

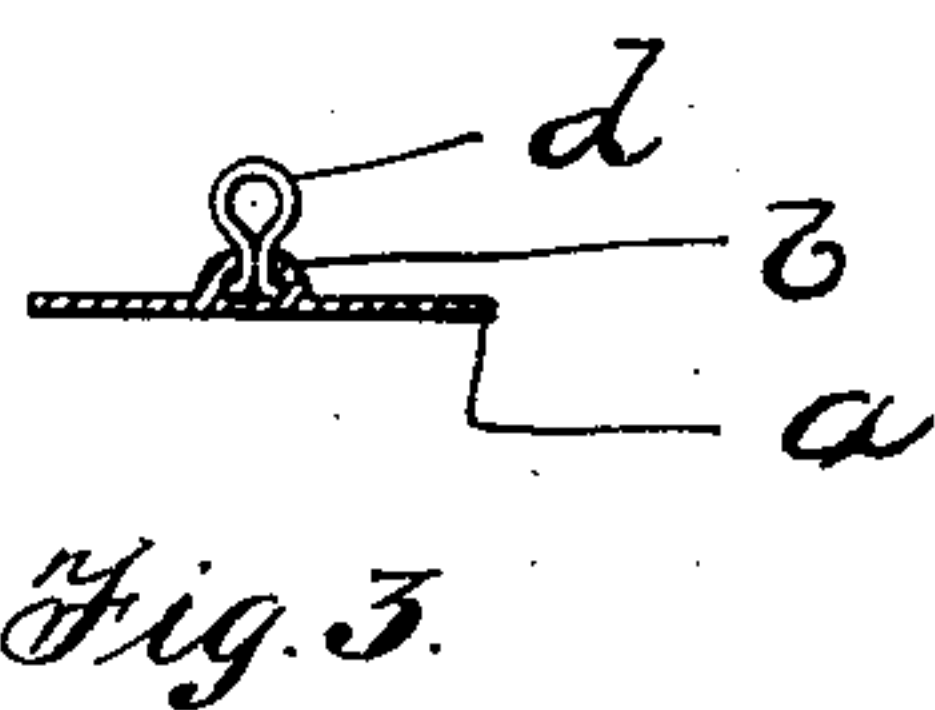
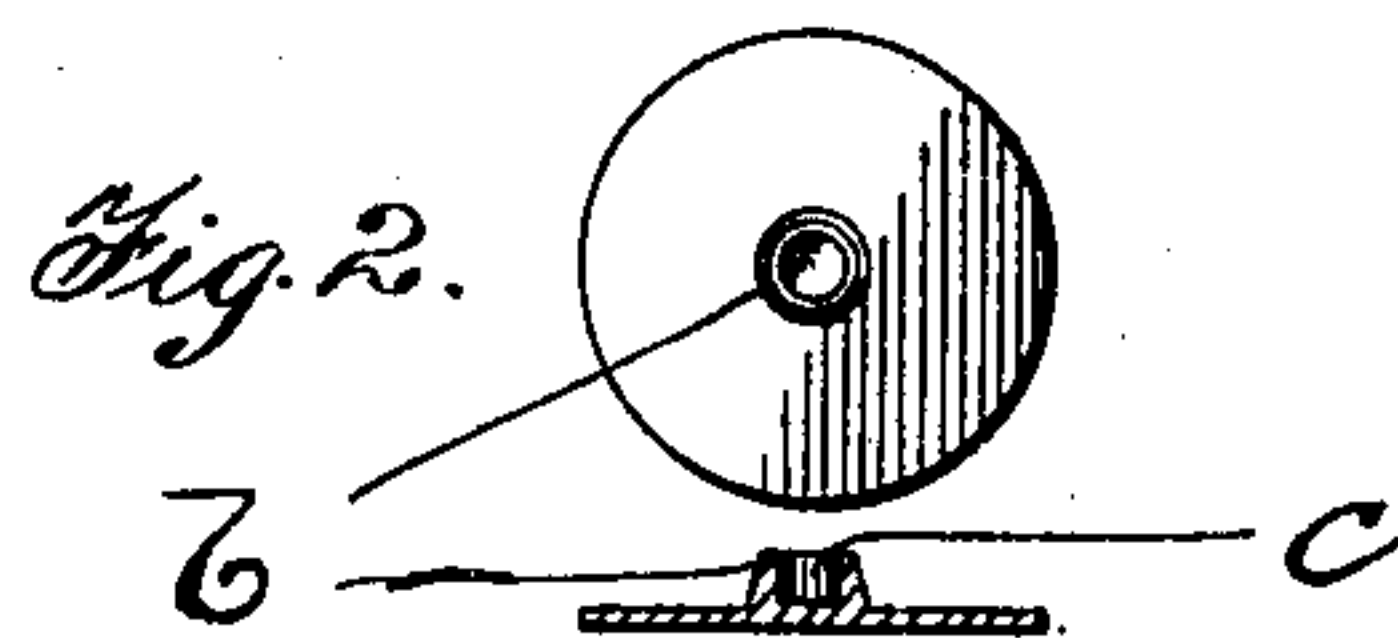
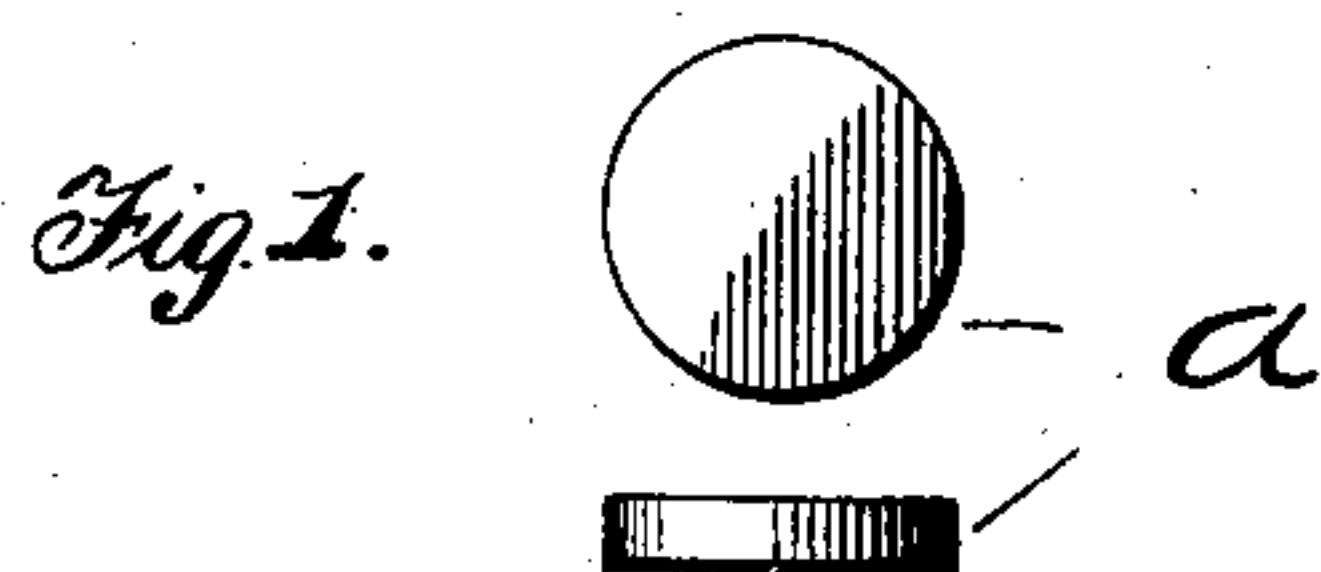
No. 739,070.

PATENTED SEPT. 15, 1903.

J. W. FORCE.
BUTTON.

APPLICATION FILED JUNE 12, 1903.

NO MODEL.



Witnesses
Frank G. Campbell.

A. H. Hemenhall

Inventor

John W. Force

W. E. V. H. V. H.
Attorney

UNITED STATES PATENT OFFICE.

JOHN W. FORCE, OF NEW BRITAIN, CONNECTICUT.

BUTTON.

SPECIFICATION forming part of Letters Patent No. 739,070, dated September 15, 1903.

Application filed June 12, 1903. Serial No. 161,136. (No model.)

To all whom it may concern:

Be it known that I, JOHN W. FORCE, a citizen of the United States of America, residing at New Britain, in the county of Hartford and State of Connecticut, have invented certain new and useful Improvements in Buttons, of which the following is a specification.

The object of the invention is to improve and cheapen the construction of buttons made wholly or partly of metal. It is applicable to buttons made either in one or more pieces.

In general the invention consists in forming a socket in the back of the button, bending the usual loop from wire, and securing both ends of the loop in the socket by swaging in the walls thereof.

One embodiment of the invention is illustrated in the accompanying drawings, in which—

Figure 1 shows a blank in plan and edge view. Fig. 2 shows in plan and edge view the blank finished and ready for the loop. Fig. 3 shows the completed button.

Referring to the drawings, *a* denotes a blank from which a button or button-back is to be made. This blank is initially thicker than is required and of smaller diameter than it is to be when finished. The blank is next spun down or pressed in a suitable machine, re-

ducing it to the desired thickness and increasing its diameter. At the center of the blank the original thickness is retained to form the annular rib *b* and the cup-shaped socket *c*. The usual loop *d* is bent up, and both ends, which are preferably provided with shoulders *e*, are placed in the cup-shaped socket and the ribs swaged down over the ends, securely uniting the loop to the button.

I claim as my invention—

1. A button provided on its rear face with a socket, a wire loop having both ends located in said socket, and a lip intumed from the walls of the socket and lying over both ends of the loop, substantially as described and for the purposes set forth.

2. A button provided on its rear face with an annular rib forming a socket, and a wire loop having both ends located in said socket and secured in place by the intumed edge of said rib, substantially as described and for the purposes set forth.

In testimony whereof I affix my signature in presence of two witnesses.

JOHN W. FORCE.

Witnesses:

H. E. HART,

D. I. KREIMENDAHL.