

March 14, 1933.

H. A. EVANS

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ORNAMENTAL RIBBON AND METHOD OF MAKING SAME

Filed Dec. 16, 1929

Fig. 1.

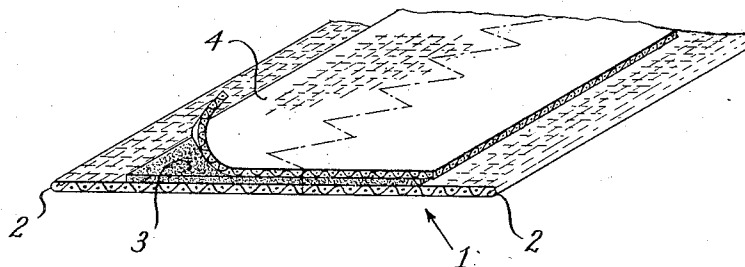


Fig. 2.

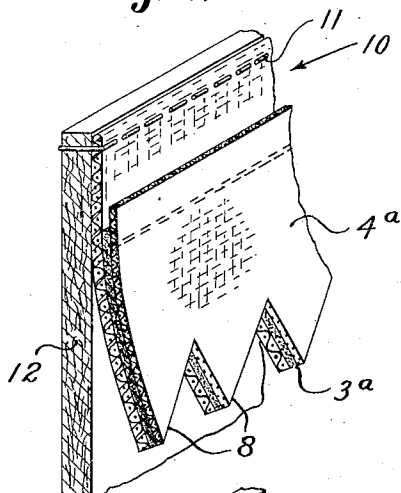


Fig. 4.

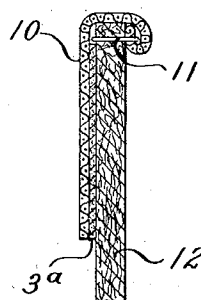


Fig. 3.

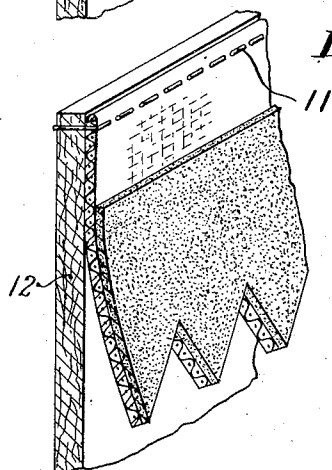
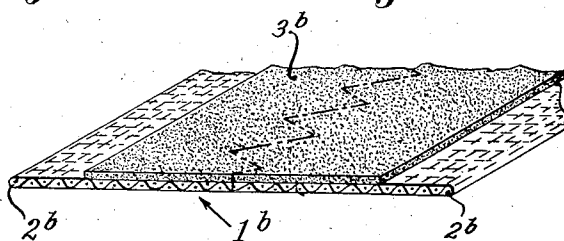


Fig. 5.



Inventor:
Harold A. Evans,
by Robert Cushman Woodbury
Attys.

UNITED STATES PATENT OFFICE

HAROLD A. EVANS, OF LYNN, MASSACHUSETTS, ASSIGNOR TO PARCO SPECIALTY CO., OF
LYNN, MASSACHUSETTS, A CORPORATION OF MASSACHUSETTS

ORNAMENTAL RIBBON AND METHOD OF MAKING SAME

Application filed December 16, 1929. Serial No. 414,365.

This invention is directed to a method of manufacturing ornamental ribbons or binding strips for application to sheet articles and to resulting products. More particularly the present invention is directed to the manufacture of French cord binding strips for shoe uppers and to ornamental binding strips of this character.

My Patent No. 1,618,754 and Patent No. 1,618,809, which issued upon an application filed by Jerome P. Byron and myself, disclose French cord binding strips which have adhesively coated marginal edges adapted to be secured to the inner face of a shoe upper after the opposite marginal portions, which may be free from adhesive, have been stitched to the outer marginal faces of the uppers. In accordance with the disclosures of these patents, a binding ribbon or strip having selvaged edges was secured to the sheet, such as the shoe upper. The cost of weaving ribbons having selvaged edges is distinctly higher than the cost of providing unselvaged strips of similar dimensions and of a similar material; furthermore the selvaged edge upon the adhesively coated margin of the ribbon impedes its ready application to curved marginal portions of the upper and necessitates snipping of the inner selvage to permit such an application of the ribbon.

The present method of manufacturing ornamental ribbon provides one selvaged edge at the side or edge of the ribbon which is to be stitched to the upper, and provides an unselvaged edge at the adhesively coated margin of the strip, this margin preferably being pinked or notched to allow ready application of the ribbon to curved marginal portions of the sheet article or upper. In order to permit this desirable result with accompanying economies in production, I preferably employ a selvaged edge ribbon or strip which is wider than the ultimate strip that is to be applied to the sheet material, and coat the intermediate portion of the original wide

strip with cementitious material, and then cut the strip into two separate ribbons, each of which has a marginal portion coated with the adhesive material, and a margin which is uncoated. This method not only permits economy in the employment of selvaged edge material, but also permits the partial coating of two strips without necessity for painstaking care in the application of the cementitious material adjoining the edge portions of the strip, as would be necessary were the individual strips each to be partially coated. Preferably the strips are severed on a zig-zag line which results in their coated margins being notched or having zig-zag edges, thus permitting greater facility in application of the strips to the curved edge portions of sheet material and affording further economies in the use of the ribbon fabric. It is evident that, when a pinked or zig-zag edge is preferred this method is particularly advantageous, since it avoids the difficulty and waste otherwise involved in cementitiously coating a ribbon having a notched edge. A covering strip of any suitable material is applied to the adhesive layer upon the intermediate adhesively coated portion of the wide strip before the same is severed to provide two separate partially coated ribbons. Thus, the economies in the application of the protective covering strip may be attained and the same may be cut accurately to conform to the notched edge of the separate ribbons.

In the accompanying drawing:

Fig. 1 is a perspective view of a portion of a fabric strip which has selvaged edges, an intermediate cementitious stripe, and a superposed covering strip, each of which may be severed as indicated by dotted lines to provide two ornamental strips or ribbons;

Fig. 2 is a perspective view of a portion of a sheet such as a shoe upper, showing the ribbon stitched to the sheet;

Fig. 3 is a similar view showing the covering strip removed from the ribbon;

Fig. 4 is a section of a marginal portion of a sheet showing the ribbon in its normal attached position upon the edge of the sheet; and

5 Fig. 5 is a perspective view of a portion of a fabric strip which has selvaged edges and an intermediate cementitious stripe, which may be severed as indicated by the dotted lines to provide two ornamental strips or
10 ribbons.

In accordance with the present invention, ornamental binding strips which are to be stitched to sheet articles and which, accordingly, desirably have selvaged edges, may be
15 conveniently manufactured from a wider ribbon 1 having opposite selvaged edges 2; for example, the ribbon 1 may have a width substantially 75% greater than that of one of individual strips manufactured therefrom.
20 An intermediate stripe 3 of suitable agglutinant, such as non-drying, permanently plastic cement, may be applied to the central part of the ribbon 1, it being evident that extreme accuracy in the application of this strip and
25 in the exact positioning of the edges of the same is not necessary. After the agglutinant 3 has been applied to the ribbon, a protective strip 4 may be applied to the adhesive stripe. Preferably the covering strip 4 is somewhat
30 wider than the stripe in order to afford adequate protection for the edges of the latter, and to facilitate its ready removal from the adhesive coating.

The ribbon with the intermediate adhesive
35 stripe and covering strip may then be run through suitable cutting mechanism, including a cutter adapted to form a zig-zag or notched cut, as indicated by dotted lines in Fig. 1 thus severing the ribbon 1, the adhesive
40 stripe 3, and the covering strip 4 to provide two ribbons having unselvaged, pinked edges with their marginal portions, adjoining these edges, coated with adhesive material and protected by the notched covering strip. The
45 resulting ribbon is shown in Fig. 2 and is designated by the numeral 10, having the adhesive coating 3^a, the covering strip 4^a, and having a notched or pinked edge designated by numeral 8. The ribbon as completed may
50 be rolled or wound upon suitable spools and distributed to the points of use or application to sheet articles. When the ribbon is to be applied to a sheet article it is attached in the same manner as described in my above
55 patent, having its uncoated edge secured by stitches 11 to the marginal portion of the sheet member 12, Fig. 2, the covering strip 4^a in the meantime being retained in engagement with the adhesive coating so that the
60 accidental engagement of the latter with foreign objects is avoided. The covering may be readily stripped or peeled from the adhesive layer (Fig. 3) and the ribbon turned over the edge of the sheet member 12, having
65 its adhesive coating 3^a pressed into firm en-

gagement with the inner face of the sheet as shown in Fig. 4. It is thus evident that, when a permanently plastic or "cold process" cement is used, a covering strip may be applied to the adhesive layer or stripe upon the
70 intermediate adhesively coated portion of the wide strip before the same is severed to provide two partially coated ribbons.

It is obvious however that the present invention is not confined to the employment of
75 "cold process" or permanently plastic cement, and many of the advantages attributable to this invention may be attained with other types of cement, such as those requiring the application of heat or solvents to render them
80 tacky. Ordinarily cements of this character do not require a protective covering strip. Fig. 5 illustrates a wide strip 1^b, which may have selvaged edges 2^b and may receive an intermediate stripe 3^b of "hot process" cement.
85 The wide stripe 1^b as thus coated is then severed into two ribbons by cutting along an intermediate zig-zag line to provide two French cord binding strips. Each of these ribbons has one selvaged edge, and an
90 opposite marginal portion coated with adhesive material and the adjoining edge notched and unselvaged. Ribbon of this type accordingly may be similar to that disclosed in Fig. 3, and may have its coated
95 portion heated to permit its adhesive application to the inner surface of the main sheet.

Not only may a ribbon manufactured in this manner have a selvaged edge at its uncoated margin which permits the ready and
100 secure stitching of the same to the outer face of the sheet article, but its opposite edge may be raw or unselvaged and preferably notched to permit its ready application to curved edge portions of the upper. Furthermore,
105 this method of manufacturing ornamental ribbons permits economy in the use of selvaged edge material since a single ribbon with two selvaged edges may be formed into two lengths or strips of ribbon for application to sheet material, and, due to the preferred manner of cutting the original
110 wide ribbon or strip, the total amount of fabric employed in producing a given length of French cord binding may be less than that required by methods heretofore employed.
115 Similarly, but a single coating operation is necessary in order to provide two partially coated strips of ribbon, and painstaking care or extreme accuracy in the location of the edges of the adhesive stripe is not
120 necessary as would be the case were the separate ribbons to be individually partially coated. This method especially avoids the difficulty of coating a pinked or notched
125 edge which would entail considerable waste of adhesive material if other methods of manufacture were employed, and this method requires but one application of a covering strip for two lengths of ribbon, and
130

also permits economy in the use of the covering fabric as well as permitting it accurately to conform to the notched or pinked edge of the binding strips.

5 From the foregoing it is evident that I have provided a method which permits the production of selvaged edged, partially coated French cord binding at a very low cost without requiring especial care in the application of the adhesive material, and 10 furthermore that this method is particularly applicable to the manufacture of pinked or notched edge ribbon of this character.

I claim:

15 1. The method of manufacturing ornamental ribbons for application to sheet articles, comprising the coating of the central portion of a strip having selvaged edges with a stripe of permanently plastic agglu- 20 tant, applying a protective strip to the stripe and cutting the strip, the stripe, and the protective strip into two separate elongate members, each of which comprises a ribbon having an adhesively coated marginal 25 portion protected with a protective covering member, and its opposite edge provided with a selvaged edge.

2. The method of manufacturing ornamental ribbons, which comprises applying a cementitious stripe to the intermediate part 30 of a fabric strip, applying a protective covering strip to the stripe, and cutting a zig-zag cut through the strip, stripe and covering strip to provide two ribbons with temporary covering strips protecting their adhesively 35 coated notched edge portions.

3. The method of manufacturing ornamental ribbons for application to sheet articles, comprising the coating of the central 40 portion of a strip having selvaged edges with a stripe of permanently plastic agglutinant, applying a protective strip to the stripe and cutting the strip, the stripe, and the protective strip along a zig-zag line thus dividing 45 them into two separate elongate members, each of which comprises a ribbon having an adhesively coated marginal portion protected with a loosely woven covering member, and its opposite edge provided with a selvaged edge, the coated margin having a zig- 50 zag edge and carrying a covering strip with a similar edge.

4. The method of manufacturing ornamental ribbons for application of sheet articles, comprising the coating of the central 55 portion of a strip having selvaged edges with a stripe of permanently plastic agglutinant, applying a covering strip to the stripe so that it projects beyond the edges to the stripe, 60 and cutting the strip, the stripe, and the covering strip along a zig-zag line extending substantially from one side of the stripe to the other thus dividing them into two separate elongate members, each of which 65 comprises a ribbon having an adhesively

coated marginal portion protected with a covering member, and its opposite edge provided with a selvaged edge, the coated margin having a zig-zag edge and carrying a covering strip with a similar edge. 70

5. The method of manufacturing ornamental ribbons for application to sheet articles, comprising the application of a coating of permanently plastic adhesive to a face portion of a strip, the application of an elongate 75 covering member to the exposed face of the adhesive coating, and cutting the strip and the covering member along a zig-zag line, thereby forming two ribbons, each of which has a notched edge, an adhesively coated face 80 portion, and a notched covering member protecting the adhesive coating.

6. The method of manufacturing binding tapes of the type having an uncoated marginal portion provided with a selvaged edge 85 to be stitched to a sheet article, and an opposite marginal face coated with a cement suitable for adhesive attachment to the sheet article, which method comprises applying to one face of a double selvaged tape intermediate 90 its selvaged edges, an adhesive strip capable of later adhesive application to the sheet article, said adhesive strip having substantially less width than said tape to provide marginal zones adjacent to each of the selvaged edges of sufficient width to receive 95 stitching, and severing the tape longitudinally by a cut spaced inwardly from each of the margins of the adhesive strip, thereby providing a pair of tapes each having an adhesive-coated margin free from selvaging and an opposite margin free from said coating but provided with a selvaged edge. 100

7. The method of manufacturing binding tapes of the type having an uncoated marginal portion provided with a selvaged edge 105 to be stitched to a sheet article, and an opposite marginal face coated with a cement suitable for adhesive attachment to the sheet article, which method comprises applying to one face of a double selvaged tape intermediate its selvaged edges a coating of thermo- 110 plastic adhesive having substantially less width than said tape, the margins of said coating being spaced inwardly from the selvaged edges of the tape to provide uncoated marginal zones of sufficient width to receive stitching, allowing said adhesive to set, and severing the tape longitudinally through said coating by a serrated cut spaced inwardly 120 from each of its longitudinal edges so that the width of the coating exceeds the depth of the serrations, thereby providing a pair of tapes each having an adhesive-coated serrated margin free from selvaging and an opposite margin free from said coating but provided with a selvaged edge. 125

8. An article of manufacture comprising a tape having a selvaged edge and an opposite unselfaged serrated edge, and a coating 130

of adhesive on one face of the tape having
an effective width substantially less than the
tape but greater than the depth of the serra-
tions, the inner longitudinal edge of said
5 coating being spaced inwardly from said sel-
vaged edge to provide an uncoated selvaged
marginal portion of sufficient width to receive
stitching, and the outer edge and marginal
portion of said coating being coextensive
10 with said opposite edge of the tape.

Signed by me at Lynn, Massachusetts, this
3rd day of December, 1929.

HAROLD A. EVANS.

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