **65** along the sides of the pontoon **10**, which is the waterline. In the case of the pontoon **10** shown in FIG. 2, the pontoon's **10** size is chosen so that when the pontoon **10** carries the full amount of weight placed upon it, the waterline **65** is located at the lower edge of the sidewall **36**. In the case of the pontoon **10** shown in FIG. 4, the waterline **65** is above the bottom of the pontoon **10** by approximately one-third of the distance between the top and bottom of the pontoon **10** when the pontoon **10** carries the full amount of weight to be placed upon it. When a pontoon **10** is made according to FIG. 2 or 4, there are only two welds **64**, **68** below the waterline

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when the pontoon **10** is in the water. The continuous weld **49** along the top of the pontoon **10** will be above the waterline **65**.

A second application of the method of this invention may be used to produce a pontoon **80** that has no welds below the waterline. This second application proceeds much the same as the method described above in FIGS. 1-5. However, when the strip is formed to the stage of FIG. 1D, it is cut to a desired length and removed from the forming machine **19** as an open ended trough **81**. FIG. 6 shows the trough **81**. This length of the trough **81** will be longer than the overall length of the finished pontoon **80** as will become apparent from the further description of the process below. Areas **86** of metal are cut from the sidewalls **36**; the areas **86** are shown shaded in FIG. 7. After the areas **86** are removed, the trough **81** is placed in a different machine between a front punch **82** and front die **88**, and a rear punch **84** and rear die **90**, as shown in FIG. 8. The punches **82**, **84**, and dies **88**, **90** are stamped together to form the rough shape of the nose cone **66** and end cap **62**. FIG. 9 shows a sectional view of the compressed dies **88**, **90** and punches **82**, **84**. After the dies **88**, **90** and punches **82**, **84** are separated, the rough shape of the nose cone **66** and end cap **62** are defined as shown in FIG. 10.

After the rough shapes of the end cap **62** and nose cone **66** are formed, a partial die **92** is inserted into the rough shape of the nose cone **66**. The partial die **92** is shown in phantom in FIG. 11. The partial die **92** is shaped so that a support **93** from above protrudes through the open top of the trough **81**. Rollers **94** are then passed over the sidewalls **95** of the nose cone **66** to form folds **96** that form the top flaps **98** of the nose cone, as shown in FIGS. 12 and 13. The partial die **92** is then pulled toward the rear of the trough **81** and may be removed from the nose cone **66**. At this stage of the process, the rear of the pontoon **80** where the end cap **62** will be made remains open as shown in FIG. 14. A pair of internal rollers **100** on a roller frame **101** is inserted into the pontoon and a pair of mating external rollers **102** is pressed against both sides of the trough **81** to form folds **104** that define the top of the central portion **105**. The external rollers **102** press inwardly on both sides simultaneously so that side loading is balanced on both sides of the roller frame **101**, which results in a straight central portion **105**. Once the top flaps **106** are formed, the roller frame **101** is removed through the rear of the pontoon **80**.

At this stage of the process, the rough shape of the end cap **62** is against the rear die **90**, and the only portion of the pontoon **80** that remains open is the rear end as shown in FIG. 16. The rear die **90** pivots about the axis of a rod **107**. A hydraulic cylinder **108** is attached to the rear die **90**. The hydraulic cylinder **108** is actuated which pivots the rear die **90** upward and folds the end cap **62** into place.

Welds **110** are then made where the nose cone **66** and central portion **105** meet. Welds **112** are made where the end cap **62** and central portion **105** meet. Also, a weld **114** is made down the center along the top of the pontoon **80**. The pontoon **80** produced by this application of the method of this patent results in a pontoon having no welded joints below the waterline **65**.

A third application of the method of this invention may be employed to produce pontoons that have no welds below the waterline and also have storage space within them. FIG. 19 shows a pontoon **120** having a storage space **121** within the pontoon. This pontoon **120** is made in the same manner as the pontoon **80** of the second application of the method, but the step of folding the sidewalls **36** is not performed. Instead a bottom panel **124** is placed between the sidewalls as shown in FIG. 19. The bottom panel **124** may be welded in place, and then a top cap **125** may be welded on top to complete the pontoon **120**. If baffles such as those shown in FIG. 3 are

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desired to be placed below the bottom panel 124 to partition the lower portion of the pontoon 120 into separate chambers, the bottom panel 124 may be composed of separate parts that allow welds to be made along the top edges of the baffles. Many configurations of the pontoon 120 with storage space 121 are possible, including configurations that would allow fuel to be stored in the space 121, or having doors that provide access to the storage space 121 that allow below deck storage of large objects.

The invention is not limited to the details given above, but may be modified within the scope of the following claims.

What is claimed is:

1. A method for making a pontoon for a pontoon boat comprising the steps:

- (a) providing a metal strip having a width, a length, and lateral edges;
- (b) forming said metal strip longitudinally to provide a cross sectional shape in which the lateral edges of said strip are adjacent to each other;
- (c) joining the lateral edges of the strip to produce a hollow central portion having a closed cross section and opposite ends; and
- (d) forming end caps from said opposite ends of said central portion to form an enclosed hollow pontoon said end caps being formed continuously from said metal strip so that a portion of said pontoon has no joints between said central portion and each said end cap.

2. A method for making a pontoon as claimed in claim 1, further comprising the step of cutting said closed cross sectional shape to a desired length.

3. A method for making a pontoon as claimed in claim 1, wherein one of said end caps is tapered.

4. A method for making a pontoon as claimed in claim 1, wherein said strip is formed longitudinally through successive rollers.

5. A method for making a pontoon as claimed in claim 2, wherein said central portion is a cylinder.

6. A method for making a pontoon as claimed in claim 2, further comprising the step of partitioning said central portion into separate chambers.

7. A method for a pontoon as claimed in claim 6, wherein rollers form said tapered end cap.

8. A method for making a pontoon as claimed in claim 7, wherein rollers fold said central portion.

9. A method for making pontoons as claimed in claim 1, wherein said end caps are stamped.

10. A pontoon made by the method of claim 1.

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11. A pontoon made by the method of claim 1, wherein no joints are made below a waterline of the pontoon.

12. A method for making a pontoon as claimed in claim 1, wherein said lateral edges are joined by welding.

13. A method for making a pontoon as claimed in claim 1, wherein said end caps are joined by welding.

14. A method for making a pontoon for a pontoon boat as claimed in claim 1, wherein said end caps are formed separately and attached to said central portion.

15. A method for making a pontoon for a pontoon boat comprising the steps:

- (a) providing a metal strip having a width, a length, and lateral edges;
- (b) forming said metal strip longitudinally to provide a cross sectional shape in which the lateral edges of said strip are adjacent to each other;
- (c) joining the lateral edges of the strip to produce a hollow central portion having a closed cross section and opposite ends;
- (d) cutting said closed cross sectional shape to a desired length;
- (e) partitioning said central portion into separate chambers; and
- (f) forming end caps from said opposite ends of said central portion to form an enclosed hollow pontoon, one of said end caps being tapered wherein rollers form said tapered end cap.

16. A method for making a pontoon as claimed in claim 15, wherein rollers fold said central portion.

17. A method for making a pontoon for a pontoon boat comprising the steps:

- (a) providing a metal strip having a width, a length, and lateral edges;
- (b) forming said metal strip longitudinally to provide a cross sectional shape in which the lateral edges of said strip are adjacent to each other;
- (c) joining the lateral edges of the strip to produce a hollow central portion having a closed cross section and opposite ends; and
- (d) forming end caps from said opposite ends of said central portion to form an enclosed hollow pontoon wherein no joints are made below a waterline of said pontoon.

18. A method for making a pontoon as claimed in claim 17, wherein said lateral edges are joined by welding.

19. A method for making a pontoon as claimed in claim 17, wherein said end caps are joined by welding.

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