June 2, 1925. 1,540,384

C. BLOOM

MANUFACTURE OF HEADS FOR DOLLS, MANIKINS, ETC

Filed Jan. 28, 1924 2 Sheets-Sheet 1

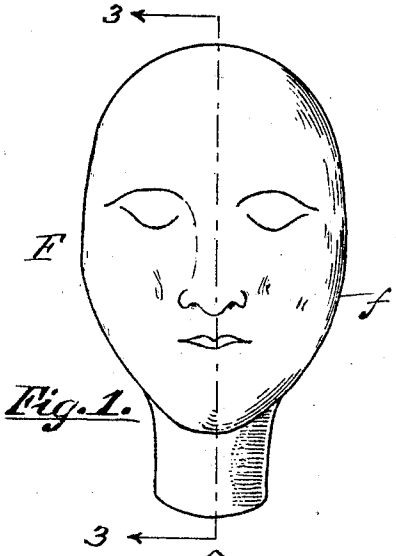


Fig. 1.

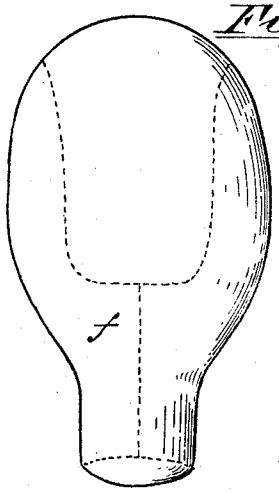


Fig. 2.

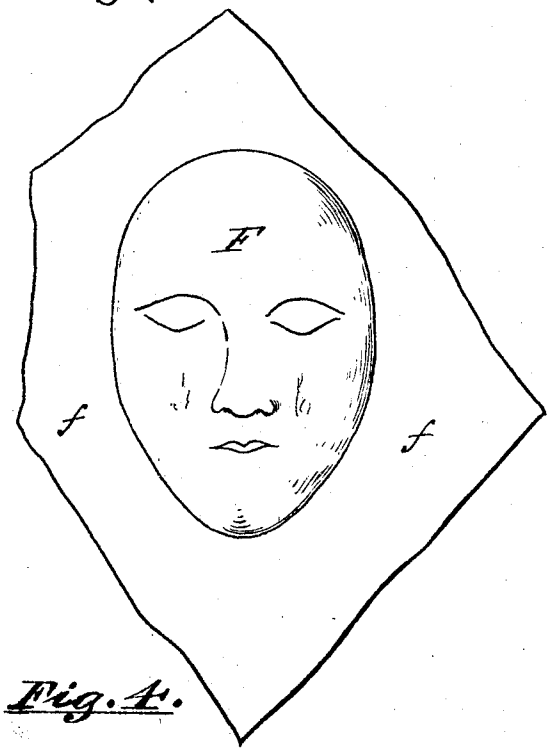


Fig. 4.

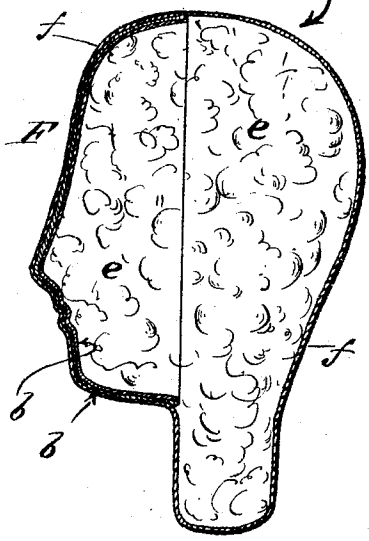


Fig. 3.

Inventor:
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Fig. 5.

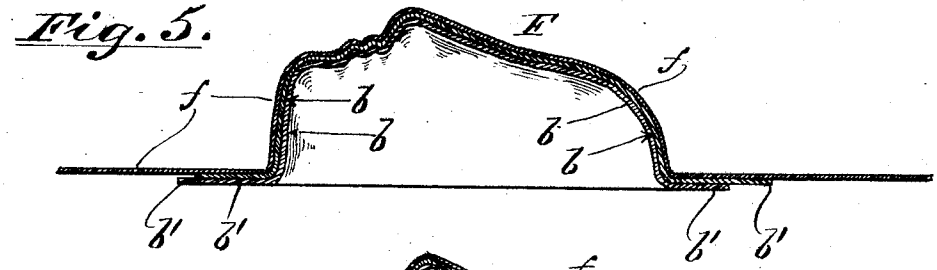


Fig. 6.

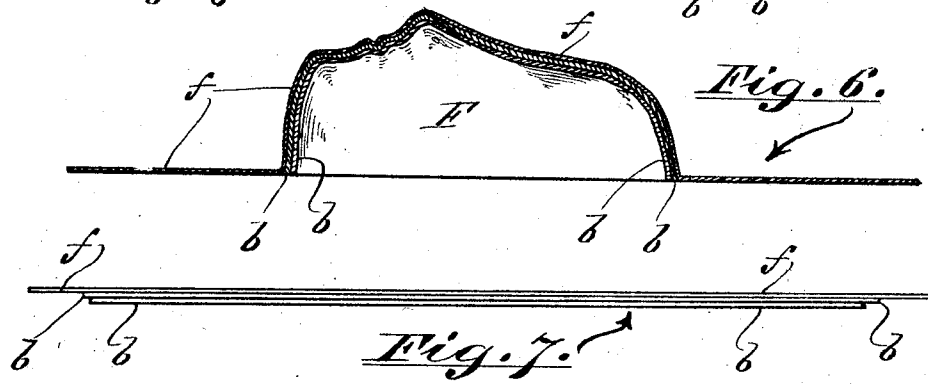
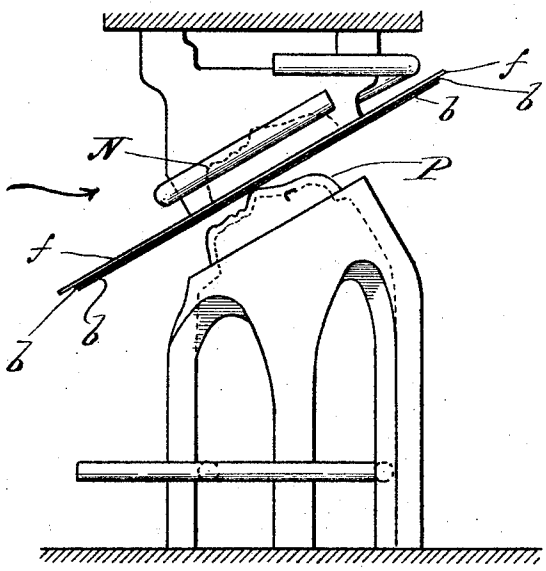


Fig. 7.

Fig. 8.



Inventor:

Charles Bloom

By his Attorneys, Leo. J. Miath

Patented June 2, 1925. 1,540,384

UNITED STATES PATENT OFFICE.

CHARLES BLOOM, OF NEW YORK, N. Y.

MANUFACTURE OF HEADS FOR DOLLS, MANIKINS, ETC.

Application filed January 28, 1924. Serial No. 689,033.

To all whom it may concern:

Be it known that I, CHARLES BLOOM, a citizen of the United States, and a resident of the borough of Manhattan, city, county, and State of New York, have invented certain new and useful Improvements in the Manufacture of Heads for Dolls, Manikins, Etc., of which the following is a specification sufficient to enable those skilled in the art to which the invention appertains to utilize the same.

My invention relates more particularly to the production of the physiognomic portion of a head for a doll, manikin, or the like; and is designed to afford a comparatively inexpensive, simple but effective, substantially rigid concavo-convex plaque adapted to be conveniently combined and incorporated with a suitable back-filling to form the head; and to be painted externally or otherwise marked or embellished according to requirements,—the invention involving the method of manufacture as well as the production, both of which are new in the art, and afford practical advantages not heretofore attained. A distinctive feature of the invention is the production of my physiognomic plaque from a combination of layers of textile material united by a binder superinduced by moisture, heat, and pressure, between suitably shaped convex and concave dies, whereby the portions of the layers subjected thereto are united integrally and solidified to an extent which renders the shape imparted practically permanent for ordinary conditions of use, while at the same time affording a marginally flexible component part adapted to form the sack or covering for the head filling or backing, all as hereinafter fully set forth.

In the accompanying drawings I illustrate a practical embodiment of the essential features of my invention, although I do not limit myself to the identical structure, or means of production shown by way of exemplification, since variations in minor details, and equivalent mechanical expedients, may be resorted to with like result, and without deviating from the spirit and intent of my invention in this respect.

With this understanding:

Fig. 1, is a front view of a doll head made in accordance with my invention;

Fig. 2, is a rear view thereof;

Fig. 3, is a section thereof, taken upon plane of line 3—3 Fig. 1;

Fig. 4, is a view of a face plaque, and surrounding portions of the surface cloth;

Fig. 5, is a central section of the face plaque and adjoining portions of the surface cloth as removed from the formative dies;

Fig. 6, is a similar view thereof after the superfluous edges of the plaque base have been trimmed off;

Fig. 7, is a sectional view of the layers of material as superposed prior to subjection to the action of the formative dies;

Fig. 8, is a view illustrative of the use and function of the formative dies, pressed, etc.

The basic structure of the facial plaque F, consists of woven fabric, preferably of two superposed layers of what is known technically as "two ply" buckram *b*, *b*, with the warp threads of one layer crossing the warp threads of the other layer, which cross, rectangular arrangement of weave I have found not only to give satisfactory results as affording a high degree of tenacity when subjected to the formative die pressure, but also as insuring a durable product of uniform strength, and resistance to change of shape in any and all directions.

Upon the two layers of buckram thus arranged with relation to each other I superpose a layer of textile fabric, such for instance as what is known as cotton sheeting, dye-colored as required, which constitutes the face cloth *f*, and then subject the combination, when moist, to the action of heated formative dies P, and N, the positive die P, being convex in conformity with the facial contour desired, and the movable negative die N, being correspondingly concave.

The buckram as obtained commercially contains starch or other sizing in sufficient quantity to function as a binder and stiffener, so that when in a cool state and when removed from the dies, the resultant mask or facial plaque F, will be self sustaining, and sufficiently stiff and resistant to constitute a permanent physiognomic portion of a head, which is completed by a suitable back filling *e*, of cotton or other appropriate or available material, covered and enclosed by and within the marginal surface cloth *f*, as shown more particularly in Fig. 4, of the drawings,—Fig. 2 thereof indicating a method of trimming and stitching of the marginal face cloth *f*, that may be resorted to for this purpose, although I do not restrict myself in this respect since it is obvious that

like results may be attained by various shape and stitching of the surface cloth.

Furthermore I do not wish to limit myself to the use of buckram for the basic structure of the face plaque F, since other woven fabric may be substituted therefor provided a suitable "binder" is used in connection therewith; and it is obvious that the surface cloth *f*, may consist of suitable fabric other than the cotton sheeting hereinbefore named in this connection.

The die press indicated in Fig. 8, is also symbolic in that any heating and power means may obviously be used in conjunction with the formative dies P, and N, with like results.

After the shaping of the facial base plaque as above set forth the marginal edges *b'*, *b'*, shown in Fig. 5, of the buckram are trimmed off to afford a well defined, uniform edge as indicated in Fig. 6, so that the surface cloth *f*, will not be impaired in appearance, and a smooth, even external configuration and finish will be imparted by the blending and continuity of covered surface that will render the use of the basic plaque inconspicuous.

The surface cloth *f*, may be painted or otherwise marked to accentuate the features, and the head otherwise embellished as may be found expedient, by resort to means well known in the art.

What I claim as my invention and desire to secure by Letters Patent is,—

1. As an article of manufacture, a head of the character designated, comprising a physiognomic portion consisting of a basic plaque of relatively coarse woven fabric, a binder, and a surface cloth, the fabric being in superposed layers with the threads in crossed relation the said physiognomic portion being subjected to moist heat and die pressure the surface cloth being extended beyond the buckram layer to form marginal portions, and the marginal portion of the surface cloth being utilized to cover and adapted to enclose the filling material, substantially in the manner and for the purpose set forth.

2. As an article of manufacture, a head of the character designated, comprising a physiognomic portion consisting of a basic plaque of buckram, and a surface cloth the surface cloth being extended beyond the buckram layer to form marginal portions, the said physiognomic portion being subjected to moisture, heat and die pressure, and the marginal portion of the surface cloth being utilized to cover and adapted to enclose the filling material, substantially in the manner and for the purpose set forth.

3. As an article of manufacture, a head of the character designated, comprising a physiognomic portion consisting of two layers of buckram with the warp crossed as related to each other, and a surface cloth the surface cloth being extended beyond the buckram to form marginal portions, the said physiognomic portion being subjected to moisture, heat and die pressure, and the marginal portion of the surface cloth being utilized to cover and adapted to enclose the filling material, substantially in the manner and for the purpose set forth.

4. The method herein set forth of making heads of the character designated, consisting in forming a physiognomic portion of one or more layers of sized woven fabric and a surface fabric, the marginal portion of the surface fabric being extended beyond the layers of sized woven fabric and subjecting the superposed layers of material to moisture, heat and pressure between formative dies, inserting the filling material, the surface fabric being of sufficient extent to afford marginal portions and then utilizing such marginal portions in the covering of the filling material, substantially in the manner and for the purpose set forth.

5. As an article of manufacture, a physiognomic plaque for heads of the character designated, consisting of layers of sized two ply buckram with the threads thereof crossed, and a surface cloth superposed thereon the marginal portion of the surface cloth being extended beyond the layers of buckram, the parts being integrally united by moisture, heat and die pressure, substantially in the manner and for the purpose set forth.

CHARLES BLOOM.

Witnesses:
SOL KASHIUS,
A. J. KUOMIZ.