No. 896,022. PATENTED AUG. 11, 1908.

J. JANOWITZ.

METHOD OF MAKING STAYS.

APPLICATION FILED MAR. 5, 1906.

Fig. 1.

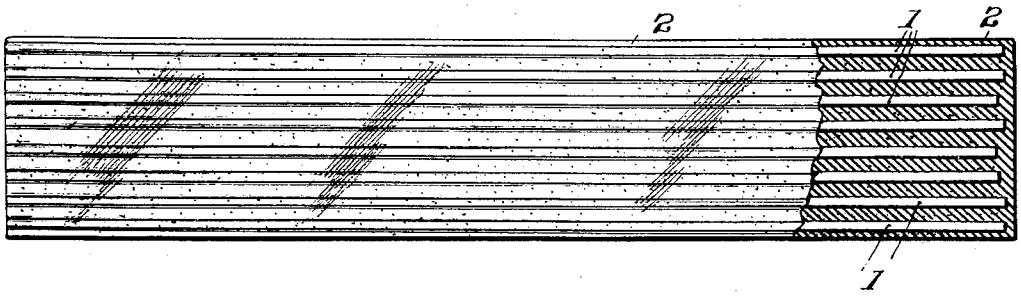

Fig. 2.

Fig. 3.

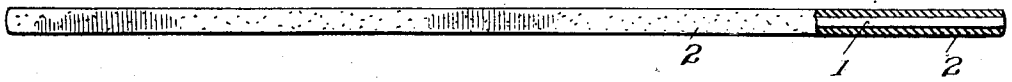

Fig. 4.

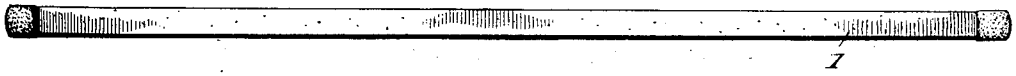

Fig. 5.

Witnesses

Jno. Amirie

M. R. Tanner

Inventor

Julius Janowitz

By Robertson & Johnson

Attorneys

UNITED STATES PATENT OFFICE.

JULIUS JANOWITZ, OF NEW YORK, N. Y.

METHOD OF MAKING STAYS.

No. 896,022. Specification of Letters Patent. Patented Aug. 11, 1908.

Application filed March 5, 1906. Serial No. 304,386.

To all whom it may concern:

Be it known that I, JULIUS JANOWITZ, of New York city, in the county of New York and State of New York, have invented certain new and useful Improvements in Methods of Making Stays, of which the following is a specification.

This invention relates to that class of stays which is intended to take the place of bones in corsets, dresses, etc., and more particularly to that class which have a covering of rubber or other suitable compound which is designed to prevent their breaking when in use, or rusting after washing or from perspiration of the wearer. Considerable trouble has heretofore been experienced in this class of stay owing to the fact that it has been difficult to properly form the ends so that the composition covering will not break off where it projects slightly beyond the steel within the covering. Various expedients have been provided but they have proved more or less ineffectual. In one way of making these stays, the steel is first cut into the required lengths and a metal die having a groove for each piece of steel is first covered with a sheet of composition in a plastic state and the pieces of steel laid on this sheet immediately over the grooves in the said die. Another sheet of the plastic composition is laid over the steel covered sheet and the upper member of the mold is placed in position and the whole is then put within a press and suitably vulcanized in the ordinary manner. After vulcanization, the sheet is cut so as to produce a number of stays and the edges of each individual stay are polished or smoothed over and the article is ready for the market. But with these stays the trouble heretofore referred to has been experienced, *i. e.*, owing to the fact that some pieces of the steel are a trifle shorter than others, the ends of the composition covering would project a little more on the shorter steels than on the longer ones, in consequence of which the ends would break off where the support of the steel was not given. I overcome this difficulty by removing the end of the composition covering as, for example, by grinding the composition end down so that it is flush with the steel. After this is carefully done, I form a cap on the end of the steel as, for example, by dipping the end of the stay into celluloid, or a similar solution; thus making the ends not only secure from breaking, but also making them a trifle thicker and more round so that they are not pushed through the cloth.

My invention may therefore be said to consist in the novel method of making stays which consists in removing the end of a composition covered stay, as by grinding off the composition covering, thus exposing the end of the stay, and in forming a cap thereon.

In the drawings accompanying this description and forming part thereof, and which illustrate the preferable, though not necessary manner of carrying out my invention: Figure 1 is a top plan view of a series of stays made in sheet form, with part of the coating broken away in order to show the irregular ends. Fig. 2 is a similar view of a single stay after being cut from the sheet, with part broken away. Fig. 3 is a similar view of a single stay after the end has been ground off. Fig. 4 is a view of a stay, such as shown in Fig. 3, but after having the cap formed thereon. Fig. 5 is an edge view of the completed stay.

Referring now to the details of the drawings by numerals: 1 in Fig. 1 represents a series of strips of steel which have been suitably covered with a coating, as 2. It will be observed that these stays are of slightly irregular lengths so that the covering projects more from some of the pieces of steel than from others. In the course of manufacture, the multiplex article shown in Fig. 1 is cut into separate stays such as shown in Fig. 2, and the edges are, of course, dressed down in any suitable way. After these stays are separated one from the other, the rubber coating which projects from the end of the steel 1, as shown in Fig. 2, is removed, as by grinding off composition coating so that none of the coating projects beyond the steel support. Each individual stay is then dipped into a celluloid or similar solution so as to form a cap thereon, as shown in Fig. 4, and this step in the process makes the ends not only secure from breaking, but also makes them a trifle thicker and more round so that they are not pushed through the cloth after they are in use.

My invention is so simple that it is believed the foregoing statement will be sufficient to enable those skilled in the art to understand my new stay and the method of making the same.

I am, of course, aware that it has heretofore been proposed to form caps on the ends of dress stays, and do not claim this broadly.

At the same time it will be obvious that I do not limit my invention to any particular composition for the covering or for the cap.

What I claim as new is:

1. The method of making stays which consists in removing the end of a composition covered stay thus exposing the end of the stay and forming a cap thereon.

2. The herein described method of making stays which consists in vulcanizing a covering upon a core, removing the end of the vulcanized covering as by grinding, and forming a cap thereon, substantially as described.

Signed by me this 26 day of Feb. 1906.

JULIUS JANOWITZ.

Witnesses:
WASHINGTON L. MANN,
H. E. MANLY.