Feb. 15, 1938. H. F. REICHENBACH 2,108,512

METHOD OF PRODUCING PARTS FOR LIPSTICKS AND THE LIKE

Filed July 19, 1935

Fig. 1.

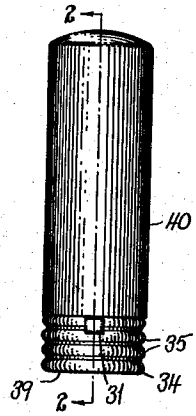


Fig. 2.

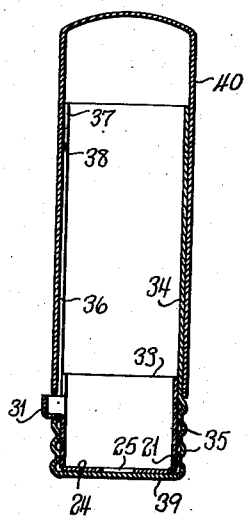


Fig. 3.

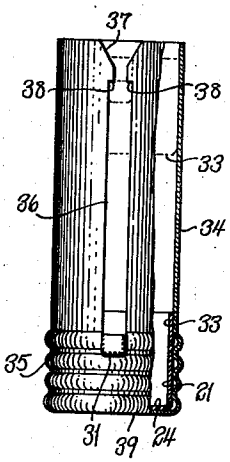


Fig. 4.

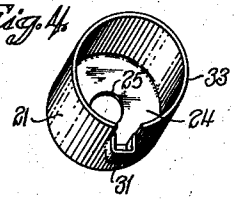


Fig. 5.

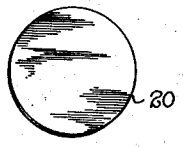


Fig. 6.

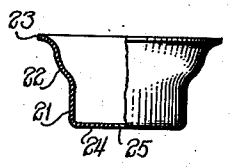


Fig. 9.

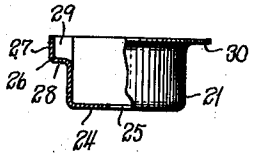


Fig. 7.

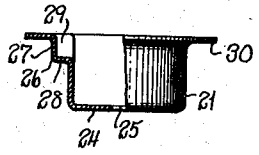


Fig. 10.

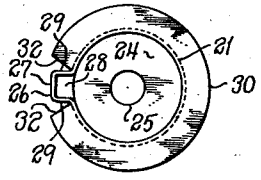
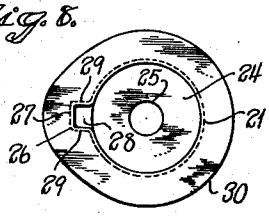


Fig. 8.



Inventor
Howard F. Reichenbach
by Seymour Earle Nichols
Atty.

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METHOD OF PRODUCING PARTS FOR LIPSTICKS AND THE LIKE

Howard F. Reichenbach, Waterbury, Conn., assignor to The Chase Companies, Incorporated, Waterbury, Conn., a corporation

Application July 19, 1935, Serial No. 32,215

4 Claims. (Cl. 113—116)

The present invention relates to an improvement in methods for producing parts for lipstick-holders and the like and relates in particular to the production of the so-called "elevator-" or carrier-members for such holders.

One of the objects of the present invention is to provide a superior method for producing cup-like carrier-members for adjustable lipsticks and the like.

A further object is to provide a superior method whereby carriers of the class referred to may be rapidly and economically produced and provided with operating projections intermediate their respective upper and lower ends.

With the above and other objects in view, as will appear to those skilled in the art from the following, considered in conjunction with the accompanying drawing and appended claims, the present invention includes all features disclosed therein which are novel over the prior art.

In the accompanying drawing:

Fig. 1 is a view in side elevation of one form of lipstick having an elevator or carrier produced in accordance with the present invention;

Fig. 2 is a longitudinal sectional view thereof taken on the line 2—2 of Fig. 1;

Fig. 3 is a view mainly in side elevation and partly in section of the lipstick-holder with the cover-member removed;

Fig. 4 is a perspective view of the carrier- or elevator-member;

Fig. 5 is a perspective view of a blank from which the carrier-member may be produced;

Fig. 6 is a view partly in side elevation and partly in transverse section of a partly-drawn blank;

Fig. 7 is a similar view of the blank after the same has been subjected to a further forming operation;

Fig. 8 is a top or plan view of the partly-formed blank of Fig. 7;

Fig. 9 is a view partly in side elevation and partly in transverse section after the blank has been subjected to a still further operation; and

Fig. 10 is a top or plan view of the unit shown in Fig. 9.

One mode of practicing the present method comprises drawing a disk-like blank 20 (Fig. 5) into the form shown in Fig. 6, in which the partially-drawn blank includes a tubular wall-portion 21 and an annular flared wall-portion 22 terminating in a laterally-extending flange 23. The partially-formed blank also includes a bottom wall 24 having, if desired, a central perforation 25.

The partially-formed blank of Fig. 6 may now be subjected to a further drawing or forming operation, whereby the metal of the flared wall-portion 22 is largely deflected into a boss-like lateral projection generally designated by the numeral 26 and including an outer wall 27, a bottom wall 28 and complementary side-walls 29—29. In the operation of forming the boss-like projection 26, part of such metal of the blank as is not deflected to form the said boss is drawn to add to the length of the tubular wall 21 and to increase the face width of the flange 23 of Fig. 6 into the wider flange 30 of Figs. 7 and 8. The boss-like projection 26 as thus formed opens inwardly into the hollow interior of the blank and also opens upwardly through the face of the said flange 30.

The partly-formed blank of Figs. 7 and 8 may now be cut to even up the periphery of its flange 30 and to remove the metal of the said flange 30 from connection with the upper terminal of the boss 26, thus converting the said hollow boss 26 before referred to into the hollow operating-projection or nib 31 of Figs. 1 to 4 inclusive. The cutting-away operation just referred to results in providing the now trimmed-and-sized flange 30 with opposed radial terminal edges 32—32, as illustrated particularly well in Fig. 10.

The nearly-completed blank of Figs. 9 and 10 may now be subjected to a drawing or other forming operation by means of which the laterally-extending flange 30 is drawn upwardly to provide a continuation of the tubular portion 21, which latter, by the operation just referred to, is now caused to extend above the upper edge of the said hollow nib 31, as illustrated particularly well in Fig. 4.

It will thus be seen that by the process just described a completed carrier or elevator 33 of cup-shaped form is produced having the upper edge of its hollow operating-projection or nib 31 located below the upper edge of the body-portion of the carrier or elevator proper.

The carrier or elevator 33 may be utilized in a variety of adjustable holders for lipsticks or other material, such, for instance, as the holder illustrated in Figs. 1 to 3 inclusive, which includes a relatively-deep cup-shaped body-member 34 having a series of annular beads 35 formed around its lower portion and provided with a longitudinal slot 36 extending at its lower end partway into the annular beads 35 of the said body-member and being flared at its upper end as at 37

and intersecting the upper edge of the said body-member.

Adjacent its upper end, the slot 36 of the body-member 34 is shaped to provide a pair of stop-shoulders 38—38 which serves to engage the upper edge of the operating-nib 31 of the carrier 33 to thus limit the upward travel of the said carrier. When the carrier 33 is moved upwardly sufficiently to engage the upper edge of its operating-nib or boss 31 with the stop-shoulders 38—38 of the body-member 34, it will be noted that the upper edge of the said carrier proper is substantially flush with the upper edge of the said body-member 34, as indicated by broken lines in Fig. 3.

When the carrier 33 rests upon the bottom wall 39 of the body-member 34, it will be noted that the upper edge of the nib 31 is in substantial alignment with the uppermost one of the beads 35, and when a cup-shaped cover or cap 40 is sleeved over the upper portion of the said body-member 34 to engage its lower edge with the uppermost one of the beads 35, the nib or boss 31 of the carrier 33 will lie at or below the lower edge of the said cap or cover 40.

Should the nature of the material from which the elevator or carrier is formed be of such character as to require annealing between operations, such annealing may be accomplished by means of methods usual in the art.

The invention may be carried out in other specific ways than that herein set forth without departing from the spirit and essential characteristics of the invention, and the present embodiment is, therefore, to be considered in all respects as illustrative and not restrictive, and all changes coming within the meaning and equivalency range of the appended claims are intended to be embraced therein.

I claim:

1. A process for producing a cup-shaped carrier member of the class described having an integral hollow boss laterally offsetting from its side wall at a point intermediate its outer and inner ends comprising: shaping a blank to a form which includes a cup-like portion, a flange laterally-offsetting from the outer end of the said cup-like portion and a laterally offsetting hollow boss adjoining both the said flange and the said cup-like portion; and subsequently deflecting the said laterally-extending flange into subsequent parallelism with the axis of the member and beyond the outer edge of the said boss to form a continuation of the said cup-like portion.

2. A process for producing a cup-shaped carrier member of the class described having an integral hollow boss laterally offsetting from its side wall at a point intermediate its outer and inner ends comprising: shaping a blank to a form which includes a cup-like portion, a flange laterally-offsetting from the outer end of the said cup-like portion, and a laterally offsetting hollow boss adjoining both the said flange and the said cup-like portion; cutting away the material of the said flange adjacent the upper edge of the said boss; and deflecting the said laterally-extending flange into substantial parallelism with the axis of the member and beyond the outer edge of the said boss to form a continuation of the said cup-like portion.

3. A process for producing a cup-shaped carrier member of the class described having an integral hollow boss laterally offsetting from its side wall at a point intermediate its outer and inner ends comprising: forming a cup-shaped blank having an outwardly-flared portion; upsetting the material of the said flared portion to form a laterally-offsetting integral hollow boss and further shaping the said outwardly-flared portion to produce outwardly-extending flange; and subsequently deflecting the said outwardly-extending flange into substantial parallelism with the axis of the member and beyond the outer edge of the said boss.

4. A process for producing a cup-shaped member of the class described having an integral hollow boss laterally offsetting from its side wall at a point intermediate its outer and inner ends comprising: forming a cup-shaped blank having an outwardly-flared portion; upsetting the material of the said flared portion to form a laterally-extending integral hollow boss; further shaping the said outwardly-flared portion to produce an outwardly-extending flange; removing the metal of the said outwardly-extending flange adjacent the outer edge of the said boss; and deflecting the said outwardly-extending flange into substantial parallelism with the axis of the member and beyond the outer edge of the said boss.

HOWARD F. REICHENBACH.