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PATENTED OCT. 2, 1906.

H. A. PALMER & J. E. UPSON.
METHOD OF MAKING WHIP BUTTONS.
APPLICATION FILED MAR. 1, 1905.

Fig. 1.

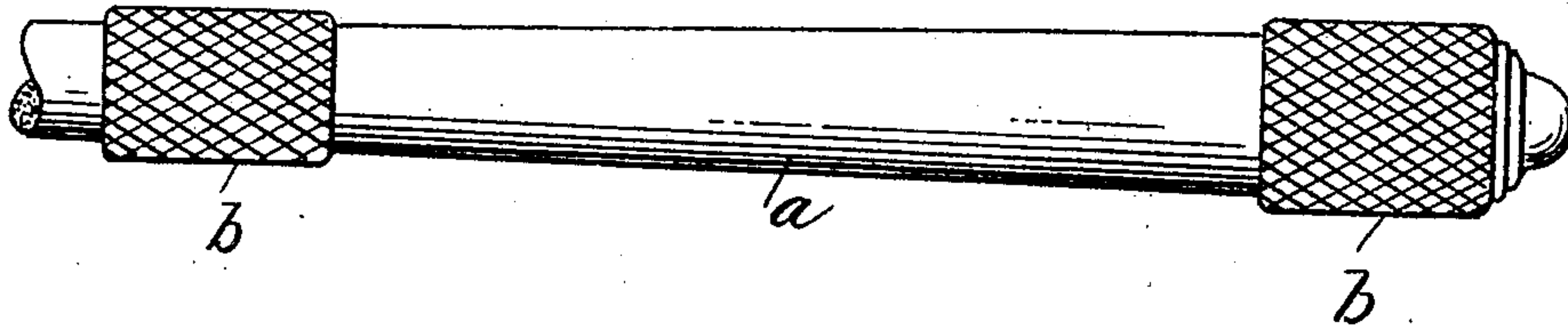


Fig. 2.

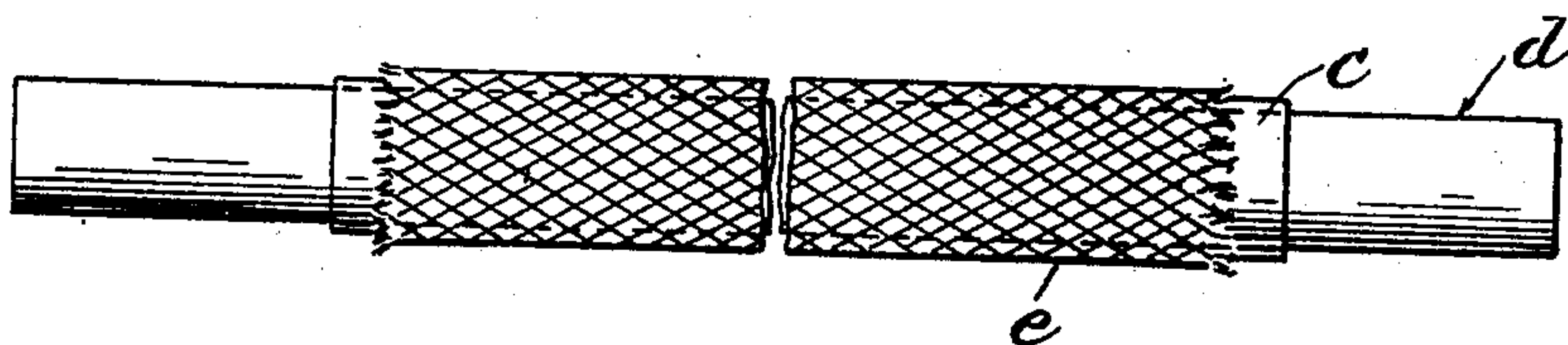


Fig. 3.

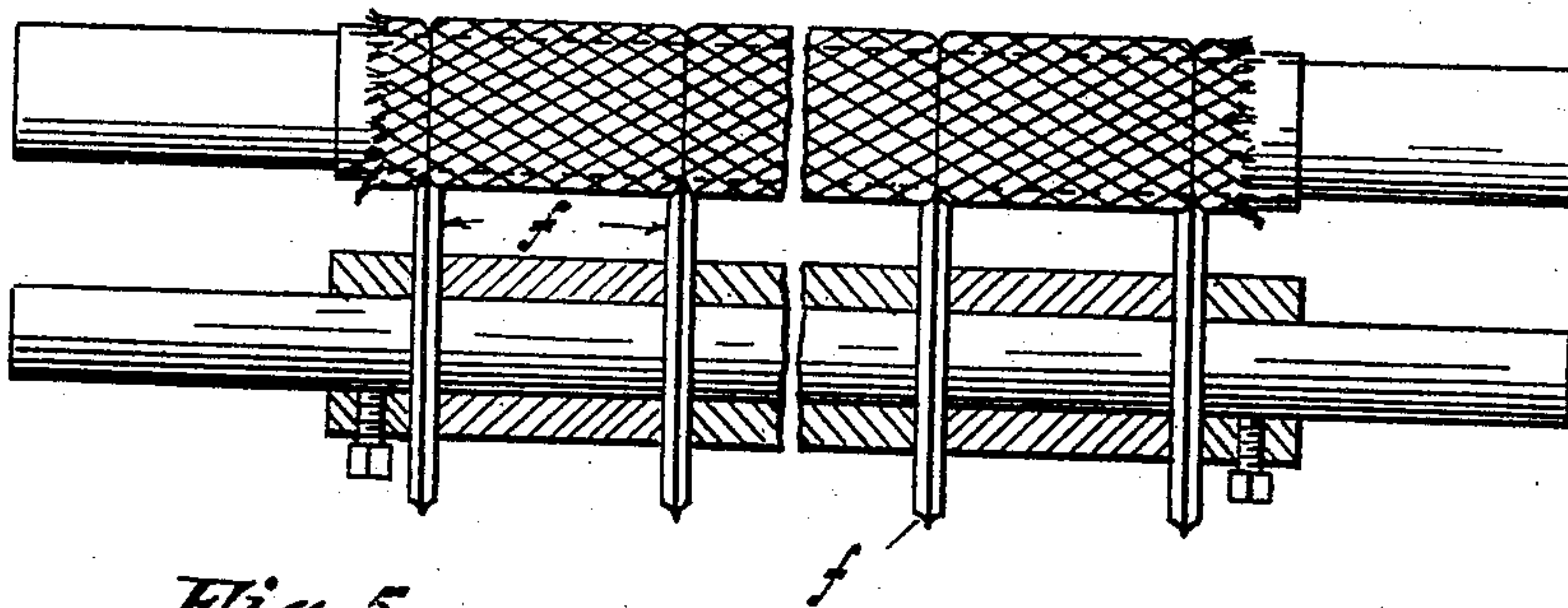


Fig. 5.

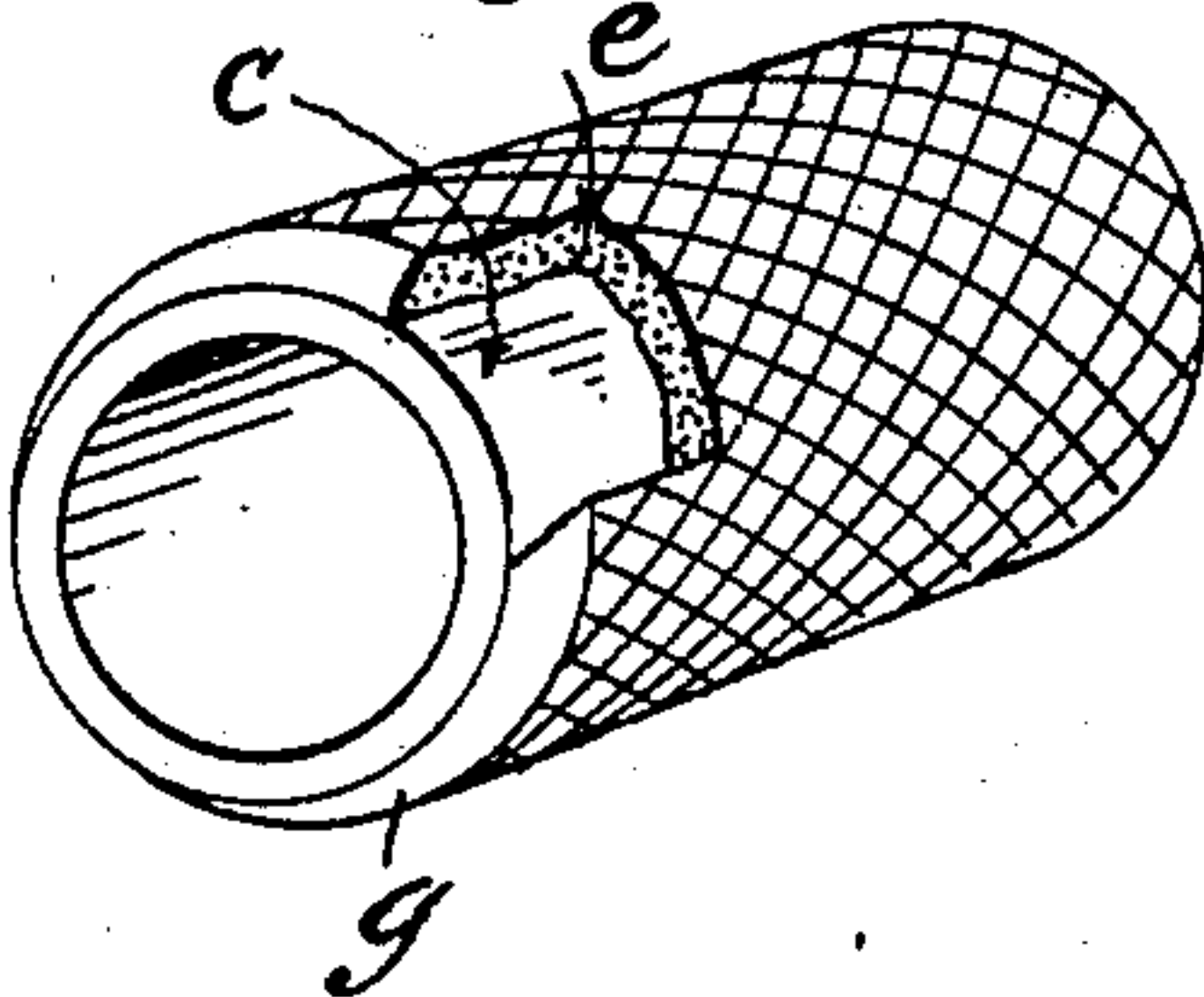
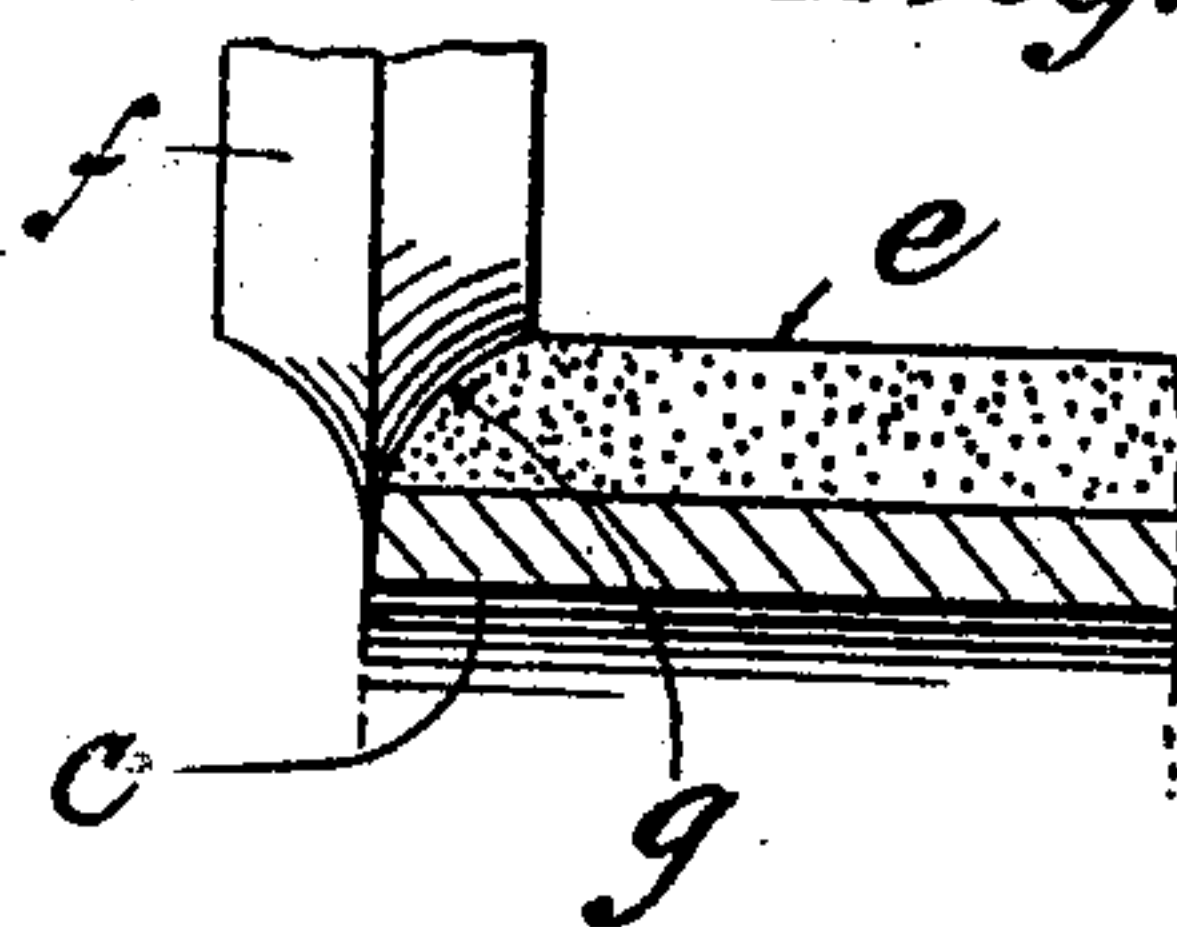


Fig. 4.



Witnesses:

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UNITED STATES PATENT OFFICE.

HENRY A. PALMER AND JOHN E. UPSON, OF WESTFIELD, MASSACHUSETTS.

METHOD OF MAKING WHIP-BUTTONS.

No. 832,272.

Specification of Letters Patent.

Patented Oct. 2, 1906.

Application filed March 1, 1905. Serial No. 247,962.

To all whom it may concern:

Be it known that we, HENRY A. PALMER and JOHN E. UPSON, citizens of the United States of America, residing at Westfield, in the county of Hampden and State of Massachusetts, have invented new and useful Improvements in Methods of Making Whip-Buttons, of which the following is a specification.

10 This invention relates to whips, the object thereof being to provide an improved textile-covered button for whips and an improved method of making the same, the essential feature of the invention lying in the provision of
15 means whereby these textile-covered buttons may be made separately from the whip and put on the latter after the manufacture thereof, and, second, in the provision of means for making these buttons in a continuous tubular
20 form and cutting them off in any desired length in a manner to prevent the fraying of the ends of the textile material with which they are covered.

25 The button and the method of making the same are illustrated in the accompanying drawings, in which—

Figure 1 shows a portion of a whip to which the buttons have been applied. Fig. 2 shows the long tubular form in which the buttons are first made on a mandrel. Fig. 3 shows one method of subdividing this long tubular
30 piece into shorter lengths to constitute individual buttons. Fig. 4 is an enlarged sectional view of a portion of a button and a portion of a rotating cutter whereby the button is cut to length and the edge thereof rolled into or embedded in the end of the button, and Fig. 5 is an enlarged perspective view of
35 a completed button.

40 Referring to the drawings, *a*, Fig. 1, indicates a portion of a whip-stock, and *b* buttons thereon. The general practice at present is to form these buttons individually on the whips by plaiting in the well-known manner.

45 In carrying out our invention a tube *c*, Fig. 2, is slipped onto a mandrel *d*, and a covering *e* of any desired thickness and pattern is then plaited thereon, just as the covering is plaited on a whip-stock, thus constituting a textile-covered tube which may be
50 of any length desired, the plaiting being ap-

plied thereto with sizing, as in all whip-making. As required for use these covered tubes are placed in a suitable machine on a
55 mandrel and rotated against suitably-spaced rotating cutters *f*, supported on a shaft parallel with the mandrel, these cutters being provided with a V-shaped edge, as shown in Fig. 4, the tubes if the sizing has become very
60 dry being immersed for a moment in water to soften the sizing before being subjected to this cutting operation.

As the cutters are rotated in contact with the tube under pressure the textile covering
65 is cut circumferentially and the paper tube *c* is creased or possibly cut through to the mandrel, and during this operation the V-shaped edges of the cutters *f* will roll down the ends of the several threads of the textile covering
70 and embed the same in said covering material and in the ends of the tube *c* in such manner that the severed button will have the smoothly-finished rounded ends *g*. (Shown in Figs. 4 and 5.)
75

When the buttons are thus cut into lengths and dried, the hardening of the sizing and the varnishing which may be applied after they have been suitably located on the whip prevents the fraying of the severed ends of the
80 textile covering and provides a button which may be applied to the whip far more cheaply than the same can be applied by the method now in general use.

While the use of a paper tube is the most
85 satisfactory known to us, the invention obviously is not confined to the use of tubes made of that material, and any other suitable material may be substituted for the paper.

Having thus described our invention, what
90 we claim, and desire to secure by Letters Patent of the United States, is—

1. The herein-described method of making whip-buttons which consists in applying a textile covering to a tube and subsequently
95 cutting up said tube transversely to constitute buttons and finishing the ends of the buttons by embedding the several ends of the textile covering into the ends of the buttons.

2. The herein-described method of making
100 whip-buttons consisting in applying a textile covering to a tube or core, then cutting and finishing the textile covering and tube at one operation by transversely cutting the same

and simultaneously forming two convex surfaces and embedding the several ends of the fabric into the core.

3. The herein-described method of making
5 whip-buttons consisting in applying a textile covering to a tube or core, then cutting and finishing the textile covering and tube at one operation by transversely cutting the same

and embedding the textile covering into the adjacent ends of the cut tube.

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