Aug. 13, 1940. A. H. SAUER, JR 2,211,676

METHOD OF MAKING STRAP LOOPS

Filed Jan. 13, 1940

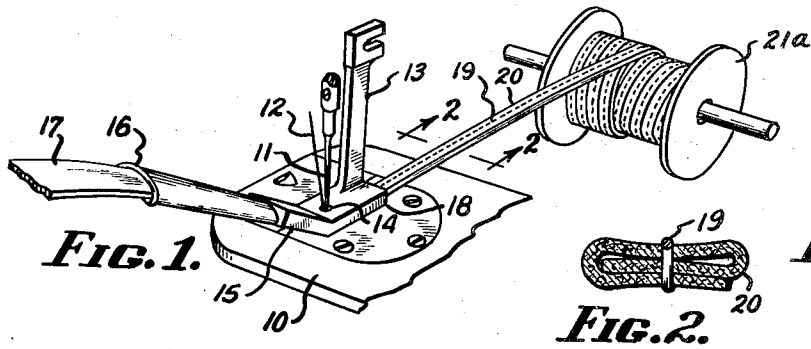


FIG. 1.

FIG. 2.

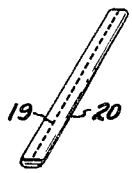


FIG. 3.

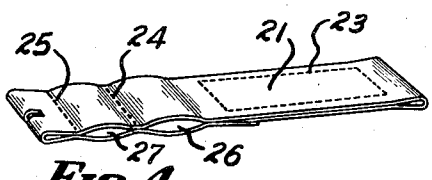


FIG. 4.

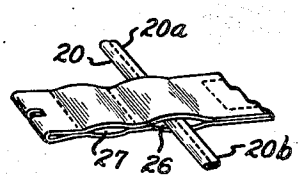


FIG. 5.

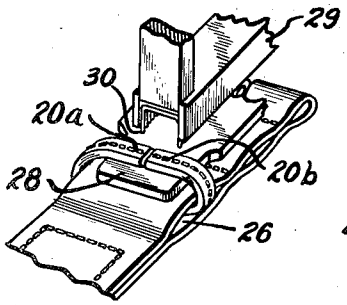


FIG. 6.

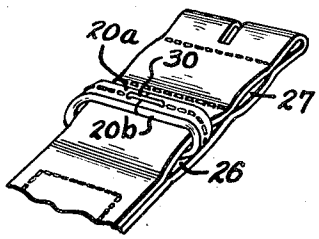


FIG. 7.

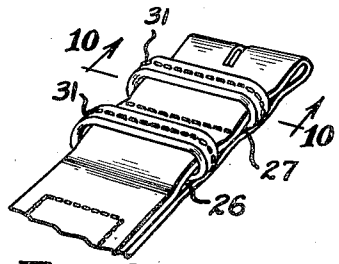


FIG. 8.

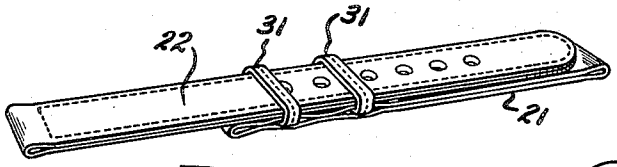


FIG. 9.

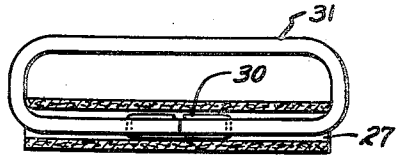


FIG. 10.

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METHOD OF MAKING STRAP LOOPS

Albert H. Sauer, Jr., Cincinnati, Ohio

Application January 13, 1940, Serial No. 313,756

2 Claims. (Cl. 69—21)

This invention relates to methods of making a strap loop or keeper. While the method described herein is applicable to many uses, I will describe it with reference to a wrist watch strap, it being understood that the method and the article made thereby could just as well be used in connection with belts or the like.

Strap loops as provided in the past have been of relatively stiff and heavy construction and have had the disadvantage of causing indentations in the strap in the region of the loops which were unsightly. Furthermore, the manufacture and application of the loops of a strap has generally been one of the most awkward and costly operations in the manufacture of the watch strap.

It is, therefore, an object of my invention to provide a method of making strap loops which are pleasing in appearance and which will not mar the strap as has generally been the case with the strap loops well known in the art and which method is simple and speedy and inexpensive.

These and other objects of my invention which will be pointed out in more detail hereinafter or which will be apparent to one skilled in the art upon reading these specifications, I accomplish by that series of method steps of which I shall now describe exemplary embodiments. Reference is made to the drawing forming a part hereof and in which:

Figure 1 is a partial perspective view of the apparatus used in making the loop.

Figure 2 is a cross sectional view on an enlarged scale taken on the line 2—2 of Figure 1.

Figure 3 is a partial perspective view of a portion of loop material.

Figure 4 is a perspective view of one part of a more or less conventional wrist watch strap which is adapted to have a buckle attached thereto as is well known in the art.

Figure 5 is a view similar to Figure 4 showing the first step in the process of applying the loop.

Figure 6 is a partial perspective view of a stapling machine showing how the strap and loop is positioned for fastening.

Figure 7 is a partial perspective view of the portion of strap with the loop as fastened by the stapling machine.

Figure 8 is a view similar to Figure 7 showing both loops in their finished position.

Figure 9 is a perspective view of the complete strap less buckle.

Figure 10 is a cross sectional view on an enlarged scale taken on line 10—10 of Figure 8.

Briefly, in the practice of my invention, I start with a relatively thin ribbon of leather or the like and fold it longitudinally to form three plies and secure the folds in position by a substantially central row of stitching. The loop material may then be cut up into lengths requisite for individual loops. I then apply the loop material by passing through the loop space in the strap and staple the two ends of the loop together in substantially abutting relation and then rotate the loop to pass the joints and staple into the loop space in the strap where it is concealed from view.

Referring more particularly to the drawing, I have shown in Figure 1 a portion of a sewing machine table at 10, the material being indicated at 11 and the thread at 12. 13 is a standard folding attachment for a sewing machine which will not be described in detail since it forms no part of my invention. Suffice it to say that the member 13 is attached to the machine in the same manner as any attachment and is provided with a hole 14 through which the needle operates. The portion generally indicated at 15 comprises an entrance portion 16 into which a ribbon 17 of leather or the like is fed and which is so constructed in its interior that the material issuing from the end 18 is folded as is shown in cross section in Figure 2. As the material passes through the member 15 it is stitched in a substantially central line, the line of stitching being indicated at 19.

The finished loop material which I have described as 20 may be wound upon a bobbin 21[a] in any desired manner to provide long lengths of loop material.

The conventional wrist watch strap consists of two pieces, one of which is adapted to be attached to one bail of the watch and to carry at its other end a buckle and the other piece of which is adapted to be attached to the other bail of the watch and to have a series of tongue holes adjacent its other end for cooperation with the buckle. These pieces I have indicated generally at 21 and 22 in Figure 9. The member 21 is shown in detail in Figure 4, and as will be clear, it consists of a relatively thin ribbon of leather or the like folded upon itself to form substantially two thicknesses which thicknesses are fastened together by a row of stitching 23 and rows of stitching at 24 and 25. There are, thus, provided spaces 26 and 27 for the acceptance of strap loops or keepers.

As indicated above, the loop material is wound upon a bobbin in long lengths. These lengths of material may be cut into pieces of appropriate lengths to form individual loops. These indi-

vidual pieces are applied to the strap as shown in Figures 5, 6, 7 and 8.

The piece of loop material is passed through one of the spaces 26 or 27 as shown in Figure 5. The ends 29*a* and 29*b* are folded upwardly and toward each other over the anvil 28 of a stapling machine indicated generally at 29. It will be clear that the anvil 28 will be substantially of the size of the strap and that the loop material is cut to a length so that when positioned, as shown in Figure 6, the ends 29*a* and 29*b* will be in substantially abutting relation. They may be held in this position by the fingers and upon actuation of the stapling machine, a staple 30 will be driven into the loop material to fasten the ends 29*a* and 29*b* together as clearly shown in Figure 7.

Another loop is similarly applied in connection with the space 27 and the loops are then rotated, as it were, to pass the joint portion and the staple into the respective spaces 26 and 27 whereupon the staples are concealed from view and the loops have the appearance shown in Figures 8 and 9. The finished loops are indicated by the numeral 31.

It will be understood that while this invention has been described in connection with wrist watch straps the same would be applicable to belts and indeed, to straps of all kinds and that while the material used has been described as being leather, the same construction would be applicable to other materials such as imitation leathers of all kinds and various fibrous materials and cloths. It will further be understood that while a conventional staple has been shown as the fastening means, that other fastening means could be used in a similar way. Therefore, I do not intend to limit myself in any way except as pointed out in the claims which follow.

Having now fully described my invention what I claim as new and desire to secure by Letters Patent is:

1. The method of making wrist watch straps which includes the steps of providing a strap portion having loop accepting openings, folding a strip of material upon itself to form a triple folded strip, stitching said strip to hold said folds in position, cutting said strip into lengths, passing a length thereof through said loop accepting portion, juxtaposing the ends of said lengths and fastening them together and passing said fastening into said loop accepting portion of said strap.

2. The method of making wrist watch straps which includes the steps of providing a strap portion having loop accepting openings, folding a strip of material upon itself to form a triple folded strip, stitching said strip to hold said folds in position, cutting said strip into lengths, passing a length thereof through said loop accepting portion, juxtaposing the ends of said lengths and stapling them together and passing said staple into said loop accepting portion of said strap.

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