Aug. 8, 1939. E. NOYACK 2,168,876

METHOD OF FABRICATING COSMETIC HOLDERS

Filed May 8, 1936

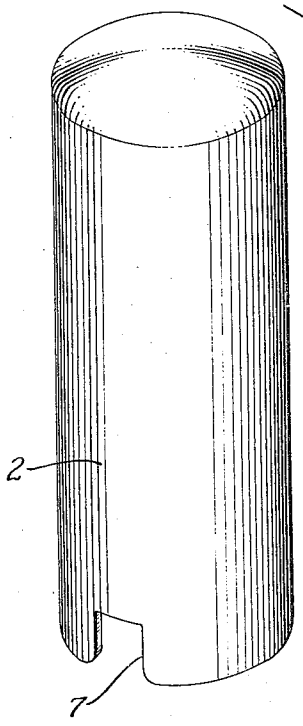
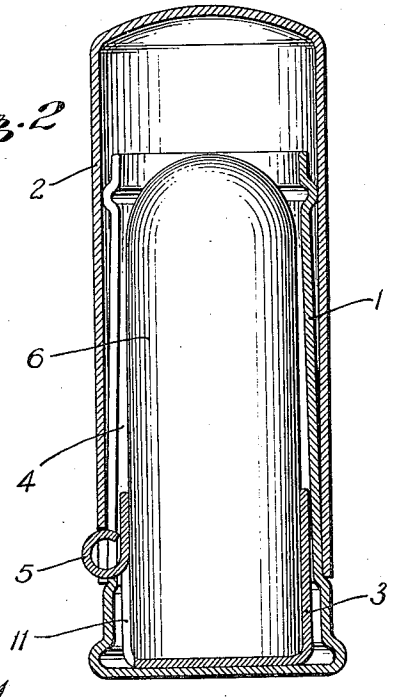


Fig. 1

Fig. 2



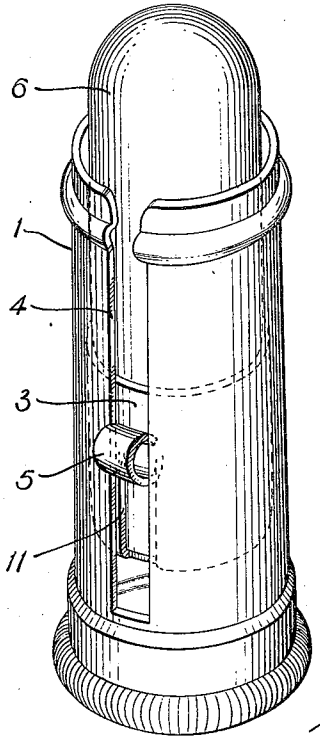


Fig. 5

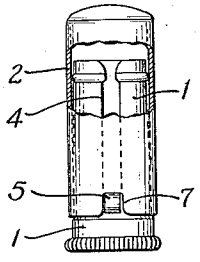


Fig. 3

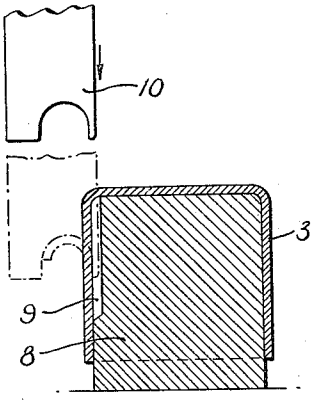
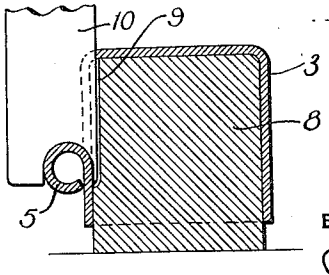


Fig. 4



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METHOD OF FABRICATING COSMETIC HOLDERS

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Application May 8, 1936, Serial No. 78,569

1 Claim. (Cl. 113—116)

The invention relates to a method of fabricating cosmetic or like holders and more especially to the method of fabricating lipstick carriers or elevators thereof, the purpose being to produce the elevator of improved or satisfactory form and at the lowest possible cost of manufacture. The invention consists in the method as hereinbelow explained in connection with the drawing which illustrates the preferred form.

Figure 1 is an enlarged perspective view on an enlarged scale of the cosmetic holder with cover withdrawn and the lipstick raised.

Figure 2 is a vertical section through the closed holder.

Figures 3 and 4 are vertical sections illustrating the method of forming the lipstick elevator, and

Figure 5 is a side elevation on a smaller scale of the closed holder, parts of the cover being broken away.

The holder as shown comprises a main case 1, a cover 2 and the elevator 3, the case being provided with a longitudinal slot 4 and the elevator with a projecting thumb piece 5 extending through the slot by means of which it may be raised or lowered to advance or retract the lipstick proper which is marked 6. Retraction of the lipstick may also be effected by replacing the cover whose lower edge, slotted at 7, fits over the thumb piece on the elevator.

The elevator is a cup stamped out of a thin sheet metal and such as can be made rapidly in automatic punch presses. The lipstick is frictionally held in the cup, seated upon the transverse wall at its bottom, the sole function of which is to sustain the endwise pressure exerted on the stick when in use.

According to this invention, the thumb piece or projection 5 is formed on the cup in the punch press in which it is made, which is to say, it is formed as one of the stages of punch press operation and at one of the existing stations in the press, and therefore without any effect whatever on the rate of production. When the elevator blank, in the course of its progress through the punch press, has reached the shape of a cup, such cup is then moved to a station in the machine where it is placed on a cylindrical die 8 provided with a longitudinal slot or channel 9 along one side. The die, shown in Figs. 3 and 4 then advances or is otherwise brought into register with a curling punch 10, which on the next stroke of the press advances through the transverse wall representing the cup bottom into the channel and shears a strip out of the cup wall beginning at its said transverse or bottom wall and at the same time curls the strip over on itself for about 360°, as indicated in Figs. 3 and 4, wherein successive positions of the tool in the same stroke are shown. This curled strip forms the thumb piece 5 and inasmuch as the punch 10 and die 8 are merely tools fitted to existing chucks in the press, it is clear that as above stated, the rate of production has not been affected.

At the same time the elevator cup thus made has the special advantage over usual cups, in that the open end or rim of the cup is continuously circular without interruption, which is an aid in assembling and introducing the plastic lipstick 6 into it, and it has the further advantage that the open slot 11, left by the strip, which extends to the bottom of the elevator cup, provides a window not concealed when the cup is set down on its bottom and through which the stick and the inner surface of the bottom can be observed until their contact has occurred to determine whether or not the stick has been pushed fully home to the bottom of the cup, this also being an aid in the assembly and insuring uniformly correct seating of the stick.

Thus it will be seen that by cutting the thumb piece strip beginning from the bottom wall of the cup the thumb piece is produced by a single rectilinear stroke and the cup itself acquires special virtues.

I claim:

The method of fabricating an elevator cup for a cosmetic holder comprising forcing a combined shearing and curling tool clear through portions of a transverse wall included in the bottom part of the cup and through the side wall of the cup; and continuing the movement of the tool lengthwise of the cup toward, but not up to, the open end of the cup, simultaneously to cut from the sidewall a longitudinal strip, the base of which is integral with the sidewall, and curl the strip on itself to form a cup-operating projection.

EDWARD NOYACK.