No. 691,850. Patented Jan. 28, 1902.

R. L. ELLERY.

EYELET.

(Application filed May 6, 1901.)

(No Model.)

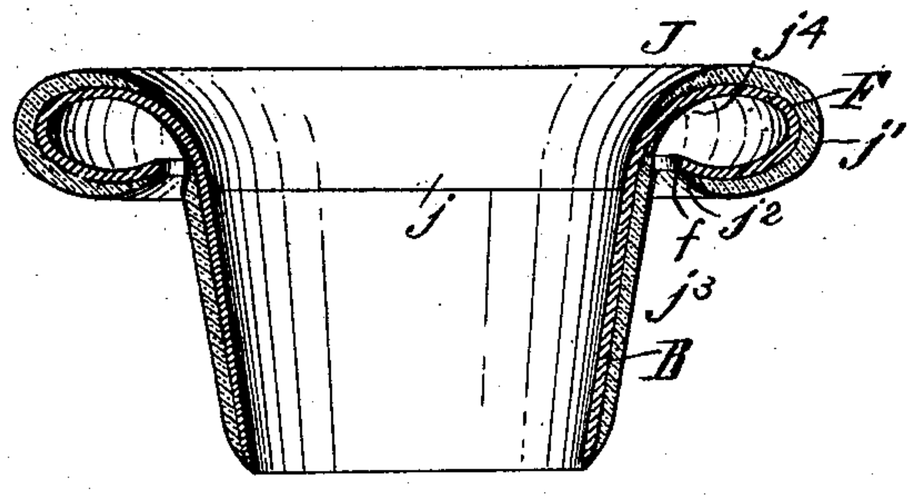

Fig. 1.

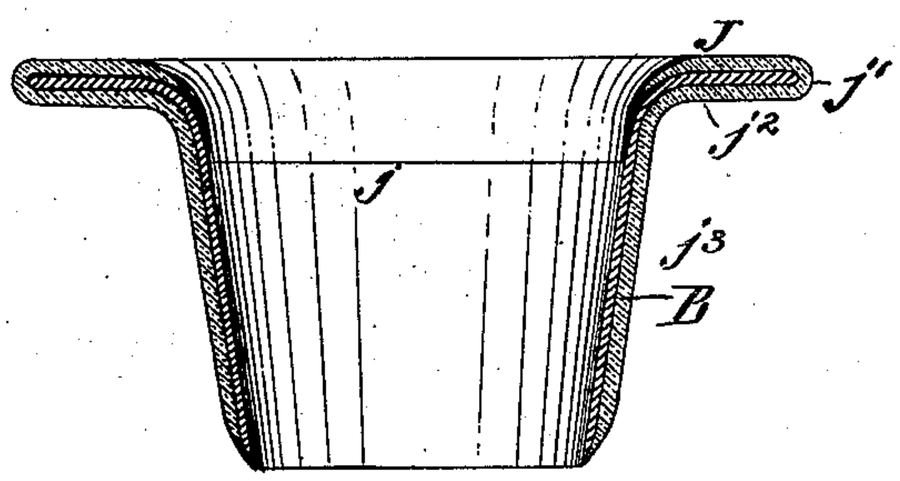

Fig. 2.

WITNESSES:

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UNITED STATES PATENT OFFICE.

ROBERT L. ELLERY, OF PORTSMOUTH, NEW HAMPSHIRE, ASSIGNOR TO MORLEY BUTTON MANUFACTURING COMPANY, OF BOSTON, MASSACHUSETTS, A CORPORATION OF MAINE.

EYELET.

SPECIFICATION forming part of Letters Patent No. 691,850, dated January 28, 1902.

Application filed May 6, 1901. Serial No. 58,897. (No model.)

To all whom it may concern:

Be it known that I, ROBERT L. ELLERY, a citizen of the United States, residing at Portsmouth, in the county of Rockingham and State of New Hampshire, have invented a new and useful Improvement in Eyelets, of which the following is a specification.

My invention consists of a japan-finished eyelet, such as is used on boots and shoes, wherein the japan is applied in a coat sufficiently thick to resist wear and abrasion on the parts which are subjected to such wear and are exposed to view, but wherein the interior of the eyelet-barrel is sufficiently free from japan to avoid gumming and clogging the eyelet-setting devices of the eyelet-setting machines commonly used.

When an eyelet is heavily japanned all over, inside and outside, so as to secure the requisite thickness of the japan coat on the rolled flange, the japan on the inside of the barrel is liable to be unevenly distributed, and even thicker than the japan on the rim, and it follows that when the eyelet-setting tool is inserted in the barrel and the clenching members of the machine are brought together some of this inside japan comes off on the eyelet-set and gums up its moving parts, and when the japan is unevenly distributed on the inside of the barrel the thick part of the japan causes one side of the barrel to split unevenly.

In the drawings hereto annexed, which illustrate embodiments of my invention, Figure 1 is a cross-section, on a magnified scale, of an eyelet which exhibits my improvements; and Fig. 2 shows in cross-section a modified form.

In applying the japan to the eyelets I prefer to coat only the external portions, leaving the interior of the barrel, except where it begins to flare toward the flange, and the interior of the flange, if the flange be of the rolled-under type, free from japan. Such an eyelet is shown in Fig. 1, where the rolled flange F is coated with japan J, the coat beginning in the flare of the barrel at j and ending at the inturned lip f of the flange at j^2. The japan is preferably applied in several successive coats, each coat being baked on before the application of the next coat. The external and convex parts of the flange are coated thickly, as at j'. At the same time I coat the visible parts of the exterior of the barrel B with a japan coating j^3, which extends from the lip of the barrel to the point j^4, or thereabout. The eyelet thus finished presents a uniform color to the eye of the observer and when attached to a shoe or other article gives the same finish as that obtained by the celluloid-coated eyelets now in use. Moreover, the freedom of the interior of the barrel from japan makes the eyelet work as well in the eyeleting-machine as an uncoated eyelet, there being no danger from gumming or clogging, as would be the case were the eyelet to be thickly japanned inside as well as outside.

Fig. 2 shows a flat flanged eyelet with external japan coats applied in substantially the same manner as is illustrated in Fig. 1.

The japan finish while giving the same attractive appearance to the eyelet as the celluloid finish in vogue is even more durable.

The japan-mixer skilled in his trade can prepare japans of various colors to match the goods to which the eyelets are to be applied.

What I claim, and desire to secure by Letters Patent, is—

1. A one-piece metallic rolled-rim eyelet having on the exterior of the rim and outside of the barrel a coating of japan, the lower inside of the barrel and the inside of the rim being left bare of japan.

2. A one-piece metallic eyelet, having a rim and a barrel, japanned on the rim and the outside of the barrel, the inside of the barrel being left bare of japan.

3. A one-piece metallic eyelet, having a rim and a barrel, a thick coating of japan on the rim and outside of the barrel, and nowhere else on the eyelet.

Signed by me at Portsmouth, New Hampshire, this 19th day of April, 1901.

ROBERT L. ELLERY.

Witnesses:
THOMAS H. SIMES,
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