March 27, 1945. C. A. OLSEN ET AL 2,372,336

METHOD OF FINISHING EDGES OF LEATHER AND THE LIKE GOODS

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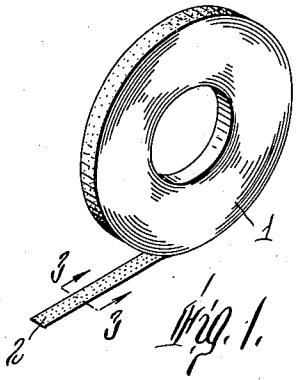


Fig. 1.

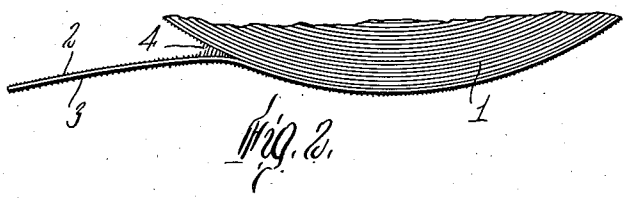


Fig. 2.

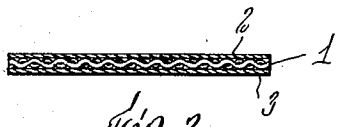


Fig. 3.

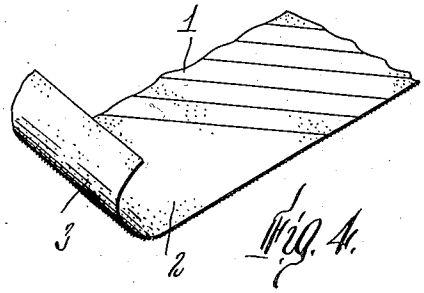


Fig. 4.

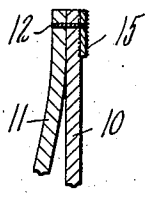


Fig. 5.

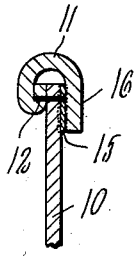


Fig. 6.

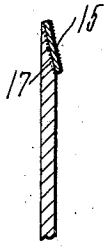


Fig. 7.

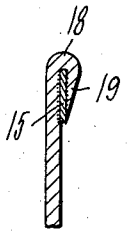


Fig. 8.

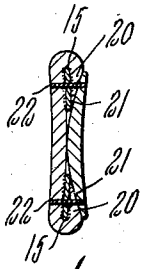


Fig. 9.

Inventors
Carl A. Olsen
Andrew J. Germain
by Wright Brown Quinby & Clay,
Attys.

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METHOD OF FINISHING EDGES OF LEATHER AND THE LIKE GOODS

Carl A. Olsen and Andrew J. Germain,
Haverhill, Mass.

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4 Claims. (Cl. 69—21)

It has heretofore been usual to finish the exposed edges of leather or similar goods, either by applying a finishing beading, commonly known as a French cord, or by folding over the skived margin of the goods so as to present a surface of the leather on the exposed edge.

When applying the French cord, the finishing strip or cord is first stitched to the goods along the margin of the goods, the strip being applied wrong side out to the front face of the goods, extending inwardly from the edge. The free edge of this strip is then brought over to enclose the edge of the goods and the adjacent edge of the strip and the back face portion of this free edge of the strip is cemented against the back face of the goods. Sometimes the cord strip is provided with a pressure sensitive adhesive on its back face to aid in performing the final cementing operation, but should this be exposed to the air for a few hours after the first securement has been effected before the completion of the finishing operation, the pressure sensitive adhesive may have lost much of its tackiness, or it may have taken up sufficient dust, trimmings, foreign material, or the like, so that it does not securely bond when the finishing operation is being completed. Moreover, this pre-coated cord strip is somewhat expensive, resulting in waste when it cannot be fully utilized. Wastage of cord material may be avoided by the use of a separate adhesively coated securing strip, this strip being coated on both sides, but if pressure adhesive cement is employed on both faces, the tackiness of the outer face of the adhesive strip, after the inner face has been secured in position on the goods, is likely to become deteriorated, either during the application of the adhesive strip to the goods, or thereafter, through contact with the air, or by contamination by dirt or other foreign matter, or both. Where the edge is finished by skiving and then folding the skived edge, difficulty is also often experienced in applying the adhesive to the skived edges without the adhesive coming into contact with other parts of the goods where it is objectionable.

In accordance with this invention the difficulties hereinbefore recited are entirely obviated by the use of an adhesive carrying tape, one face of which is coated with pressure sensitive adhesive, while the other face has applied thereto an adhesive which is normally non-tacky but which may be activated when it is desired to secure a portion of the goods thereto.

For a more complete understanding of this invention, reference may be had to the accompanying drawing in which

Figure 1 is a perspective view of a roll of adhesive tape having a pressure sensitive adhesive on one face and a normally non-tacky but readily activated cement on its opposite face.

Figure 2 is a fragmentary side elevation to a larger scale than Figure 1 of the roll of tape showing a portion of the tape partly pulled away from the roll.

Figure 3 is a detail section to a larger scale on line 3—3 of Figure 1.

Figure 4 is a fragmentary perspective view of a fabric showing the manner in which it may be cut to form bias tape suitable for the purpose of this invention.

Figures 5 and 6 are detail sectional views through the edge portions of leather or other suitable goods, showing different stages in application of a French cord thereto for imparting an edge finish.

Figures 7 and 8 are similar sectional views showing the finishing of the edge of the goods by skiving and folding.

Figure 9 is a cross sectional view of a shoe strap or similar article showing the method of edge finishing of Figure 8, but further showing the application of a back finishing strip so that both faces of the article present a finished surface of the material.

Referring first to Figures 1 to 4, a tape which may be of fabric, paper, or other suitable material, is supplied, this tape as shown in Figures 1 and 2 being packed in a roll from which it may be unwound as desired. One face of this tape, such as 2, is provided with an adhesive coating, preferably a pressure sensitive coating, such as is well known in the art. The opposite face is supplied with a coating 3 of a normally non-tacky adhesive such, for example, as thermoplastic adhesive which may be rendered tacky by heating it to above normal room temperature. If the goods whose edges are to be finished have curved edges, it is preferable to employ a bias tape which may be made by cutting diagonally of the weave a fabric strip as shown in Figure 4 into tape sections, and the coatings may be applied before the tape is cut, if desired.

In Figures 5 and 6 the use of such a tape in connection with the finishing of leather goods by a French cord is illustrated. The goods to be finished is shown at 10, the finishing cord being shown at 11. To the flesh face of the goods is progressively secured an adhesive strip or tape 15 unrolled from the coil 1, the pressure sensitive

face being applied to the goods so that adhesion is quickly effected. The exposed rear face of the strip is then in non-tacky condition and may be handled without damage to its tacky qualities when these are brought out by suitable activation. For example, if the rear face coating is a thermoplastic adhesive normally non-tacky at room temperatures, activation may be produced by applying heat thereto.

The French cord 11 is applied to the outer face of the goods as shown in Figure 5 with its outer finished face against the finished face of the goods 10, and is preferably secured thereto and to the strip 15 as by a line of stitching 12. The free inner edge of the strip is then turned up and inwardly to enclose its opposite edge and the exposed edge of the goods, and is brought down and applied in facial contact with the rear face of the strip 15 which may be activated by pressing the parts together with a heated iron. This secures the rear portion 16 of the cord strip in position and completes the finishing operation.

Where it is desired to finish the edge of the goods by skiving and folding, the operation is performed as illustrated in Figures 7 and 8. The flesh face of the goods to be finished adjacent to the edge is skived off as at 17 and to the scarf is applied the tacky face of the tape 15 as shown in Figure 7. This edge portion of the goods is then folded back to bring the normally non-tacky face of the tape 15 against the flesh face of the goods inwardly of the scarf, as shown in Figure 8, where the folded portion is secured by heat and pressure to form the finished edge presenting the grain or finished face of the leather as at 18 over the exposed edge of the goods.

In Figure 9 there is illustrated in cross section a shoe strap in which both edges of the leather are finished by skiving and folding as illustrated in Figures 7 and 8, after which a finishing strip, preferably with skived margins, is applied to the back of the strap with its grain face outwardly exposed, the parts being then stitched together by the lines of stitching 22. With this arrangement substantially all of the exposed surfaces of the strap present the grain surface of the leather.

One of the advantages of employing a thermoplastic cement for the normally non-tacky surface is that it is easy to activate it at the same time that the parts are being pressed together for adhesion, it being only necessary to apply moderate heat when the parts are so pressed, a heated pressing iron being used to apply both heat and pressure.

Another advantage is illustrated in Figure 2, the pressure sensitive cement adhering sufficiently to the thermoplastic cement in the roll so that when the tape is peeled off from the roll, the surface of the pressure sensitive cement is somewhat disturbed as at 4 (see Figure 2), increasing its tackiness, so that it is conditioned for application to the goods immediately and its surface not glazed or dried out by exposure to the atmosphere.

A normally non-tacky cement activated by other than heat is, however, within the general scope of this invention. For example, an activating liquid may be used, if desired, such as moisture applied to a soluble gum or any solvent for an adhesive which may be rendered tacky by such solvent. In general, however, it is preferred to use a thermoplastic adhesive since this requires no liquid of any sort, which might damage other portions of the article if applied thereto, and it is easier and cleaner to handle.

From the foregoing description of certain embodiments of this invention, it should be evident to those skilled in the art that various changes and modifications might be made without departing from the spirit or scope of this invention.

We claim:

1. The method of finishing the edge of goods, which comprises applying to one face of such goods adjacent to such edge the tacky face of a tape provided with a normally tacky face and a normally non-tacky coating on its opposite face, and thereafter turning over a finishing portion of the goods into facial contact with said normally non-tacky tape face and applying pressure thereto while said normally non-tacky face is activated to render it tacky.

2. The method of finishing the edge of goods, which comprises applying to one face of such goods adjacent to such edge the pressure sensitive adhesive face of a pressure sensitive adhesive coated tape coated on the opposite face with a normally non-tacky thermoplastic adhesive, and then folding over such edge and pressing it against said thermoplastic coating while said coating is activated by heat.

3. The method of finishing the edge of leather goods with French cord, which comprises sticking to the back face of the goods along said edge a tape having a normally non-tacky exposed rear face, securing the outer edge of a French cord tape along the outer face of the goods adjacent to said edge, and then turning the free edge of said cord tape over the other edge of said tape and the edge of the goods and into facial contact with said normally non-tacky face and pressing it into contact with said normally non-tacky face while said normally non-tacky face is activated to render it tacky.

4. The method of finishing the edge of leather goods, which comprises skiving the marginal portion of such goods on the flesh side, adhesively securing to the skived face once face of a tape having its opposite face coated with a normally non-tacky adhesive, and then folding back said skived portion and bringing the normally non-tacky face of said tape against the flesh side of the goods inwardly of the scarf and pressing the goods and tape together while said normally non-tacky face is activated to render it tacky.

CARL A. OLSEN.
ANDREW J. GERMAIN.