Nov. 4, 1941. R. J. SMITH 2,261,302

SLIDE FASTENER KEY

Filed Dec. 30, 1938

Fig. 1.

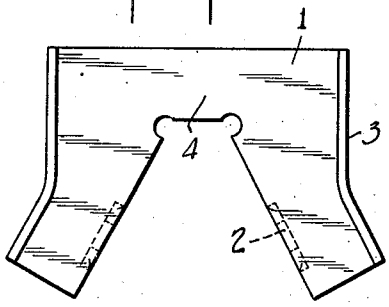


Fig. 2.

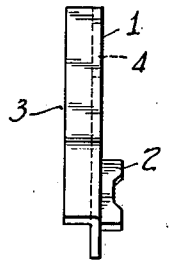


Fig. 4.

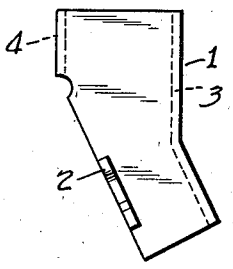


Fig. 3.

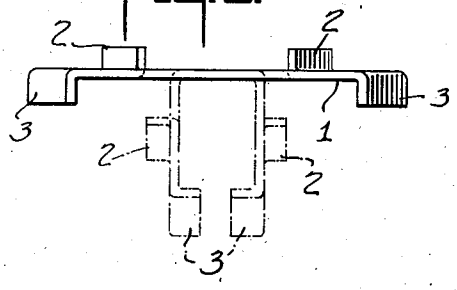


Fig. 5.

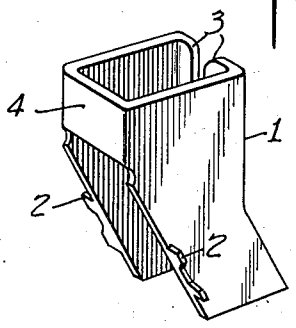


Fig. 6.

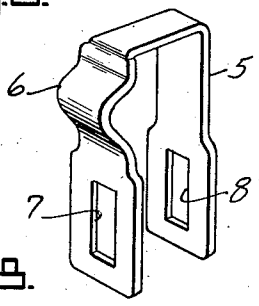


Fig. 7.

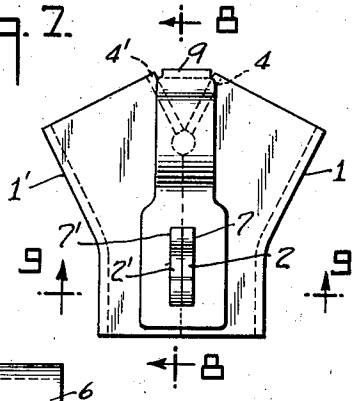
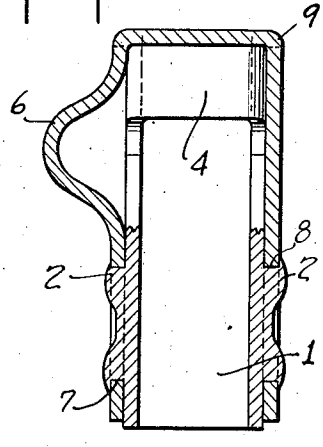


Fig. 8.



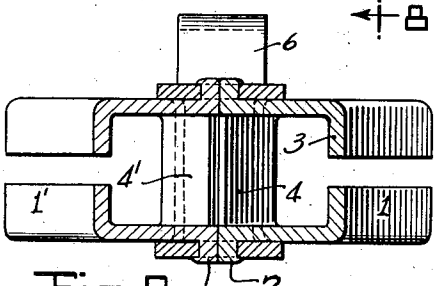


Fig. 9.

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SLIDE FASTENER KEY

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Application December 30, 1938, Serial No. 248,381

4 Claims. (Cl. 29—148)

It is an object of my invention to provide a key or slide fastener closure which will be more positive in operation than present types due to the structure of the key itself and the process or method by which I manufacture and assemble the same. I also provide a key which is less costly to manufacture and which will have less fracture and breakage than present type of keys in this art. The keys now in use with slide fastener are either die cast or more conventionally stamped and coined out of sheets and then bent or folded into final form. This bending occurs at the middle where the smallest amount of metal is available and with resulting tendency to break. My key is characterized by being formed entirely by metal stamping and is so shaped that great strength is obtained. In a conventional punch press process trimming and bending are required and in some cases keys are made by a swedging or coining press process, both of which involve considerable waste of material and metal.

My invention will be more readily understood by reference to the accompanying drawing in which like numbers refer to like parts in the several views.

In Fig. 1 is shown an envelopment in plan of one side of one portion of key stamping.

In Fig. 2 is shown a side elevation of same.

In Fig. 3 is shown an edge view and designates position after folding.

Fig. 4 shows a side elevation after folding.

Fig. 5 shows a perspective view after folding.

Fig. 6 shows a perspective view of the overfolding wicket portion.

Fig. 7 shows a front elevation of two side portions assembled with the wicket to form a finished key.

Figs. 8 shows a sectional elevation of assembly along plane 8—8 of Fig. 7, and

Fig. 9 shows a plan view of assembly along plane 9—9 of Fig. 7.

Referring to the drawing, at 1 is shown the body of one side of the two firming portions of my key having the lugs or protrusions 2, the elevated edge or rim 3 and the center flat section 4. In Fig. 6 is the overfolding wicket 5 having front and rear cut out portions 7 and 8 and a bent or elevated portion 6 adapted to receive a tab or handle (not shown). This wicket 5 fits over the two portions of the key as shown in Figs. 7, 8 and 9 and holds them securely together, the protrusion 2 passing through apertures 7 and 8 and securing the assembly as indicated at 9.

It is now obvious that I may form the portion 1 out of stampings. (The corresponding parts of the corresponding duplicate, side to side body portions are indicated in the drawing by the same numerals but with the indication prime, this 1 corresponds to 1', and so on.) The elements 1 and 1' are bent to provide the form shown in Fig. 5 and thus the key is formed by bending in opposite directions than that of any prior art fastener key. When placed side to side the wicket 5 is placed over the two body portions, as shown in Fig. 7, and the lugs 2—2' are staked so as to make an integral firm assembly having two smooth angular channels to receive the elements or scoops of a slide fastener and operate the same in the best possible manner with catching or jamming eliminated due to absence of burrs and rough edges of a conventional die case or coined fastener key.

Having thus described my invention, what I claim and desire to secure by United States Letters Patent is:

1. The process of manufacture of a closure key for slide fasteners which consists of die stamping identical sides of the key, forming said side portions and placing two of said portions side to side and integrating the same with a wicket portion staked to each side of each of said slide portions.

2. The process of manufacture of a closure key for slide fasteners consisting of die stamping out of sheets identical side portions of the key, forming said side portions in predetermined form, placing two of said portions side to side and integrating same with a wicket portion welded to said side portions.

3. A key for slide fasteners comprising a closure wicket and two identical stamped slide portions side to side, said wicket slotted to receive protrusions provided therefor on said slide portions and staked thereto.

4. A key for slide fasteners comprising a closure wicket and two identical stamped slide portions side to side, said wicket welded to said slide portions thus providing an integrated whole.

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