July 31, 1956 R. I. PRUPIS 2,756,491

MANUFACTURE OF SLIDERS FOR SLIDE FASTENERS

Filed Sept. 16, 1952 3 Sheets-Sheet 1

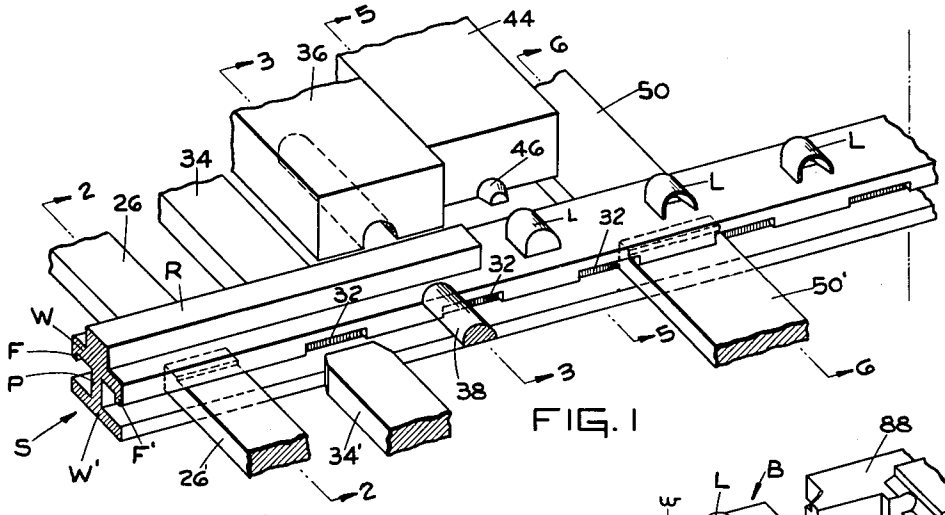


FIG. 1

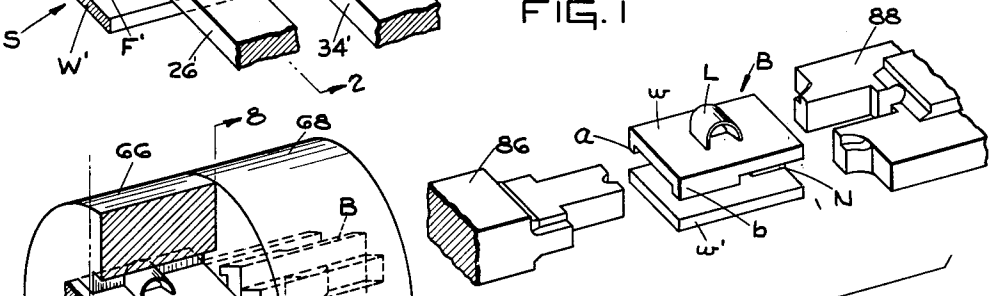


FIG. 1A

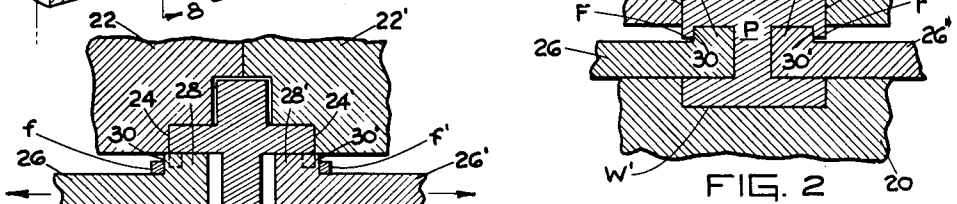


FIG. 2

FIG. 2A

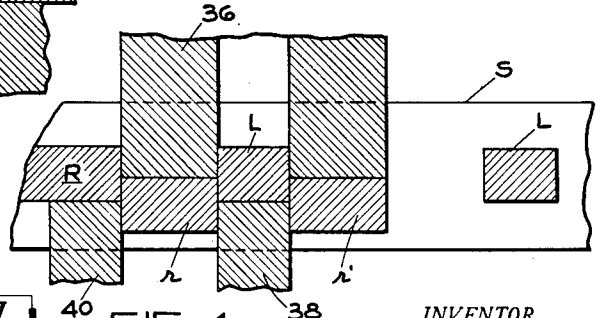


FIG. 4

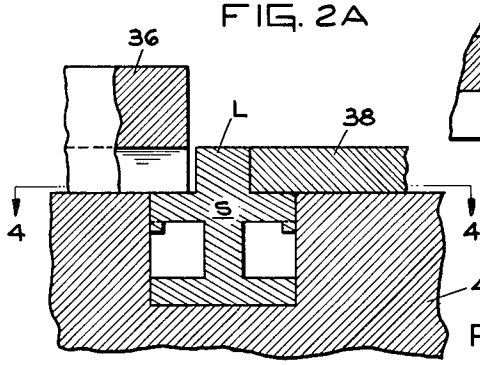


FIG. 3

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MANUFACTURE OF SLIDERS FOR SLIDE FASTENERS

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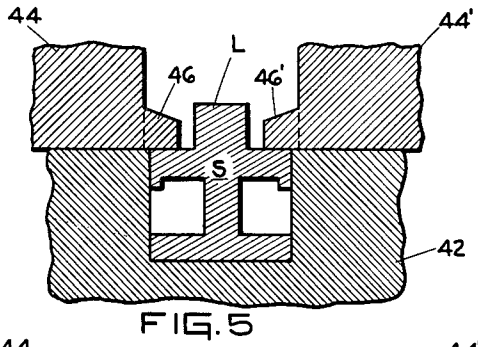


FIG. 5

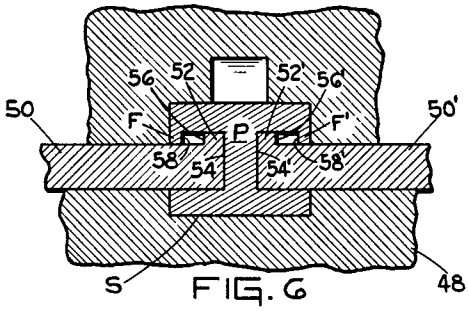


FIG. 6

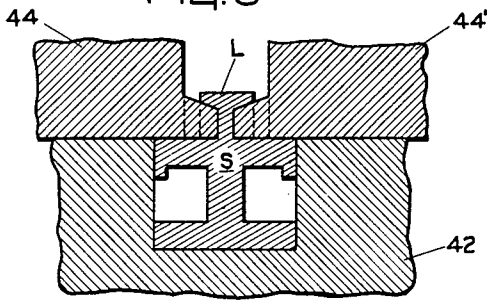


FIG. 5A

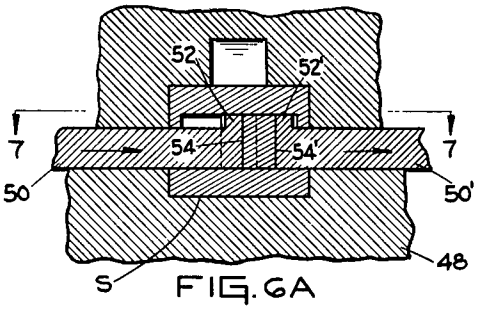


FIG. 6A

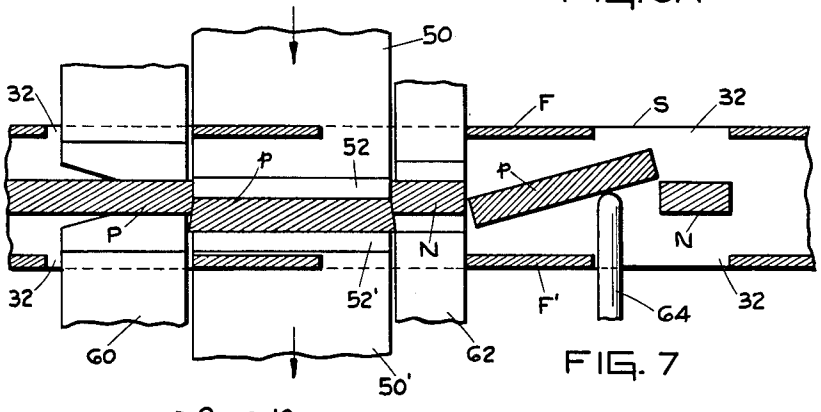


FIG. 7

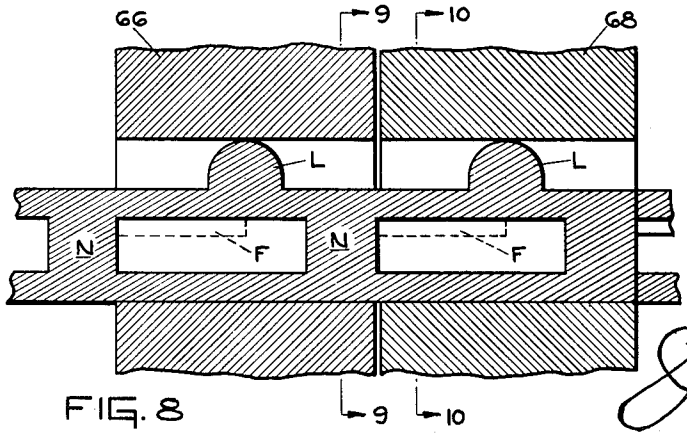


FIG. 8

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MANUFACTURE OF SLIDERS FOR SLIDE FASTENERS

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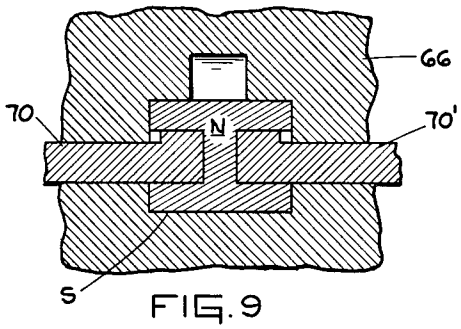


FIG. 9

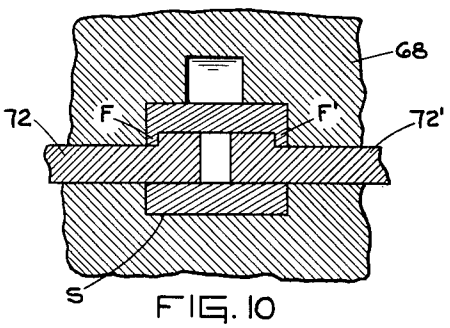


FIG. 10

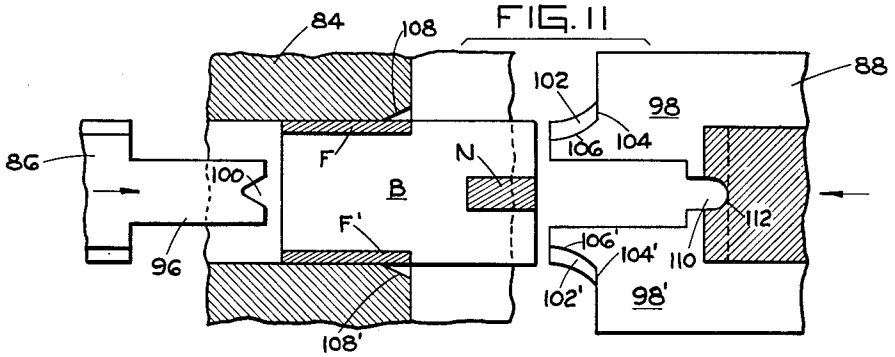


FIG. 11

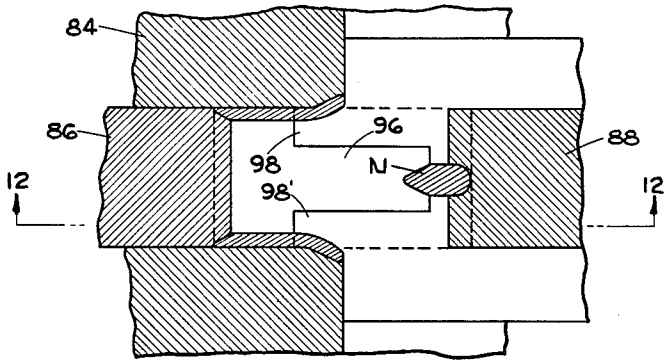


FIG. 11A

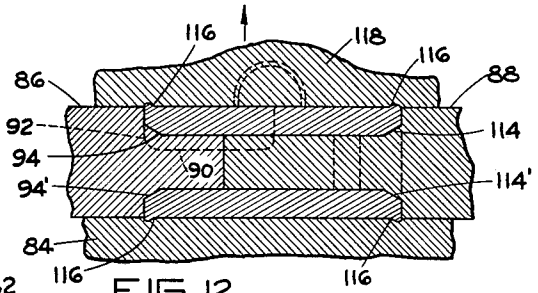


FIG. 12

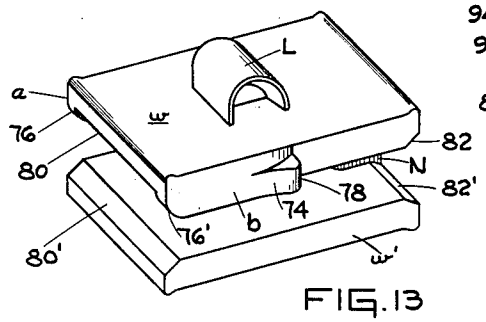


FIG. 13

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2,756,491

MANUFACTURE OF SLIDERS FOR SLIDE FASTENERS

Robert I. Prupis, West Orange, N. J., assignor to Conmar Products Corporation, Newark, N. J., a corporation of New Jersey

Application September 16, 1952, Serial No. 309,754

13 Claims. (Cl. 29—409)

The invention relates to slide fasteners, and more particularly to sliders therefor and their methods of manufacture.

It has been the practice to manufacture sliders by subjecting a flat metal strip of uniform thickness to a series of forming operations to produce the final shape of the slider. In these prior art methods, the side flanges and lug are generally formed by rolling, coining or bending operations. The strip is then blanked and each piece is bent upon itself to bring the two wing portions connected by a neck or post into parallelism at one end. The post portion is further deformed or worked to impart strength to the structure.

The prior art methods briefly referred to above present a number of manufacturing problems, and the finished sliders possess several limitations. Generally, all of the parts of the finished slider must be equal to, or of a thickness smaller than, the thickness of the original strip from which the sliders are formed. Since portions of heavy cross-section are necessary to provide the desired strength at the post portion of the slider, metal stock must be used which is sufficiently thick to provide the strength required at only this small area of the slider. In those regions of the slider where the strength requirements are not as great, the strip must be reduced in thickness, for it is desired to keep the overall bulk of the finished product to a minimum. Thus, the cost of manufacture is greatly increased, because of the added material cost, and the added working of the material engendered by these conflicting objectives.

Another problem encountered in the commonly practiced methods of slider manufacture, resides in the formation of smooth, well-formed, inturned flanges. When the inturned flanges are formed by a coining operation, ragged edges may result which then have to be removed by an additional finishing operation. Otherwise, very expensive dies are required to completely enclose and properly finish those portions of the strip which will provide the inturned flanges.

Still another limitation of the prior art methods of slider manufacture resides in the operation of bending the blank severed from the strip to bring the slider wing portions into parallelism. This is a critical step in the manufacture of sliders, because the channel height within the slider is a critical dimension; the operation requires tools of a high degree of accuracy and is a very costly one.

Further, it has been found desirable to manufacture sliders of a metal such as aluminum, because such material readily lends itself to coloring in great variety of colors, as by anodizing. Aluminum, however, has relatively low tensile strength. It has been found practically impossible to achieve the desired strength at the post area of the slider with known methods of manufacture without unduly increasing the overall size of the slider.

In accordance with the present invention, most of the aforementioned difficulties and limitations are eliminated. Instead of using a flat strip having a thickness

dictated by the strength requirements of only a portion of the slider, the present invention contemplates forming sliders from a preformed blank possessing a contour which may be described as initially providing an embryo of the finished slider. The blank has the material located where it is needed. Thus, the need for a comparatively heavier cross-section at the post portion of the slider than in the main body portions of the wings and the flanges is provided in the blank initially, thereby eliminating wastage of material in those areas where it is not needed. Instead of necessitating complicated forming or bending operations to provide the inturned flanges, smooth flanges of the exact cross-section desired in the finished product are supplied by the embryo slider blank initially. Also, instead of requiring that severed flat blanks be bent to bring the wings into parallelism, such bending operation is eliminated; the parallelism of the wings with respect to each other is assured when the preformed blank is made.

The embryo slider blank is formed initially as a continuous strip, and preferably by extrusion. The blank is provided with spaced parallel wing portions having inturned flanges along the longitudinal edges of at least one of the wing portions. A central longitudinal web which furnishes the post in the finished slider connects the wing portions. Also, a longitudinally extending rib is provided on at least ont of the wing portions to furnish a lug in the finished slider. In the preferred form of the invention, most of the punching and shaping operations to form the flanges, post and lug to final shape are performed upon the blank while it is still in continuous strip form. It is within the scope of the invention, however, to sever from the continuous blank individual blanks having a length substantially equal to the length of the finished slider prior to the punching and shaping operations for forming the flanges, lug and post.

To accomplish the foregoing general objects and such other more particular objects as may hereinafter appear, the invention resides in a novel blank for manufacturing sliders, and the methods for manufacturing sliders from such blanks as are hereinafter more particularly described in the specification and sought to be defined in the claims. The specification is accompanied by drawings, in which:

Figs. 1 and 1A are schematic views, in perspective, showing the novel blank of the present invention and various steps in the method of manufacturing sliders from such blank;

Fig. 2 is a vertical section taken approximately in the plane of line 2—2 of Fig. 1, showing the step of removing portions of the continuous inturned side flanges provided by the blank;

Fig. 2A is a view similar to Fig. 2, but showing the flange-removing punches in a different position;

Fig. 3 is a cross-section, taken approximately in the plane of line 3—3 of Fig. 1, showing a step in the forming of the slider lug;

Fig. 4 is a horizontal cross-section taken approximately in the plane of line 4—4 of Fig. 3;

Fig. 5 is a vertical cross-section, taken approximately in the plane of line 5—5 of Fig. 1, showing the manner in which the lug may be indented;

Fig. 5A is a view similar to Fig. 5, but showing the lug indenting punches in a different position;

Fig. 6 is a vertical cross-section, taken approximately in the plane of line 6—6 of Fig. 1, showing the manner in which the central web of the blank may be sheared to provide the internal channel of the slider and the post portion connecting the wings;

Fig. 6A is a view similar to Fig. 6, but showing the punches in a different position;

Fig. 7 is a horizontal cross-section, taken approximately

in the plane of line 7—7 of Fig. 6A, this view additionally showing the manner in which the portion of the web which is severed from the blank may be removed;

Fig. 8 is a vertical cross-section, taken approximately in the plane of line 8—8 of Fig. 1A, showing the manner in which a continuous strip blank may be severed to provide semi-finished sliders;

Figs. 9 and 10 are vertical cross-sections, taken approximately in the planes of lines 9—9 and 10—10 of Fig. 8;

Fig. 11 is a horizontal cross-section showing the manner in which the post portion of the slider may be finally formed, the post forming members being shown in open position;

Fig. 11A is a view similar to Fig. 11, showing the post forming members in closed position;

Fig. 12 is a vertical cross-section, taken approximately in the plane of line 12—12 of Fig. 11A; and

Fig. 13 is a perspective view of a completed slider made in accordance with the present invention.

Referring to the drawings, and more particularly to Fig. 1, the sliders are made from a blank S which is formed initially as a continuous strip to provide a pair of longitudinally extending wing-providing portions W, W' maintained in parallelism with respect to each other and connected by a central longitudinal web P. The web P provides the post in a finished slider. Either or both of the wing-providing portions W, W' is, or are, provided with oppositely inturned side flanges, F, F', which are continuous and extend longitudinally of the strip blank. Preferably, the inturned flanges are formed on only one of the wing-providing portions, and in the form of the invention illustrated, such inturned flanges are provided on the upper portion W. In order to provide a lug for the finished slider, one of the wing-providing portions has integrally formed therewith, a longitudinally extending continuous rib R. A rib R may be provided on each of the wing-providing portions in the event that a double lug slider is desired. The strip blank S is formed so that the distance between the inner faces of the portions W, W' is equal to the desired height of the slider channel in the finished slider. Also, the blank is formed so that the distance between the inner faces of the flange portions F and F' is equal to the desired width for the closing end of the slider channel in the finished slider.

The strip blank S preferably is formed by extruding a suitable material, such as aluminum, magnesium, etc. Since the blank is preformed to the outline of the finished sliders, the contours and dimensions of the portions which provide the wings, flanges and post in the finished article are initially selected for the purposes and functions which such parts are to serve in the finished product. Thus, the central web P has initially imparted thereto the dimensions to furnish the amount of material desired to give the necessary strength, while the wing and flange portions W, W', F and F' are given the contours and thicknesses desired in the finished sliders. Moreover, it is now possible to make sliders of material, such as aluminum, which may be readily anodized in a variety of colors to meet the demands of the industry for attractiveness and requisite strength, without any undue increase in the size of the product.

In the preferred form of the invention, sliders are produced from the blank S in the following manner, it being understood, however, that the invention is not limited to the preferred sequence of operations about to be described. As shown in Fig. 1, and in greater detail in Figs. 2 and 2A, the blank S, which is continuous strip form, is subjected to a punching operation to remove sections of the continuous, inturned flange portions F and F'. The blank strip is located in a die block 20 with the wing-providing portion W and the rib R enclosed within a stationary die. Preferably, the stationary die is made in two parts 22, 22' to facilitate regrinding of its cutting faces 24, 24'. A pair of shearing punches 26, 26' are located

beneath the flange portions F and F' and are provided with raised portions 28, 28' which substantially fill out the space between the inturned flange portions and the central web. The raised portions 28, 28' of the punches are provided with working or cutting faces 30, 30' for cooperation with the cutting faces 24, 24' provided on the stationary dies 22, 22'. The punches 26, 26' are arranged for movement away from each other, as indicated by the arrows in Fig. 2A. The movement of the punches may be obtained by any well-known means in the art, for example, by the use of cams fastened to the upper plate of the die set cooperating with corresponding cam faces on the outer ends of the punches.

As shown in Fig. 2A, when the punches 26, 26' are moved outwardly, sections *f*, *f'* of the side flanges F and F' are severed or sheared off. The width of the punches is, of course, selected so that the desired lengths of the flange portions required in the finished product remain in the strip. The severed sections *f*, *f'* being sheared outwardly in the punching operation present no problem in removing them from the strip area. The punches 26, 26' are then returned through the apertures or notches 32, as shown in Fig. 1, resulting from the described shearing operation, permitting the strip S to be advanced. The notches are brought in front of a pair of pilots 34, 34' which move into the notches upon the completion of the feeding movement, thereby assuring that the strip is properly located for the preceding as well as the succeeding operations.

The strip blank S may then be subjected to a lug-forming operation, the lug being provided for connection to the pull device, not shown, as is common in the art. As shown in Fig. 1, and more specifically in Figs. 3 and 4, a punch 36 is arranged to cooperate with a pair of stationary die members 38 and 40 to remove sections *r*, *r'* from the continuous rib R, thereby leaving a substantially semi-cylindrical lug L on the top surface of the strip. The strip blank S is seated within a die block 42 in a manner which will expose the rib R only to the action of the punch 36 and the cooperating stationary die members 38 and 40.

To complete the formation of the lug L, the strip blank S is indexed forwardly another pitch where it is indented by suitable tools. As shown in Fig. 1, and more particularly in Figs. 5 and 5A, the strip blank S is located in the extended die block 42 so that only the lug L is exposed. A pair of oppositely disposed indenting punches 44, 44' having semi-frustroconical projections 46, 46' are moved towards each other from the position shown in Fig. 5 to the position shown in Fig. 5A to form oppositely disposed semi-circular flanges beneath which the trunnions of a pull device (not shown) are received. A lug of the described structure is well-known in the art.

The strip blank S is indexed forward another pitch for the initial operation of forming the post and the internal channel of the slider. As shown in Fig. 1, and in greater detail in Figs. 6, 6A and 7, a section of the continuous, central web P is removed from the strip blank S. This is accomplished by seating the strip in a die block 48 in a manner to permit a pair of oppositely disposed punches 50, 50' to reach beneath the portions of the inturned flanges F, F' which still remain in the strip. The punches 50, 50' are provided with raised portions 52, 52' so that the total height of the working faces 54, 54' of the punches is equal to the height of the central connecting web P, or the distance between the wing-providing portions W, W'. A clearance at least equal to half the thickness of the central web P is provided between the outside faces 56, 56' of the raised portions 54, 54', and the inside faces, designated 58, 58', of the flanges F and F'.

As best shown in Fig. 7, a pair of spaced dies 60 and 62 are disposed through the notches 32 and arranged to

cooperate with the punches **50**, **50'**. The motion of the punches is indicated by the arrows in Figs. 6A and 7 so that, as the punch **50** is moved inwardly, it cooperates with the spaced dies **60** and **62** to sever a section or segment *p* from the central web. As the segment *p* is displaced by the punch **50**, the sheared segment bears against the punch **50'**, moving this punch in the same direction as the direction of movement of the punch **50**. The total movement of the punches is limited to the aforementioned clearance provided between punch face **56** and the face **58** of the flange. Actually, a punch penetration of approximately half the thickness of the web P is sufficient to cause separation of the segment *p* from the web. In order to permit further feeding of the strip, the severed section or slug *p* is then realigned back into its original position where it was severed from the central web P. This is accomplished by reversing the punch movement from the position shown in Figs. 6A and 7, to the position shown in Fig. 6. This reverse movement also serves to assure that the segment *p* is severed from the web P. The severed segment *p* can now pass through the die **62** and may be removed from within the confines of the strip S by a push rod **64**, schematically shown in Fig. 7. The push rod passes through a notch **32** on one side of the strip and the segment *p* is ejected through a notch on the other side of the strip. As will be observed from Fig. 7, only a predetermined part N of the originally continuous central web P remains in the blank and represents the material from which the neck or post will finally be formed. Also, by removing the segment *p* from an area in the web P which is substantially opposite to the portions of the flanges F, F' which remain in the blank, the general outline of the internal substantially Y-shaped channel as required in the finished product is formed.

The strip blank S may now be severed transversely into individual blanks by any suitable means. Preferably, this is accomplished by means of a rotary shearing die schematically illustrated in Figs. 1A, 8, 9 and 10. A stationary die **66** is aligned with a rotatable shearing die **68**, the die set being provided with suitable inserts, such as **70**, **70'** and **72**, **72'**, to closely confine the strip S and allow the strip to be fed smoothly through the die. Initially, the stationary and rotary dies **66** and **68** are in alignment. The die **68** is then rotated to shear individual slider blanks B from the strip blank S. The rotary die is then brought back into alignment with the stationary die, whereupon when the strip is fed forward the end thereof acts to push out the severed blank B from the rotary die. The blank B, as best shown in Fig. 1A, now comprises two perfectly parallel wings *w* and *w'* provided with inturned flanges *a* and *b* extending from at least one of the wings, and the wings are connected together at one end by the semi-finished post N. One of the wings is already provided with a lug L. At this stage, the blank B is ready for final forming.

The finished product is shown in Fig. 13, and is provided with appropriate lead-in surfaces to facilitate the free and easy movement of the slide fastener elements through the slider. The flanges *a* and *b* are flared outwardly at **74** and are provided with radii at **76**, **76'** and at **78**. Also, bevels **80**, **80'** and **82**, **82'** are formed on the wings *w* and *w'*. The neck portion N is transformed from a rectangular to a substantially diamond or pear shape (Fig. 11A).

In order to form the blank B into the final finished form, as described, it is placed in a die housing **84** which completely surrounds the blank. As shown in Figs. 11, 11A and 12, a pair of opposed forming punches **86** and **88** are moved together to enter the channel of the blank, to form the post N to final shape, and to form the described bevels and lead-in surfaces. The punch **86** is provided with relieved portions **90**, which, as shown in Fig. 12, rise to curved faces **92** to form the radii **76** and **76'** on the slider's flanges. The punch **86** is provided with chamfers **94**, **94'** to form the bevels **80**, **80'** on the slider wings *w*, *w'* at the closing end of the slider. The punch **86** terminates in a narrow extension **96** which mates between two prongs **98** and **98'** of the punch **88**. The extremity of the extension **96** is provided with a cutout **100** of a shape conforming to the inside contour of the finished post or neck N. The extremities of the punch extensions **98** and **98'** of the punch **88** are relieved at **102** and **102'** in order that these die parts may reach under the flanges *a* and *b*. The relieved portions **102** and **102'** rise to curved faces **104**, **104'** to form the radii **78** of the finished slider. The vertical inside faces, designated **106** and **106'**, flare outwardly to conform with the inside faces of the flared portions **74** in the finished slider. Relieved portions **108**, **108'** conforming to the outside faces of the flared flanges are provided in the die **84**. The space between the two prong portions **98** and **98'** of the punch **88** narrows down at **110** to a width which is slightly greater than the post or neck portion N of the slider blank. The two prongs of the punch meet in a curve **112** which will impart the desired finished contour to the post N. Chamfers **114** and **114'** are provided on the punch **88** to form the bevels **82** and **82'** on the top and bottom wings of the slider adjacent the post. Slightly relieved areas **116** are provided in the die **84** to make room for the metal displaced in bevelling the blank. To facilitate ejection of the finished slider from the die, the die **84** is split, so that the top part thereof, designated **118**, may be opened in the direction of the arrow (Fig. 12) after the described forming operations.

In the sequence of operations hereinbefore described, the continuous form of the blank S was maintained while the punches acted upon the blank to remove sections of the continuous flanges and the continuous rib. While this sequence of operations is preferred, the continuous blank or strip S may be severed to lengths substantially equal to the length of the finished slider, or the length of the blank B as previously described, prior to either the flange-forming operation or the lug-forming operation. In such cases, the severed blanks may be disposed to abut each other as they are fed through a progressive die for subsequent operations, the die blocks being arranged for smooth feeding of the severed blanks to the various stations.

It is believed that the novel construction of the embryo slider blank of my invention, as well as the advantages thereof, whereby sliders of improved characteristics may be manufactured therefrom, will be apparent from the foregoing detailed description. It will also be apparent that while I have shown and described a preferred form of my invention, changes may be made in the slider blank disclosed, and the disclosed methods of manufacturing sliders from such blanks, without departing from the spirit or scope of the invention, as sought to be defined in the following claims.

I claim:

1. The manufacture of sliders for slide fasteners, said sliders being of the type comprising a pair of spaced, parallel wings having inturned flanges and a post connecting said wings at one end thereof to provide an internal channel of substantial Y-shape, which comprises first forming a blank comprising a pair of spaced parallel wing portions, inturned flanges along the longitudinal edges of at least one of said wing portions and a central longitudinal web connecting said wing portions, then removing a section of the connecting web between said wing portions leaving a portion thereof to provide a slider post and thereby also producing an internal slider channel of substantially Y-shape.

2. The manufacture of sliders for slide fasteners, said sliders being of the type comprising a pair of spaced, parallel wings having inturned flanges and a post connecting said wings at one end thereof to provide an internal channel of substantial Y-shape, which comprises

first forming a blank comprising a pair of spaced parallel wing portions, inturned flanges along the longitudinal edges of at least one of said wing portions and a central longitudinal web connecting said wing portions, then removing sections of said flanges, and removing a section of the connecting web over an area substantially opposite the flange portions remaining in the blank leaving a portion of said web to provide a slider post and thereby also producing an internal slider channel of substantially Y-shape.

3. The manufacture of sliders for slide fasteners, said sliders being of the type comprising a pair of spaced, parallel wings having inturned flanges and a post connecting said wings at one end thereof to provide an internal channel of substantial Y-shape, which comprises first forming a blank comprising a pair of spaced parallel wing portions, inturned flanges along the longitudinal edges of at least one of said wing portions and a central longitudinal web connecting said wing portions, then removing a section of the connecting web between said wing portions leaving a portion thereof to provide a slider post and thereby also producing an internal slider channel of substantially Y-shape, and then forming said slider post to final shape.

4. The manufacture of sliders for slide fasteners, said sliders being of the type comprising a pair of spaced, parallel wings having inturned flanges and a post connecting said wings at one end thereof to provide an internal channel of substantial Y-shape, which comprises first forming a blank comprising a pair of spaced, parallel wing portions, inturned flanges along the longitudinal edges of at least one of said wing portions and a central longitudinal web connecting said wing portions, then removing sections of said flanges, removing a section of the connecting web over an area substantially opposite the flange portions remaining in the blank leaving a portion of said web to provide a slider post and thereby also producing an internal slider channel of substantially Y-shape, forming said slider post to final shape, and shaping portions of the wings and flanges to provide lead-in surfaces to facilitate smooth movement of fastener elements through the slider.

5. The manufacture of sliders for slide fasteners, said sliders being of the type comprising a pair of spaced, parallel wings having inturned flanges and a post connecting said wings at one end thereof to provide an internal channel of substantial Y-shape, which comprises first forming a blank comprising a pair of spaced, parallel wing portions, inturned flanges along the longitudinal edges of at least one of said wing portions, a central longitudinal web connecting said wing portions and a central longitudinal rib on at least one of said wing portions, then removing a section of the connecting web between said wing portions leaving a portion thereof to provide a slider post and thereby also producing an internal slider channel of substantially Y-shape, and removing a section of said rib leaving a portion thereof to provide a slider lug.

6. The manufacture of sliders for slide fasteners, said sliders being of the type comprising a pair of spaced, parallel wings having inturned flanges and a post connecting said wings at one end thereof to provide an internal channel of substantial Y-shape, which comprises first forming a blank comprising a pair of spaced, parallel wing portions, inturned flanges along the longitudinal edges of at least one of said wing portions, a central longitudinal web connecting said wing portions and a central longitudinal rib on at least one of said wing portions, then removing sections of said flanges, removing a section of the connecting web over an area substantially opposite the flange portions remaining in the blank leaving a portion of said web to provide a slider post and thereby also producing an internal slider channel of substantially Y-shape, and removing a section of said rib leaving a portion thereof to provide a slider lug.

7. The manufacture of sliders for slide fasteners, said sliders being of the type comprising a pair of spaced, parallel wings having inturned flanges and a post connecting said wings at one end thereof to provide an internal channel of substantial Y-shape, which comprises first forming a blank comprising a pair of spaced, parallel wing portions, inturned flanges along the longitudinal edges of at least one of said wing portions, a central longitudinal web connecting said wing portions and a central longitudinal rib on at least one of said wing portions, then removing a section of the connecting web leaving a portion thereof to provide a slider post and thereby also producing an internal slider channel of substantially Y-shape, removing a section of said rib leaving a portion thereof to provide a slider lug, forming said slider lug to final shape and forming said slider post to final shape.

8. The manufacture of sliders for slide fasteners, said sliders being of the type comprising a pair of spaced, parallel wings having inturned flanges and a post connecting said wings at one end thereof to provide an internal channel of substantial Y-shape, which comprises first forming a blank comprising a pair of spaced, parallel wing portions, inturned flanges along the longitudinal edges of at least one of said wing portions, a central longitudinal web connecting said wing portions, a central longitudinal rib on at least one of said wing portions, then removing sections of said flanges, removing a section of the connecting web over an area substantially opposite the flange portions remaining in the blank leaving a portion of said web to provide a slider post and thereby also producing an internal slider channel of substantially Y-shape, removing a section of said rib leaving a portion thereof to provide a slider lug, forming the slider lug to final shape, forming the slider post to final shape and shaping portions of the wings and flanges to provide lead-in surfaces to facilitate smooth movement of the fastener elements through the slider.

9. A method for making sliders for slide fasteners, said sliders being of the type comprising a pair of spaced, parallel wings having inturned flanges and a post connecting said wings at one end thereof to provide an internal channel of substantially Y-shape, said method comprising providing a continuous strip blank having a pair of spaced, parallel wing portions, at least one of said wing portions being provided with continuous inturned flanges along the longitudinal edges thereof, and a continuous central web connecting said wing portions, the distance between said flanges being substantially equal to the width of the closing end of the internal channel in the finished slider, and the distance between the wing portions being substantially equal to the height of the internal channel in the finished slider, removing sections of said continuous flanges, removing a section of the connecting web at an area substantially opposite the flange portions remaining in the strip to provide a slider post portion and an internal channel of substantially Y-shape, and severing said strip blank to form individual slider blanks each having a length substantially equal to the length of a finished slider.

10. A method for making sliders for slide fasteners, said sliders being of the type comprising a pair of spaced, parallel wings having inturned flanges and a post connecting said wings at one end thereof to provide an internal channel of substantially Y-shape, said method comprising providing a continuous strip blank having a pair of spaced, parallel wing portions, at least one of said wing portions being provided with continuous inturned flanges along the longitudinal edges thereof, a continuous central web connecting said wing portions, and a continuous rib formed integrally with one of said wing portions, the distance between said flanges being substantially equal to the width of the closing end of the internal channel in the finished slider, and the distance between the wing portions being substantially equal to the height of the internal channel in the finished slider, removing sections of said continuous flanges, removing a section of the connecting web at an area substantially opposite the flange portions remaining in the strip to provide a slider post portion and

an internal channel of substantially Y-shape, removing sections of said rib leaving a portion thereof to provide a lug adapted to receive a pull device, and severing said strip to form individual slider blanks each having a length substantially equal to the length of a finished slider.

11. A method for making sliders for slide fasteners, said sliders being of the type comprising a pair of spaced, parallel wings having inturned flanges and a post connecting said wings at one end thereof to provide an internal channel of substantially Y-shape, said method comprising providing a continuous strip blank having a pair of spaced, parallel wing portions, at least one of said wing portions being provided with continuous inturned flanges along the longitudinal edges thereof, and a continuous central web connecting said wing portions, the distance between said flanges being substantially equal to the width of the closing end of the internal channel in the finished slider, and the distance between the wing portions being substantially equal to the height of the internal channel in the finished slider, removing sections of said continuous flanges, removing a section of the connecting web at an area substantially opposite the flange portions remaining in the strip to provide a slider post portion and an internal channel of substantially Y-shape, severing said strip blank to form individual slider blanks each having a length substantially equal to the length of a finished slider, and forming the slider post portion to final shape.

12. A method for making sliders for slide fasteners, said sliders being of the type comprising a pair of spaced, parallel wings having inturned flanges and a post connecting said wings at one end thereof to provide an internal channel of substantially Y-shape, said method comprising extruding a continuous strip blank having a pair of spaced, parallel wing portions, at least one of said wing portions being provided with continuous inturned flanges along the longitudinal edges thereof, and a continuous central web connecting said wing portions, the distance between said flanges being substantially equal to the width of the closing end of the internal channel in the finished slider, and the distance between the wing portions being substantially equal to the height of the internal channel in the finished slider, removing sections of said continuous flanges, removing a section of the connecting web at an area substantially opposite the flange portions remaining in the strip to provide a slider post portion and an internal channel of substantially Y-shape, severing said strip blank to form individual slider blanks each having a length substantially equal to the length of a finished slider, and forming the slider post portion to final shape.

13. A method for making sliders for slide fasteners, said sliders being of the type comprising a pair of spaced, parallel wings having inturned flanges and a post connecting said wings at one end thereof to provide an internal channel of substantially Y-shape, said method comprising extruding a slider strip blank having a pair of spaced, parallel wing portions, at least one of said wing portions being provided with continuous inturned flanges along the longitudinal edges thereof, a continuous central web connecting said wing portions, and a continuous rib formed integrally with one of said wing portions, the distance between said flanges being substantially equal to the width of the closing end of the internal channel in the finished slider, and the distance between the wing portions being substantially equal to the height of the internal channel in the finished slider, removing sections of said continuous flanges, removing a section of the connecting web at an area substantially opposite the flange portions remaining in the strip to provide a slider post portion and an internal channel of substantially Y-shape, removing sections of said rib leaving a portion to provide a lug adapted to receive a pull device, severing said strip blank to form individual slider blanks each having a length substantially equal to the length of a finished slider, forming the slider post portion to final shape, and shaping portions of the wings and flanges to provide appropriate lead-in surfaces to facilitate smooth movement of fastener elements through the slider.

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