

April 25, 1967

G. G. NICLAS
METHOD FOR THE PRODUCTION OF COSMETIC
STICKS, PARTICULARLY LIPSTICKS

3,315,344

Filed June 5, 1963

2 Sheets-Sheet 1

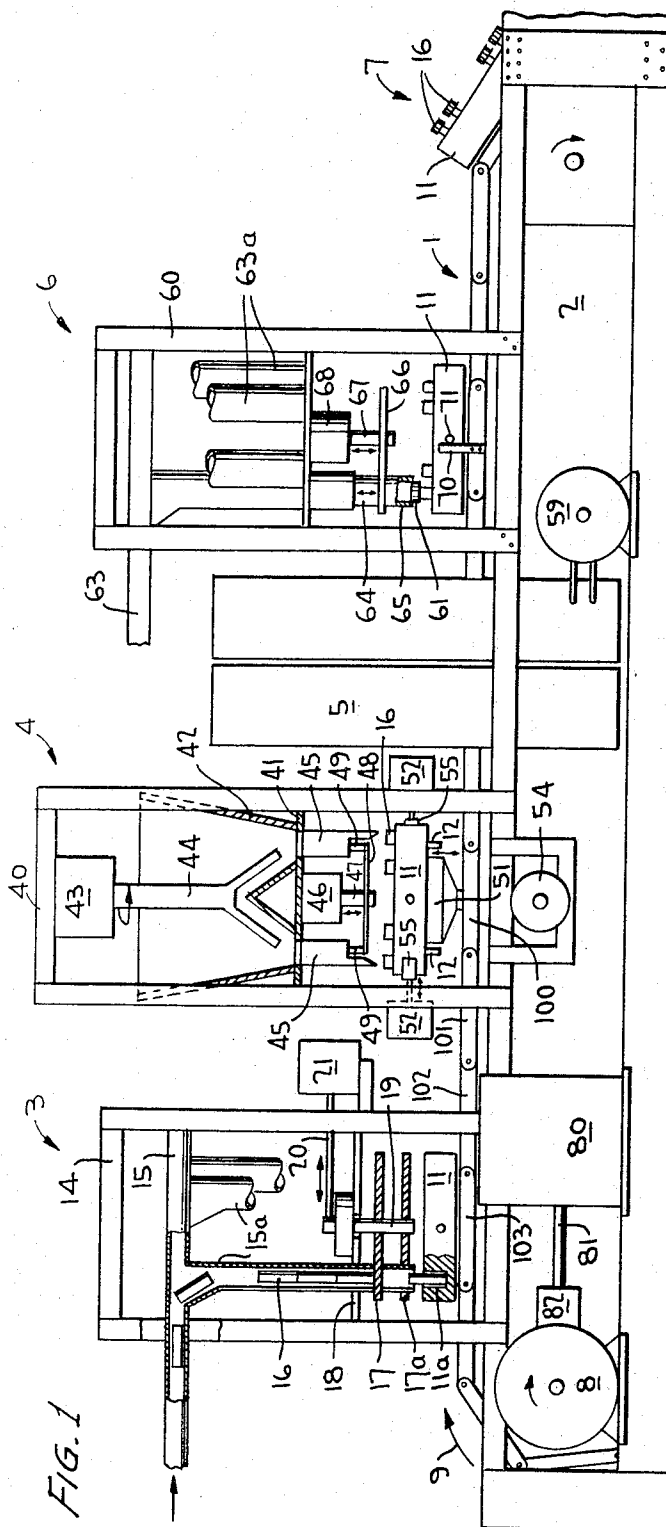


FIG. 1

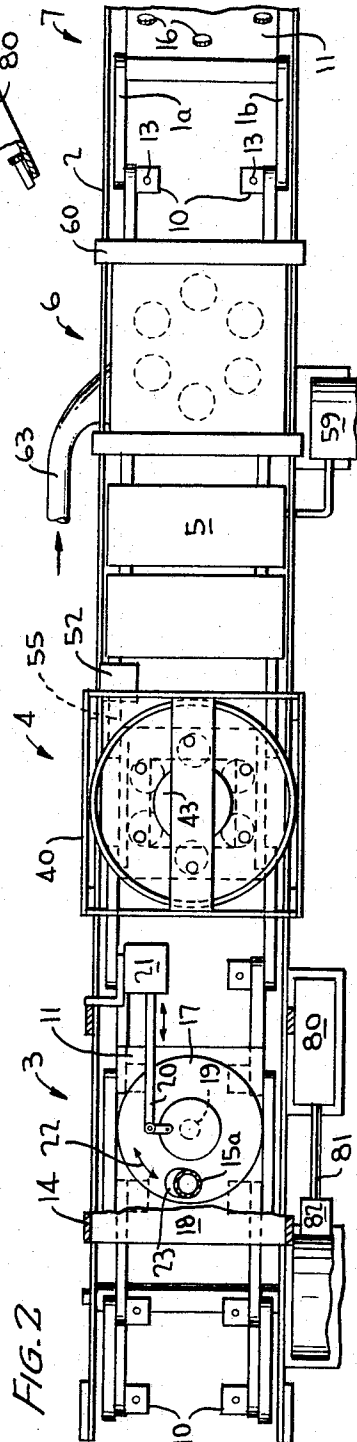


FIG. 2

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2 Sheets-Sheet 2

FIG. 3

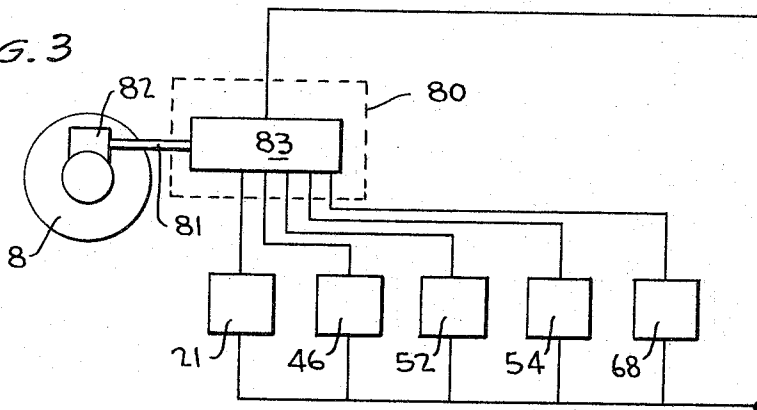


FIG. 5

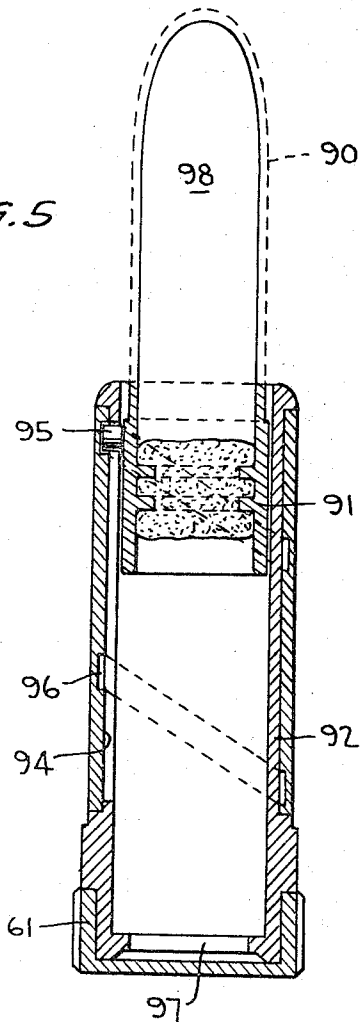
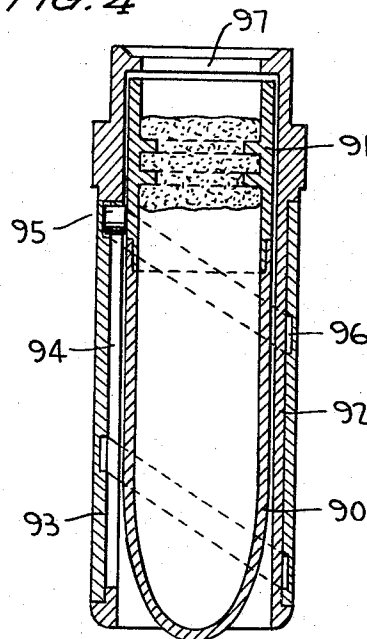


FIG. 4



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1

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METHOD FOR THE PRODUCTION OF COSMETIC STICKS, PARTICULARLY LIPSTICKS

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4 Claims. (Cl. 29—428)

The present invention relates to an improved method for the manufacture of cosmetic pencils or sticks, in particular lipsticks, wherein the paste stick is poured from a mass which is in the condition of a fluid or flowable melt and is surrounded by a casing serving as a packing.

Lipsticks are decidedly mass produced articles, the production of which must take place in the most rational manner possible. Additionally, the manner of use of such cosmetic sticks requires a careful hygienic handling thereof during production, wherefore a contacting of the paste sticks after completion of the pouring operation, for instance during packaging must be prevented.

The method of the present invention fulfills these requirements in that, the paste in the form of a melt or fluid mass is poured from the open end of the lipstick casing into a two-piece paste-receiving mold or receptacle surrounded by the lipstick casing, wherein one part of such two-piece mold or receptacle forms a portion of the aforesaid lipstick casing. In a preferred embodiment for performing the inventive method, in order to pour the paste sticks the lipstick casings containing the pouring molds or receptacles are handled on a conveyor belt, wherein container means adapted to receive a number of lipstick casings and operatively associated with the conveyor belt are fed to a first station for loading of the container means with a number of such lipstick casings. The container means together with the lipstick casings are then successively fed to a second station for pouring of the melt or fluid mass, a third station for cooling the melt, a fourth station for closing the infeed opening of the casings, and a fifth station for removing the casings from the receiving-containers. Due to the performance of this method it is now possible to produce lipsticks in a rational manner, whereby due to the pouring of the paste melt into the individual paste-receiving molds or receptacles which are already surrounded by the casing serving as the lipstick cartridge or packing, there is effectively prevented contact with the paste sticks.

Additionally, the present invention also pertains to an apparatus for executing the inventive method which is manifested in that, there is provided a continuously drivable conveyor means such as a conveyor belt or band which supports a number of receiving-containers for the lipstick casings, transporting such casings containing the paste-receiving molds or receptacles to a pouring device for filling the receptacles or molds with paste. The receiving-containers are releasably connected with the conveyor belt through the agency of holding or retaining means, while there is further provided, at least at the pouring station or device, a support mechanism for the receiving-containers mounted to be stationary with respect to the direction of movement of the conveyor belt which upon release of the receiving-containers from the conveyor belt influences a bringing into a state of rest or standstill the aforesaid receiving-containers during the pouring operation. The invention also has reference to a lipstick or the like manufactured in accordance with the aforescribed method.

Accordingly, it is an important object of the present invention to provide an improved method for the manufacture of cosmetic pencils or sticks in an extremely rational and economical manner, being extremely hygienic

2

in that the cosmetic paste is not handled during production.

Another important object of the present invention is the provision of an improved method for the production of cosmetic sticks, particularly lipsticks, permitting fabrication of the lipsticks in an automatic manner, without requiring manual handling during production.

A further important object of the present invention is to provide for an improved method for the production of cosmetic applicators, particularly lipsticks, wherein the paste may be poured into a paste-receiving mold or receptacle already surrounded prior to paste pouring by a casing serving as the lipstick cartridge or packing, so that it therefore is not necessary to contact the paste or its receiving-mold before, during and after pouring.

Yet a further important object of the subject invention is to provide an improved method enabling production of lipsticks in an extremely hygienic manner, particularly permitting pouring of the paste into the lipstick proper without requiring contact with the paste.

Still another important object of the present invention is the provision of an improved method for the production of lipsticks or the like, wherein there is provided a two-piece paste-receiving receptacle or mold, one part of which forms a portion of the lipstick casing, and the other part of which is detachable from said one part to expose the paste for use, whereby the aforesaid two-piece mold is already surrounded by the lipstick casing prior to pouring, such that the paste mass can be poured directly into the lipstick casing, the inlet opening then sealed, without necessitating contact with the paste during production, resulting in a very hygienic manufacturing technique.

These and still further objects and the entire scope of applicability of the present invention will become apparent from the detailed description given hereinafter; it should be understood, however, that the detailed description and specific example, while indicating a preferred embodiment of the invention, is given by way of illustration only, since various changes and modifications within the spirit and scope of the invention will become apparent to those skilled in the art from this detailed description.

In the drawings:

FIGURE 1 is a side view schematically illustrating details of a complete apparatus for the production of lipsticks in accordance with the teachings of the present invention;

FIGURE 2 is a top plan view of the apparatus depicted in FIGURE 1;

FIGURE 3 is a schematic circuit diagram of a control unit of the apparatus of FIGURE 1;

FIGURE 4 is a cross-sectional view illustrating details of a suitable paste-receiving mold or receptacle of a lipstick adapted to be employed with the apparatus of FIGURE 1; and

FIGURE 5 illustrates in cross-section a lipstick unit manufactured by the apparatus of FIGURE 1.

Referring now to the drawings, and in accordance with FIGURES 1 and 2, it will be recognized that the inventive apparatus for the production of cosmetic pencils or sticks, particularly lipsticks, essentially comprises a main machine frame 2 which supports transport or conveyor means, here illustrated as a conveyor band or belt 1, as well as a number of successively arranged stations operably associated with the machine frame 2 embodying a loading device 3, a pouring device 4, a cooling device 5, a closing device 6 and an emptying device 7.

The conveyor band 1 carried by the machine frame 2 comprises two endless chain strands 1a and 1b spaced at a suitable distance from one another, and adapted to be continuously driven in the direction of the arrow 9 through the intermediary of a suitable drive motor 8. The chain

3

strands 1a and 1b, formed of individual chain links, are provided at the points of interconnection of the individual chain links with inwardly directed, confronting support plates 10, as such for convenience in illustration has only been shown in FIGURE 2 at the two ends of the apparatus. The support plates 10 serve to detachably support containers 11 conveniently provided at their bottom face with pins 12 (see container 11 at station 4 of FIGURE 1) which can be fitted into suitable bores or apertures 13 provided at the support plates 10. Thus, when the containers 11 are positioned on the conveyor band 1, each container 11 extends in the axial direction of said conveyor band and projects at its ends somewhat past the length of an individual chain link, so that each such container 11 rests upon two neighboring support plates 10 provided at each side of the chain strands 1a and 1b. The width of the containers 11 approximately corresponds to the spacing between the two chain strands 1a and 1b of the conveyor band 1.

The containers 11 transported by the conveyor band 1 serve to receive and support sleeve-shaped pouring molds or paste-receiving receptacles already surrounded by a casing serving as the lipstick cartridge or packing, as generally indicated with reference numeral 16, the construction of which will be more fully explained hereinafter. In the illustrated embodiment, all of the containers 11 are designed to simultaneously receive six lipstick casings 16. Naturally, as should be evident, the apparatus could be constructed to handle more or less than six casings. A loading device or mechanism 3 is provided for filling each of the containers 11 with six casings 16. The loading device 3 has a supporting framework or structure 14 connected with the main machine frame 2. The framework 14 supports an infeed guide or conducting channel system 15 serving to supply casings 16 to the receiving-containers 11. For this purpose, and in the described embodiment, the casing infeed system 15 is then naturally, in accordance with the receiving capacity of the individual containers 11, also provided with six casing discharge tubes 15a. However, since all six tubes 15a are identical in structure, and for purposes of providing a clearer illustration of the loading device 3, only one such discharge tube 15a is completely shown in the drawings.

In order to control the operation of the discharge tubes 15a, each of which open at a small distance above the container 11, there are provided two control disks 17 and 17a spaced from one another at a distance corresponding approximately to the length of a casing 16 and operatively connected to one another via a common shaft 19. The control disks 17 and 17a are rotatably mounted through the agency of the shaft 19 on a platform 18 supported by the framework 14. These control disks 17 and 17a are displaceable in the direction of the double-headed arrow 22 (FIGURE 2) by means of a lever system 20 which engages at one end thereof with the shaft 19 for the control disks 17 and 17a, the other end of which is operably associated with actuating means, here shown as an electromagnet 21. The control disks 17, 17a exhibit slot-like openings 23 (only visible on disk 17 of FIG. 2) through which the discharge tubes 15a piercingly extend. Such control disks 17 and 17a close the discharge tubes 15a in such a manner that, in one end or terminal position of said control disk the bottom disk member 17a obviates each outlet opening of the discharge tubes 15a, whereas the upper disk member 17 does not block the respective throughflow passages of said discharge tubes. In this manner, a casing 16 arrives in front of each outlet opening of each discharge tube 15a.

On the other hand, in the other end or terminal position of the control disks 17, 17a, the outlet opening of each discharge tube 15a is freed by the lower control disk 17a, whereas then the upper control disk 17 blocks the throughflow passage of the respective discharge tubes 15a, so that each casing 16 situated between the two control disks 17 and 17a can fall out of its corresponding dis-

4

charge tube 15a, without the following casings 16 arranged in stacked formation in each such discharge tube sliding down. Only after execution of a renewed turning or pivoting of the control disks 17 and 17a does there occur a sliding down of the casings 16, so that in each discharge tube 15a there again arrives a casing in front of the respective outlet opening of the aforesaid discharge tubes, which are then blocked by the lower control disk 17a. The ejected casings 16 then fall into the container 11 which, in the meantime, is positioned beneath the loading device 3, as will be further explained in detail shortly hereinafter.

A pouring device or station 4 is provided for the pouring or filling of the individual casings 16, having a supporting framework 40 connected with the main machine frame 2. A platform 41 is connected with the supporting framework 40, upon which rests a storage funnel or vessel 42 adapted to contain the lipstick paste mass to be poured, which is in a condition of a melt or fluent mass. A stirring member 44 driven by a suitable motor 43 extends into the funnel or storage vessel 42 and ensures for the necessary viscosity of the pourable paste mass. Arranged at the floor of the storage vessel 42 and the underface of the platform 41, respectively, in this illustrated embodiment, there are six dosing and filling valves 45, each dosing valve 45 servicing one of the lipstick casings 16.

The outlet opening of each such dosing valve 45 opens above the container 11 which has previously been positioned at the pouring device 4 in order to partake in the pouring operation, and naturally, each such outlet opening is arranged in alignment with the corresponding lipstick casing 16 to be filled with paste. An electromagnet 46 serves as the common actuating or control means for the dosing valves 45. The electromagnet 46 includes an armature or core 47 which is rigidly connected with an entraining disk 48. Each of the dosing valves 45 is provided with a piston 49 fixedly connected with the entraining disk 48, so that the armature 47 can move up and down together with the entraining disk 48 and pistons 49. In such type dosing and filling valves 45 an upper valve seat of each such valve is opened in one terminal position of the associated piston, so that the pourable paste mass can flow into the interior of the dosing valves, whereby during this terminal position a lower valve seat of each valve is disposed in its closed position and prevents an outflow of the aforesaid pourable mass. Due to the downward movement of the pistons 49, the upper valve seats are closed and the lower valve seats are opened, so that the pourable paste mass located in the respective valve housings can flow out of the latter, such pourable mass moving through the corresponding outlet openings of the dosing valves 45 and arriving at the lipstick casings 16 properly situated beneath such openings. Dosing valves suitable for the purpose of the present invention are well known to the art, and for this reason need not be described in further detail. In my copending United States application Ser. No. 284,894, filed June 3, 1963, for Apparatus for the Dosing and Filling of Molten Masses for the Production of Cosmetic Articles and the Like, I have disclosed and explained details of a dosing and filling valve suitable, by way of example and not limitation, for use in the apparatus of the present invention.

In order to provide for a standstill period of the containers 11 necessary during the pouring operation, there is provided a table or platform 51 which can be raised and lowered, and which can thereby raise and lower the containers 11 away from and onto, respectively, the conveyor band 1. The elevationally adjustable table 51 is mounted to be stationary with respect to the direction of movement of the conveyor band 1. The drive for the table or platform 51 takes place through the agency of a servomotor 54, with there further being provided aligning or centering magnets 52 ensuring for proper

5

positioning and alignment of the containers 11 on the table 51, as will shortly be explained. Upon completion of the pouring operation at the pouring device 4, the filled lipstick casings 16 are conveyed to a cooling device 5 having associated therewith a suitable cooling mechanism 59 providing the necessary temperature to solidify or congeal the paste mass now contained in the paste-receiving molds or receptacles of the casings 16.

For capping or closing the filled lipstick casings 16 there is provided a closure device or station 6 by means of which there can be pressed onto each filled lipstick casing 16 a closure cap 61 or the like. The closure device 6 is arranged at the main machine frame 2 via its supporting framework 60 and supports a guide or conducting channel system 63 for the infed and guiding of closure caps 61, which system is similar to the conducting channel arrangement 15 for the loading mechanism 3, previously described. At this closure device 6 there is likewise provided six discharge tubes 63a, each of which carry at their lower end a plunger or ram 65 movable in the direction of the double-headed arrow 64. These plungers 65 are rigidly connected through the intermediary of an entraining disk 66 with the armature or core 67 of a suitable electromagnet 68 ensuring for collective movement of the plungers 65 at the same time, whereby during downward movement of these plungers the caps 61 are pressed onto the corresponding lipstick casings 16, as will also be explained in further detail hereinafter.

A control mechanism or device 80 is provided for controlling the aforescribed apparatus in dependency of the continuous movement of the conveyor band 1 and is coupled via a mechanical connection 81 with a reduction gearing 82 of the drive motor 8. As best ascertained by referring to FIGURE 3, the control mechanism 80 essentially comprises a contact drum or roller 83, well known in the art, which is coupled into the electric circuit of the actuating magnets 21, 46, 52 and 68 as well as the circuit of the servomotor 54, and controls the aforesaid electromagnets in addition to the servomotor as a function of the movement of the transport or conveyor means.

In operating the aforescribed apparatus, initially the conveyor band 1 is started in motion through a continuous path of movement with the aid of the drive motor 8 and via the reduction gearing 82 (see FIGURE 2). Due to the movement of the conveyor or transport band 1 the containers 11, which have been placed on the aforesaid conveyor band at a predetermined spacing from one another, successively arrive at the individual processing stations 3-7. Initially, one such container 11 is loaded with a number of lipstick casings 16 as soon as it has moved beneath the respective openings of the casing discharge tubes 15a of the loading device 3, in the described embodiment therefore loaded with six casings. For this purpose, the electromagnet 21 receives an impulse or control signal via the control drum 83 allowing this magnet to pull-up, so that the control disks 17, 17a, due to their turning or pivotal movement as aforescribed, render the respective discharge openings of the discharge tubes 15a unobstructed, whereupon the lipstick casings 16 located in front of each such discharge openings can fall into the corresponding receiving-recesses 11a provided at the container 11. As soon as the casings 16 have left the discharge openings of the discharge tubes 15a, the electromagnet 21 as well as the control disks 17 and 17a return into their starting position, so that the other casings 16 in the discharge tubes 15a can slide down and the loading device 3 is then again ready to load the next container 11 with casings.

Due to the continued movement of the casing-loaded container 11 such then arrives in the operating zone of the pouring device 4. Now, as soon as this container 11 is situated above the container-lifting table or platform 51 then the servomotor 54 is actuated, causing the table

6

51 to undergo an upward movement, thereby raising the container 11 from the conveyor band 1. When the table 51 has reached its upper extreme position then the control drum 83 interrupts the current circuit to the servomotor 54 causing such upward movement and closes the circuit of the electromagnets 52. These container aligning magnets 52 with the air of impact angle members 55 (see FIGURE 2) displace and retain the container 11 in a predetermined position deemed necessary for the pouring operation. In this aligned position of the container 11, each of the lipstick casings 16 are located exactly beneath and in alignment with a discharge opening of one of the dosing valves 15.

In consequence of the excitation of the magnet 46 through the agency of the control drum 83 the outlet of each of the dosing valves 45 is now opened, as previously described, whereupon the measured or dosed quantity of the pourable mass of lipstick paste is poured into each of the associated lipstick casings 16. Upon the expiration of a specified pouring time the control drum 83 interrupts the current circuit to the holding or aligning magnets 52 as well as to the valve-electromagnet 46, whereby, on the one hand, the container 11 is freely supported on the table 51 and, on the other hand, the outlets of the dosing valves 45 are closed and their inlet openings are then opened. At the same time the control drum 83 also switches in the servomotor 54 to cause a lowering of the table 51, whereby the previously raised container 11 is again placed upon the continuously moving conveyor band 1 and is entrained by the latter.

In order to impart to the container 11 being lowered a feed movement corresponding to the speed of movement of the conveyor band 1, in order that such container arrives at the prescribed position upon the support plates 10, each of the individual chain links of the chains 1a and 1b of the conveyor band 1 are provided with an entrainment element 70 (only one of which is shown in the drawing of FIGURE 1, at station 6), which during lowering movement of the table 51 engages with a stop or nose-piece 71 provided at each side wall of the container 11, to displace such container along the table 51 in the normal direction of movement of the conveyor band 1. In this manner there is achieved the result that, the container 11 during its lowering movement arrives at the exact position necessary for further transport by the conveyor band 1, so that the pins 12 can engage in the openings or bores 13 of the support plates 10.

If the table 51 has reached its lower end position, then the control drum 83 interrupts the current circuit necessary for the lowering movement of the servomotor 54. The time for the pouring operation, that is, the time span from the raising of the container 11 from the conveyor band 1 until such container is again seated upon the conveyor band, is so calculated that in the meantime the conveyor band 1 has advanced the length of one chain link. In other words, if the container 11 is raised from the chain link 100 of the conveyor band 1 (see FIGURE 1), then such container will be set down upon the next subsequent chain link 101. From this it follows that, the subsequent container must be spaced from the container arranged on the chain link 100 a distance corresponding to at least two chain links 101 and 102, in which case such trailing container is positioned on the chain link 103. Naturally, however, it is also possible to extend the time for carrying out the pouring operation, whereby, however, the unit of time must be based upon the movement of a chain link through a distance corresponding to the length of such a link. The subsequently arranged trailing containers 11 are then spaced from one another through a corresponding increased number of chain links.

It is here to be mentioned that it is of course also possible to provide for the containers a container-standstill mechanism which is stationary with respect to the direction of movement of the conveyor band, such as the elevationally adjustable table 51 aforescribed, at the load-

ing device 3 as well as at the closure device 6 which, upon releasing the containers from the conveyor band 1, brings such containers into a stationary state during the loading with casings and during pushing of the closure caps 61 onto the casings 16, respectively. Due to the relatively slow speed of travel of the conveyor band 1 in the illustrated embodiment, it is possible in this case to execute the loading and closing operations during container travel.

The container 11, now with poured or filled lipstick casings 16 and which have been transported further by the conveyor band 1, arrive at the junction of the pouring device 4 in the region of a cooling device 5 which surrounds the conveyor band 1. As previously mentioned, the cooling mechanism 59 of the cooling device 5 ensures for the presence of a predetermined temperature necessary to solidify or congeal the poured mass. Upon leaving the cooling device 5 the container 11 arrives in the operating zone of the capping or closure device 6, through the aid of which the lipsticks are obturated at their paste infeed or inlet openings, as previously described. As soon as the lipstick casings 16 which are carried by the container 11 are located directly beneath the plungers 65 of the closure device 6, then the control drum 83 switches-in the current circuit of the electromagnet 68, whereupon the latter causes a downward movement of the plungers 65 toward the casings 16, each of which plungers then pushes-on a suitable closure cap 61 onto the associated casing. Thereafter, due to interruption of the current circuit by the control drum 83, the magnet 68 returns into its starting position and, therewith, also the plungers 65, into the outlet end of each of the latter a subsequent closure cap can slide down so that the closure device 6 is then once again in "ready" condition for the next closure operation. It is here to be mentioned that, in the infeed opening of the casings 16 can be also closed with a suitable tag or label, or for instance with a small disk or plate, in lieu of the closure caps 61.

After sealing the casings 16 disposed in the container 11 the latter arrives at an emptying station or device 7, at which the casings 16, due to the reverse movement of the conveyor band 1, fall out of the recesses 11a of the container 11 into a receiving channel 80' from which these casings can arrive for instance, at a receptacle or reach a packaging machine.

In FIGURE 4 there is illustrated a casing 16 provided with a sleeve-shaped mold or paste-receiving receptacle or cup adapted to be used for the manufacture of lipsticks by means of the aforescribed apparatus. The actual mold or paste-receiving receptacle or cup comprises a first elongated, stick-like member or part 90 which tapers or constricts at its closed end, as shown. This elongated, substantially bullet-shaped, stick-like part 90 is fitted at its open end onto a second ring-shaped or annular member or part 91. The pouring mold or paste-receiving receptacle or cup formed of these two parts 90 and 91 is surrounded by a sleeve 92 which, in turn, is partially enclosed by a jacket member 93 rotatable about the sleeve 92. In the sleeve 92 there is provided a longitudinal groove 94 through which extends a guide pin 95 rigidly connected with the ring-shaped part 91, which guide pin 95 engages with a helical extending groove 96 provided internally of the jacket 93. In this manner there is formed a paste-feeding mechanism, which permits advancing of the paste-receiving mold part 90 out of the sleeve 92 in the direction of the tapered or constricted end of the pouring mold, upon holding the sleeve 92 and turning the jacket 93. The paste-receiving mold or cup 90, 91, surrounded by the casing 16 formed of the sleeve 92 and jacket 93 is inserted into the container 11 by means of the loading device 3, whereby the open end 97 of the sleeve 92, which during normal use of the lipstick unit is the lower end, now extends upwards and forms the infeed opening for pouring-in of the molten mass. In FIGURE 5 there is illustrated a

lipstick unit which is ready for use, the casing end 97 of which is sealed by means of a cap 61 snugly fitted thereon, in a manner as previously described. In order to use the paste stick 98 consisting of the solidified molten paste mass which has been screwed out of the casing sleeve 92, the elongated bullet-shaped part 90 of the paste-receiving mold, shown in broken lines in FIGURE 5, is lifted from the ring-shaped part 91 connected with the sleeve 92.

As will be appreciated from the foregoing discussion, the pouring of the molten mass into the paste-receiving mold or receptacle surrounded by the casing serving as the lipstick cartridge or packing, already prior to the pouring operation permits a faultless, hygienic further processing of the sticks, since the cosmetic stick can only first then be contacted after rotating the paste stick out of the casing and lifting the part 90 of the paste-receiving mold. Furthermore, the casings containing the paste-receiving molds or receptacles permit a completely automatic further processing on a conveyor belt, as such has been previously described during the description of the inventive apparatus. While in the illustrated embodiment the casing 16 containing the two-piece pouring mold 90, 91 is formed of the sleeve 92 and jacket 93, it would be of course conceivable to only initially provide the sleeve 92 and then sometime after pouring of the paste into the mold 90, 91 surrounded by such sleeve to apply the outer jacket to the cosmetic applicator unit.

While there is shown and described a present preferred embodiment of the invention, it is to be distinctly understood that the invention is not limited thereto but may be otherwise variously embodied and practised within the scope of the following claims.

Having thus described the present invention, what is desired to be secured by United States Letters Patent, is:

1. A method of manufacturing cosmetic pencils or sticks, particularly lipsticks, in which the paste-like cosmetic stick is poured from a paste mass in a molten condition into a two-part paste-receiving mold surrounded by a casing, with a feed mechanism interconnecting said paste-receiving mold with said casing in order to axially displace said paste-receiving mold relative to said casing, comprising the steps of: detachably supporting at least one container for receiving lipstick casings surrounding the two-part mold upon a conveyor means, transporting said container via said conveyor means to a first station, loading the container at the first station with a specified number of said casings surrounding the two-part mold, with the rear end of each casing being open and exposed for filling of said two-part mold within the casing, transporting the container loaded with casings via said container means to a second station, lifting the casing loaded-container at the second station off of said conveyor means, filling the stationary, two-part mold of each casing now supported in the stationary, lifted container means via its open rear end with the molten paste mass at said second station and during such time as said conveyor means is moving, then placing said container with the paste filled two-part mold of each casing again on to said conveyor means, transporting the container loaded with casings filled with the molten paste mass via said conveyor means to a third station, cooling the molten paste mass at the third station to form a solidified paste stick within each casing, transporting the container loaded with casings each of which contain a solidified paste stick via said conveyor means to a fourth station, sealing the open rear end of each casing at the fourth station, and then transporting the container via said conveyor means to a fifth station where such sealed casings are emptied from the container.

2. A method of manufacturing cosmetic pencils or sticks, particularly lipsticks, in which the paste-like cosmetic stick is poured from a paste mass in a molten condition into a two-part paste-receiving mold surrounded

by a casing, with a feed mechanism interconnecting said paste-receiving mold with said casing in order to axially displace said paste-receiving mold relative to said casing, comprising the steps of: detachably supporting at least one container for receiving lipstick casings surrounding the two-part mold upon a conveyor means, transporting said container via said conveyor means to a first station, loading the container at the first station with a specified number of said casings surrounding the two-part mold, with the rear end of each casing being open and exposed for filling of said two-part mold within the casing, transporting the container loaded with casings via said conveyor means to a second station, lifting the casing loaded-container at the second station off of said conveyor means while the latter is moving, filling the stationary, two-part mold of each casing now supported in the stationary, lifted container means via its open rear end with molten paste mass at said second station and during such time as said conveyor means is moving, then placing said container with the paste-filled two-part mold of each casing again on to said conveyor means at a location rearwardly of the original location at which said container was supported upon said conveyor means and with respect to the direction of travel of the latter, transporting the container loaded with casings filled with the molten paste mass via said conveyor means to a third station, cooling the molten paste mass at the third station to form a solidified paste stick within each casing, transporting the container loaded with casings each of which contain a solidified paste stick via said conveyor means to a fourth station, sealing the open rear end of each casing at the fourth station, and then transporting the container via

said conveyor means to a fifth station where such sealed casings are emptied from the container.

3. A method of manufacturing cosmetic pencils or sticks as defined in claim 2, wherein said container for receiving lipstick casings surrounding the two-part mold is supported upon a conveyor means formed of two spaced strands in order to expose the portion of said container intermediate said two spaced strands, and wherein the step of lifting the casing loaded-container off of the conveyor means is undertaken by applying a force to the exposed portion of said container in order to detach such from said conveyor means.

4. A method of manufacturing cosmetic pencils or sticks defined in claim 3, including the further step of fixing the lifted casing loaded-container in a desired position, while it is raised, at said second station.

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