July 7, 1953 J. WILLIAMS ET AL 2,644,776

ARTICLE AND METHOD OF MAKING FABRIC COVERED RODS

Filed June 10, 1950 2 Sheets-Sheet 1

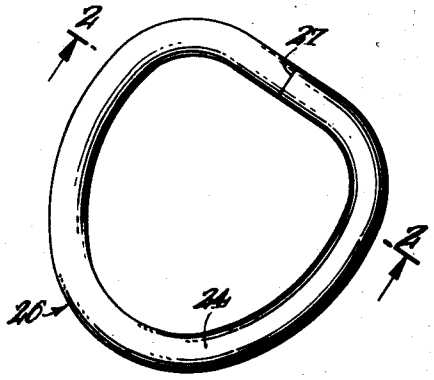


FIG. 1.

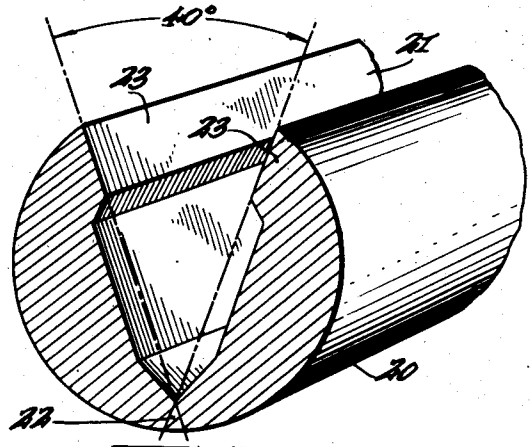


FIG. 3.



FIG. 2.

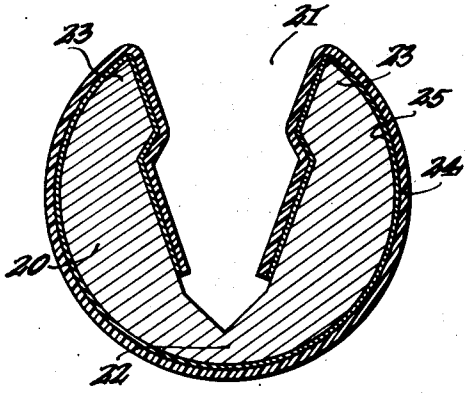


FIG. 4.

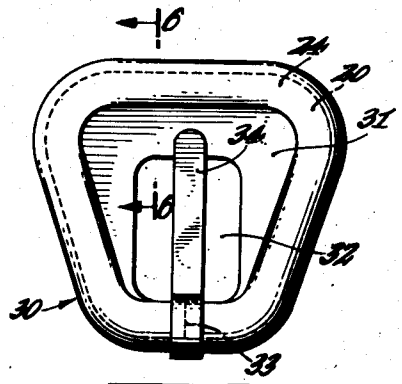


FIG. 5.

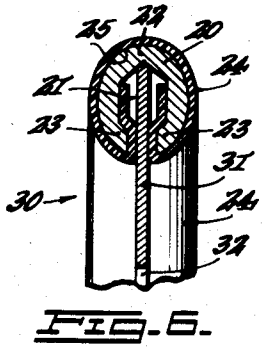


FIG. 6.

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ARTICLE AND METHOD OF MAKING FABRIC COVERED RODS

Filed June 10, 1950 2 Sheets-Sheet 2

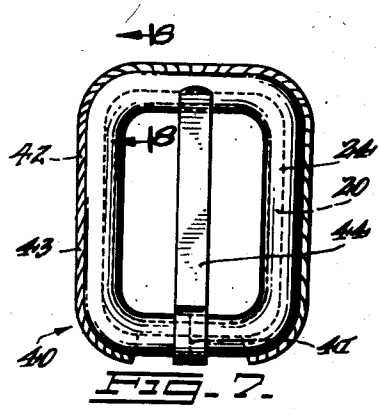


FIG. 7.

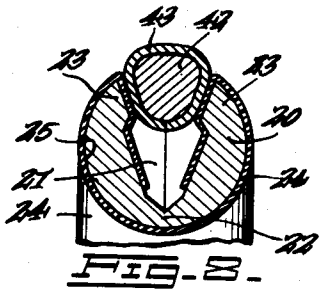


FIG. 8.

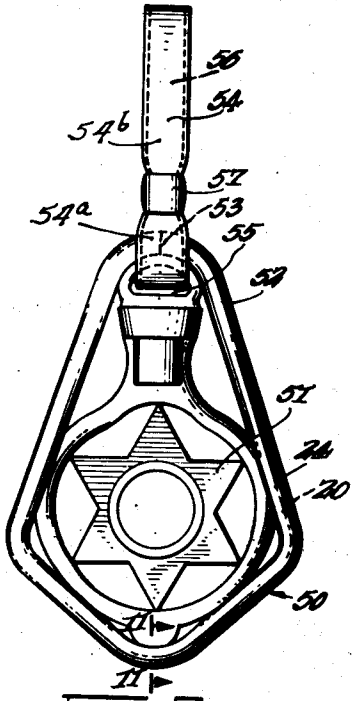


FIG. 9.

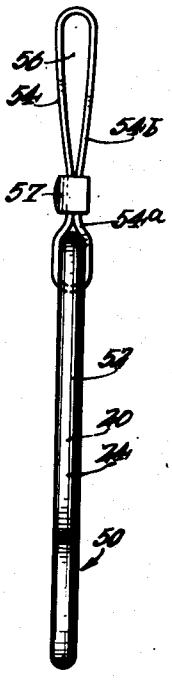


FIG. 10.

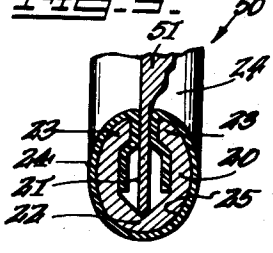


FIG. 11.

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ARTICLE AND METHOD OF MAKING FABRIC COVERED RODS

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Application June 10, 1950, Serial No. 167,424

12 Claims. (Cl. 154—43)

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This invention relates to new and useful improvements in method of covering a metallic rod and the metallic rod so covered.

More particularly, the present invention proposes a new and novel method for securely attaching a covering of flexible material to a length of metallic rod and then using the covered rod as the frame for a belt buckle, as a decoration for ladies' accessories, as a decoration for picture frames and mirrors, jewel boxes and cases of various types and other similar uses.

Heretofore, it has been known to cut a groove of uniform width in the side of a length of metallic rod and to adhesively secure a length of leather or the like about the rod with the edges of the length of leather extended into the groove. It has been found, however, that merely cementing the covering on the rod with the edges thereof located in the groove does not provide a satisfactory long wearing article. After a while portions of the covering, due to drying out or disintegration of the adhesive material used, begin to detach themselves from the rod destroying the ornamental beauty of the article of which the covered rod forms a part.

The present invention proposes extruding the rod to have a channel in the side thereof into which the edges of the covering can be extended after being adhesively engaged about the rod with the side wall of the rod opposite the open side of the channel being so thin that the portions of the rod on opposite sides of the channel can be squeezed together to clamp the inserted edge portions of the covering in position in the channel to overcome the objections to the prior art constructions.

In accordance with the present invention, there is a dual means for securing the covering in position, so that in the event the adhesive should dry out and disintegrate the edge portions of the covering will be clamped in position making it impossible for the covering to come loose.

A further object of the invention proposes providing the channel during the extruding process with inwardly projected lips on opposite sides of the open side of the channel in a manner to contact the inserted edge portions of the covering and securely clamp them in position.

Another object of the present invention is the provision of means for manufacturing the covered rod and employing that covered rod in the manufacture of buckle frames or as a part of the decoration of an accessory to be worn by women or as a decoration for articles of the type previously referred to.

It is a further object of the present invention to construct covered rods and articles employing those rods which are simple and durable and which can be manufactured and sold at a reasonable cost.

For further comprehension of the invention,

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and of the objects and advantages thereof, reference will be had to the following description and accompanying drawings, and to the appended claims in which the various novel features of the invention are more particularly set forth.

In the accompanying drawings forming a material part of this disclosure:

Fig. 1 is a perspective view of a buckle frame in accordance with the present invention and made of covered rod prepared in accordance with the present invention.

Fig. 2 is an enlarged transverse sectional view taken on the line 2—2 of Fig. 1.

Fig. 3 is an enlarged perspective view of the extruded metallic rod used to form a part of the covered rod of the present invention.

Fig. 4 is an end elevational view of Fig. 3 with the covering adhesively secured to the rod and prior to squeezing together the side portions of the rod.

Fig. 5 is a plan view of a buckle constructed in accordance with a modification of the present invention.

Fig. 6 is an enlarged detailed sectional view taken on the line 6—6 of Fig. 5.

Fig. 7 is a view similar to Fig. 5, but illustrating the buckle constructed in accordance with a further modification of the present invention.

Fig. 8 is an enlarged detailed sectional view taken on the line 8—8 of Fig. 7.

Fig. 9 is an elevational view of an accessory to be worn by women and which includes as a part of the decoration thereof a length of covered rod prepared in accordance with the present invention.

Fig. 10 is a side elevational view of Fig. 9.

Fig. 11 is an enlarged detailed sectional view taken on the line 11—11 of Fig. 9.

The buckle frame, according to the first form of the invention shown in Figs. 1 to 4, includes a metallic rod 20 of aluminum or the like which has a channel 21 extended in from one side thereof. The channel 21 is substantially V-shaped with the side walls thereof forming substantially a forty degree angle as clearly shown in Fig. 3. The material 22 of the rod 20 between the apex of the V-shaped channel 21 and the outer periphery of the rod 20 is comparatively thin so that the side portions of the rod 20 on opposite sides of the channel 21 can be easily squeezed together for a purpose which will become clear as this specification proceeds.

The rod 20 is formed by an extrusion process to include the channel 21 and at the same time the opposite side walls of the channel, immediately adjacent the open side of the channel, are formed with lips 23 which are directed inward and toward one another.

Engaged about the rod 20, there is a covering 24 preferably of a synthetic resin or plastic ma-

terial but which may also be leather, cloth, artificial leather, rubberized materials, oilcloth or any other similar material. The cover **24** is in the form of an elongated strip of material with its length extended parallel to the length of the rod and having its free edge portions extended into the channel **21** well past the lips **23**, see particularly Figs. 2 and 3. Prior to engaging the covering about the rod **20**, the inner face thereof is coated with a layer of adhesive, mucilage or the like **25** so that the covering will be adhesively secured to the adjacent outer face of the rod **20** or the walls thereof defining the channel **21**.

When the covered rod is to be used to form the frame **26** of a buckle as shown in Fig. 1, the side portions of the rod **20** on opposite sides of the substantially V-shaped channel **21** are first squeezed together to securely clamp those portions of the inserted edges of the covering **24** which extend across the faces of the lips **23** in position between those lips. Thus, the covering **24** is held, in addition to the adhesive, mucilage or the like **25**, by the clamping action of the lips **23** so that even if the adhesive, mucilage or the like 25 should dry out or otherwise disintegrate it will be impossible for the covering to work itself loose from the rod **20**. Following the clamping together of the side portions of the rod **20**, the covered rod is then bent into the desired shape of the buckle frame with the ends of the covered rod contacting each other at a point **27**, see Figs. 1 and 2 to be located beneath that end of the belt which is to be permanently attached to the buckle frame. The usual tongue, not shown, is also pivotally attached to the buckle frame **26** at the point **27**, as is generally known in the art, to complete the formation of the covered buckle. The buckle frame **26** is bent to shape with the open side of the channel **21**, which is now pressed shut, located on the inside of the frame.

In the modification of the invention shown in Figs. 5 and 6, there is illustrated a buckle **30** which includes a covered rod constructed as described in connection with the first form of the invention. The buckle **30** includes a polished metallic buckle plate **31** formed with a passage **32** for the tongue end of the belt to be attached to the buckle **30**.

In assembling the buckle **30**, the covered rod after the covering **24** has been adhesively applied thereto, is bent about the periphery of the metallic plate **31** with the edge portions of that plate extending into the channel **21** completely to the apex thereof as shown in Fig. 6. The ends of the covered rod join one another at the point **33**. Following the bending of the covered rod about the metallic plate **31**, the side portions of the rod on opposite sides of the channel **21** are squeezed together to clamp the inserted edge portions of the covering **24** between the adjacent faces of the metallic plate **31** and the lips **23**.

To complete the formation of the buckle **30** a tongue **34** has one end curled about the plate **31** and the covered rod, at the point **33** where the ends contact one another.

In Figs. 7 and 8, there is illustrated a buckle **40** constructed in accordance with a still further modification of the present invention. The buckle **40** is constructed by bending the covered rod, following the application of the covering **24**, into the desired shape with the ends of the covered rod contacting one another at the point **41** and with the open side of the covered rod, which is still open, directed outward. Extended along the open side of the channel **21** there is length of stiff wire **42** which has a length of leather or similar material **43** spirally wound thereabout. The wire **42** is tightly bent about the periphery of the bent covered rod so that the inserted edge portions of the covering **24** and the leather or similar material **43**, which is adhesively secured to the wire **42**, are clamped between the adjacent faces of the lips **23** and the wire **42**, see Fig. 8, to be retained thereby in the event the respective adhesives dry out or otherwise disintegrate.

A novel decorative appearance can be achieved in the buckle **40** by enclosing the rod **20** in a covering **24** of one color and spirally enclosing the wire **42** in leather **43** colored to contrast with the color of the covering **24**. To complete the formation of the buckle **40** a metallic tongue **44** has one end pivotally bent about the covered rod at the point **41** where the ends thereof meet.

In Figs. 9 to 11 there is illustrated an accessory **50** of the type worn by women pendant fashion from a waist engaging belt. The accessory **50** is comprised of a center molded plate **51** having a covered rod **52** engaged about the periphery thereof with the ends of the rod **52** meeting at the point **53** at the top thereof. The plate **51** is molded of metal in any desired shape and to include any desired design. The covered rod **52**, following the adhesive securing of the covering **24** to the metallic rod **20** and with the channel **21** still open, is bent about the periphery of the plate **51** with certain of the edge portions of the plate extending completely into the channel **21** completely to the apex thereof. Following bending of the covered rod **52** about the plate **51**, the side portions of the covered rod **52** on opposite sides of the channel **21** are squeezed together so that the inserted edge portions of the covering **24** will be clamped between the adjacent faces of the lips **23** and the inserted edge portions of the plate **51**, see Fig. 11. In those areas of the covered rod **52** where there are no inserted edge portions of the plate **51**, the inserted edges of the covering **24** are clamped between the adjacent faces of the lips **23** as described in connection with the first form of the invention. By making those portions of the plate **51** which are to be inserted into the channel **21** as thin as possible, the covered rod **52** when squeezed together throughout its entire length will be thickened very little in the areas where the edge portions of the plate **51** are inserted.

To complete the formation of the accessory **50**, one end of a strap **54** has one end **54**[a] inserted through an opening **55**, see Fig. 9, formed in the molded plate **51** and extended upward along the back face of the strap. The other end **54**[b] of the strap **54** is extended downward along the back face of the strap forming a loop **56** through which the waist engaging belt can be passed. The ends **54**[a] and **54**[b] are secured in position behind the strap **54** by a metallic clip **57** engaged about the strap closely adjacent the top portion of the covered rod **52**.

From the foregoing it is apparent that the invention proposes a new and improved covered rod and method of forming the same and which covered rod can be used in various ways both in the formation of articles possessing utility by themselves or as decorative additions on other articles without departing from the scope of the present invention.

While we have illustrated and described the preferred embodiments of our invention, it is

to be understood that we do not limit ourselves to the precise constructions herein disclosed and the right is reserved to all changes and modifications coming within the scope of the invention as defined in the appended claims.

Having thus described our invention, what we claim as new, and desire to secure by United States Letters Patent is:

1. The method of manufacturing a covered rod, which comprises extruding a metallic rod having a V-shaped channel extended in from one side thereof and lips adjacent the open side of the channel directed toward one another with the metal between the apex of the V and the outer periphery of the rod being comparatively thin and the sides of the V being formed at substantially a 40° angle, covering the rod with a cover, extending the edge portions of the cover into the channel past the lips, and squeezing the side portions of the rod on opposite sides of the channel together to clamp the inserted edge portions of the cover between the adjacent faces of the lips.

2. The method of manufacturing a covered rod, which comprises extruding a metallic rod having a V-shaped channel extended in from one side thereof and lips adjacent the open side of the channel directed toward one another with the metal between the apex of the V and the outer periphery of the rod being comparatively thin, coating one face of a length of cover material with a layer of adhesive material, engaging the cover about the rod with the coated face facing the rod, extending the free edges of the cover into said channel past said lips, and squeezing the side portions of the rod on opposite sides of the channel together to clamp the inserted edge portions of the cover between the adjacent faces of the lips.

3. The method of manufacturing a buckle frame, which comprises extruding a metallic rod having a V-shaped channel extended in from one side thereof and lips adjacent the open side of the channel directed toward one another with the sides of said V being formed at substantially a 40° angle, covering said rod with a cover, extending the edge portions of the cover into said channel past said lips, squeezing the side portions of said rod on opposite sides of said channel together for clamping the inserted edge portions of the covering between the adjacent faces of the lips, and bending the rod into the desired shape with the ends thereof meeting at the point where the buckle tongue is to be pivotally attached.

4. A covered rod comprising a metallic rod having a V-shaped channel extended in from one side thereof, the metal in said channel between the apex of the V and the outer periphery of said rod being comparatively thin, lips on the side walls of the channel adjacent the open side thereof directed toward one another and spaced at substantially a 40° angle, and a covering engaged about the rod and having its edge portions inserted into said channel past said lips and clamped between said lips.

5. A covered rod comprising a metallic rod having a V-shaped channel extended in from one side thereof, the metal in said channel between the apex of the V and the outer periphery of said rod being comparatively thin, lips on the side walls of the channel adjacent the open side thereof directed toward one another and spaced at substantially a 40° angle, and a covering engaged about the rod and having its edge portions inserted into said channel past said lips and clamped between said lips, and adhesive securing the inner face of said covering to said rod.

6. A covered rod comprising a metallic rod having a V-shaped channel extended in from one side thereof, the metal in said channel between the apex of the V and the outer periphery of said rod being comparatively thin, lips on the side walls of the channel adjacent the open side thereof directed toward one another and spaced at substantially a 40° angle, and a covering engaged about the rod and having its edge portions inserted into said channel past said lips and secured between said lips, said rod being aluminum.

7. A covered rod comprising a metallic rod having a V-shaped channel extended in from one side thereof, the metal in said channel between the apex of the V and the outer periphery of said rod being comparatively thin, lips on the side walls of the channel adjacent the open side thereof directed toward one another and spaced at substantially a 40° angle, and a covering engaged about the rod and having its edge portions inserted into said channel past said lips and clamped between said lips, said covering being made of plastic material.

8. The method of manufacturing a covered rod, comprising extruding a hollow rod frame having a V-shaped channel at the interior thereof and providing lips adjacent the open sides thereof, the apex of said V-shaped channel and said lips being in a straight line, covering the rod with a cover, extending the edge portions of the cover inside the channel past the lips, and squeezing the side portions of the channel together to clamp the inserted covering portion that overlies the lips.

9. The method of claim 8 wherein in forming the hollow rod frame, the interior section of the frame between the lips and the groove is further cut away, the free edges of the cover extending in said cut away portion and terminating at the V-shaped channel.

10. The method of claim 9 wherein the cut away portion is parallel to the lips and apex of the V-channel.

11. A covered rod comprising a hollow frame, with a V-shaped channel, lips on the open sides of said channel, the lips and the apex of the V-shaped channel being in the same plane, and a covering around the rod and terminating within the hollow frame beyond said lips and clamped together by said lips.

12. The article of claim 11 wherein the angle formed by the V-apex and the lips is substantially 40 degrees.

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