

J. L. HERZOG.
METHOD OF FORMING CUFF BUTTONS.
APPLICATION FILED AUG. 3, 1910.

979,163.

Patented Dec. 20, 1910.

Fig. 1.

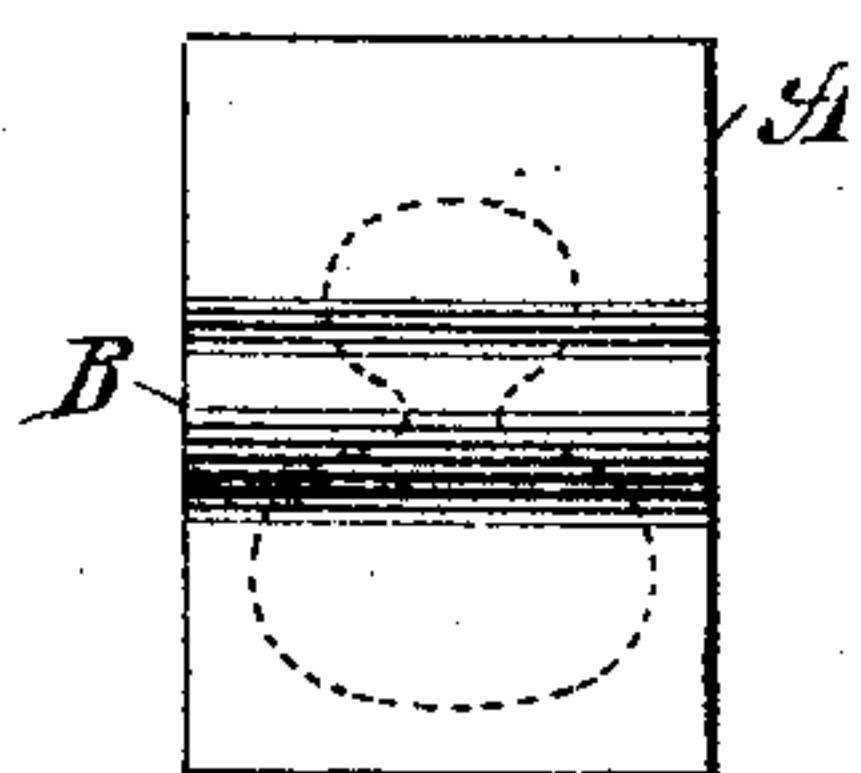


Fig. 2.

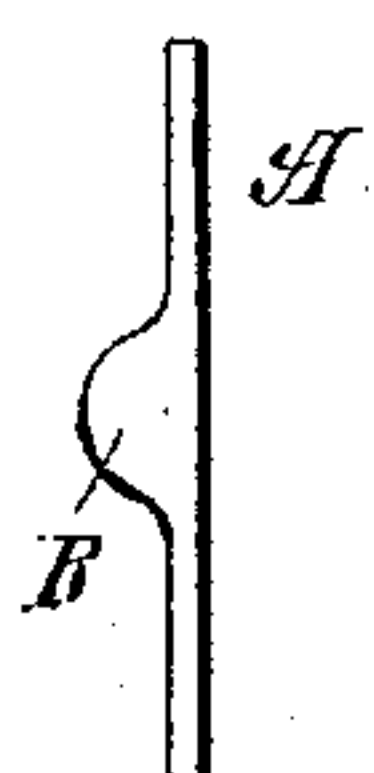


Fig. 3.

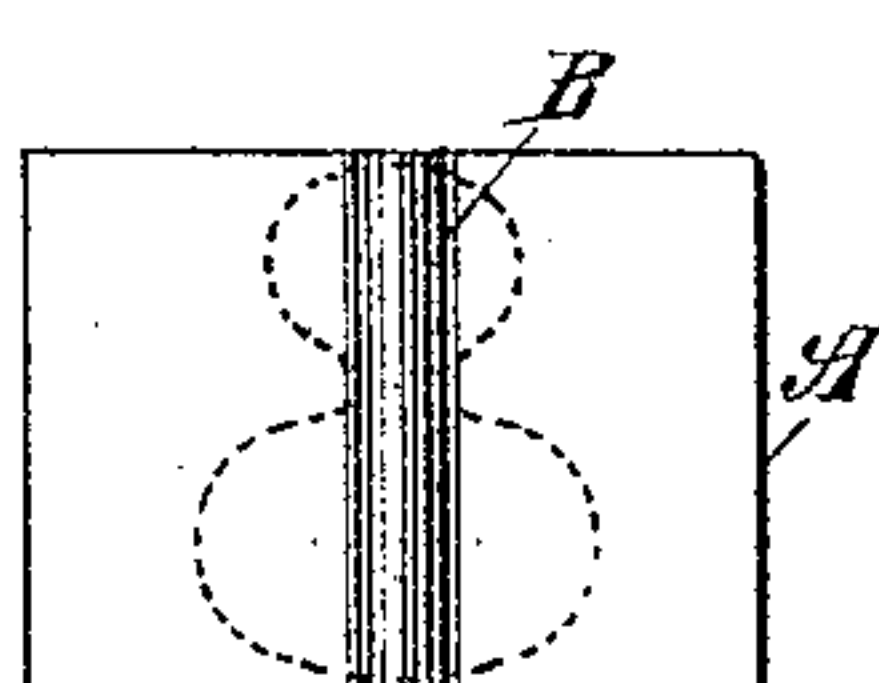


Fig. 4.

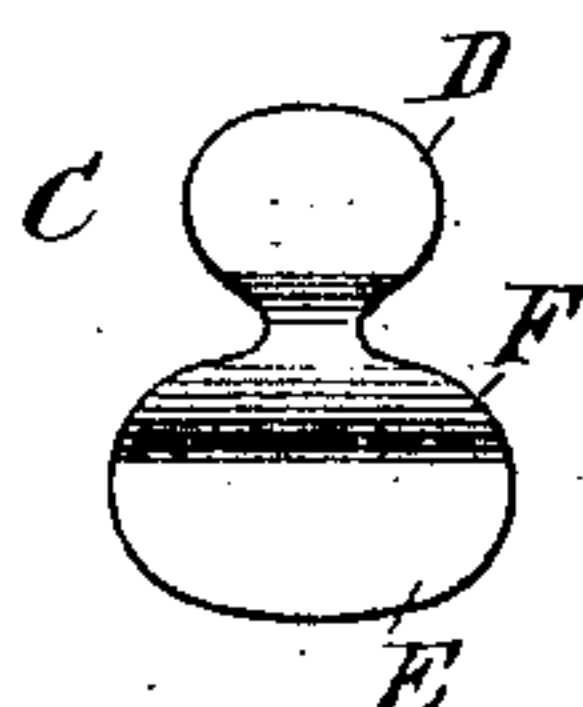


Fig. 5.



Fig. 6.

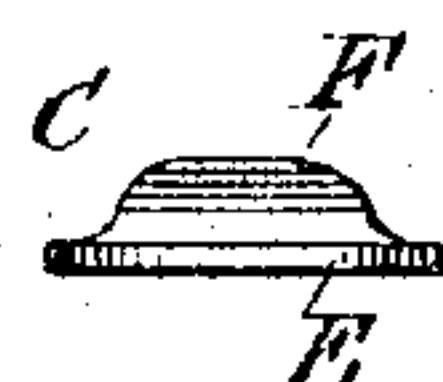


Fig. 14.

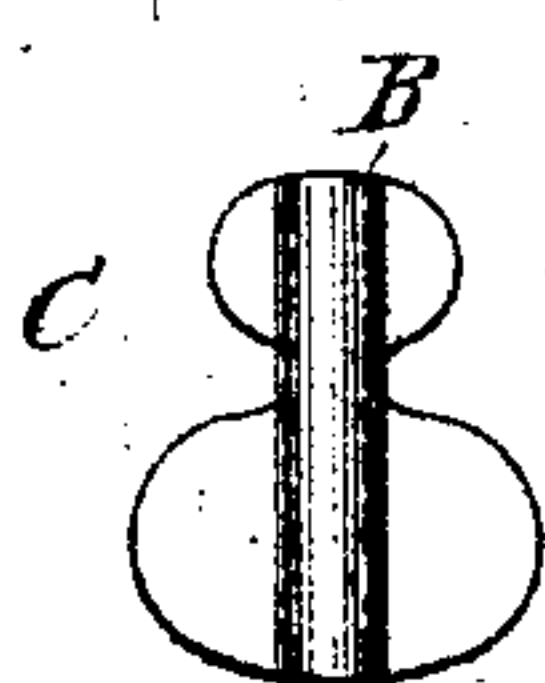


Fig. 15.

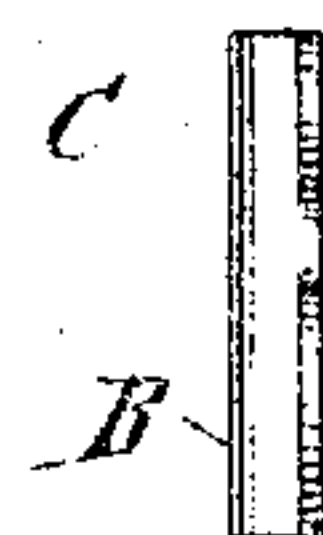


Fig. 7.

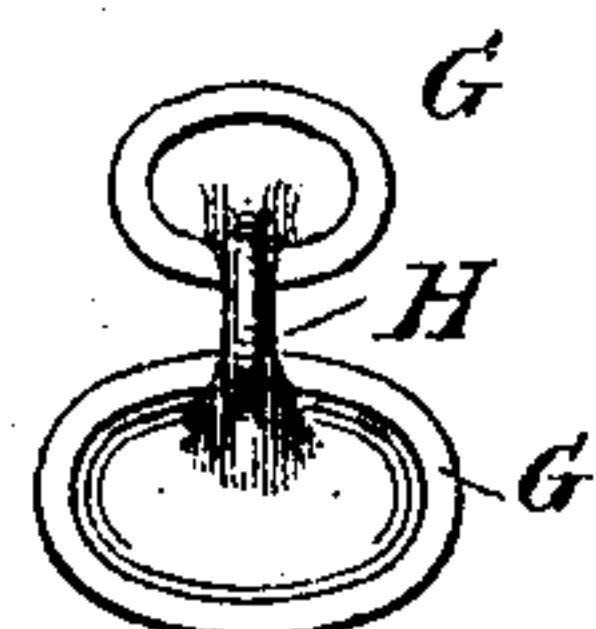


Fig. 8.

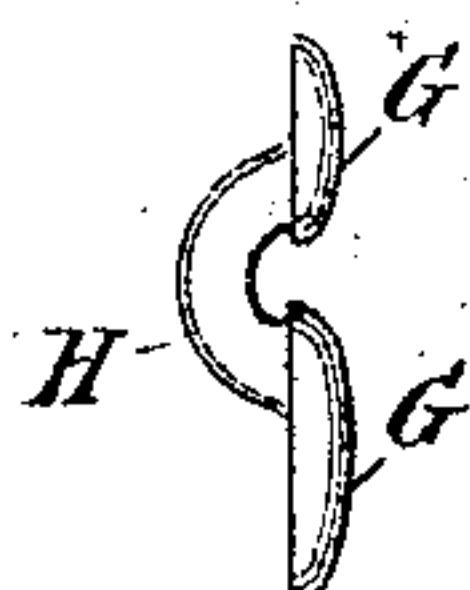


Fig. 9.



Fig. 10.

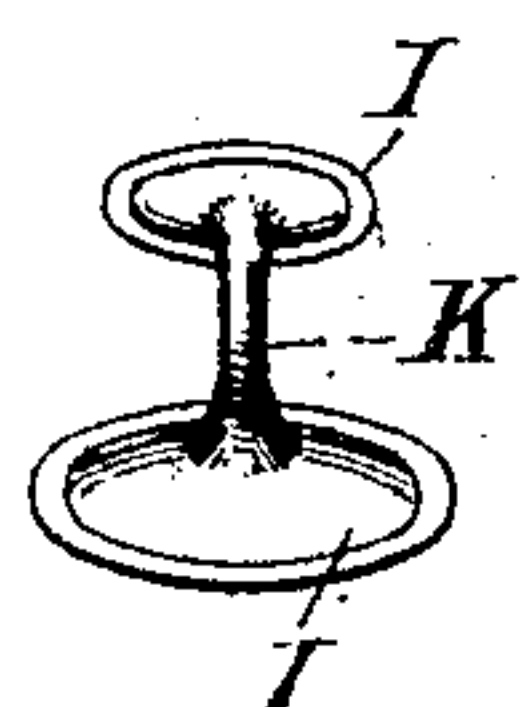


Fig. 11.

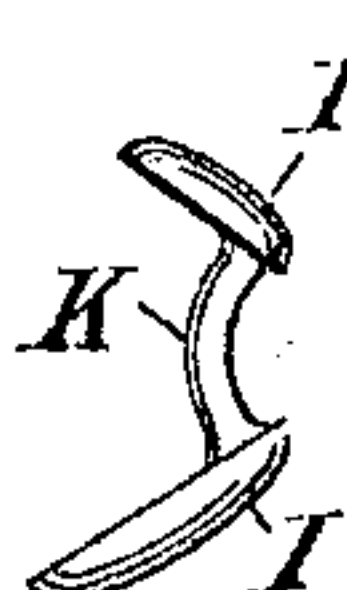


Fig. 12.



Fig. 13.



WITNESSES

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METHOD OF FORMING CUFF-BUTTONS.

979,163.

Specification of Letters Patent.

Patented Dec. 20, 1910.

Application filed August 3, 1910. Serial No. 575,302.

To all whom it may concern:

Be it known that I, JOSEPH L. HERZOG, a citizen of the United States, and a resident of New York, borough of Manhattan, in the county of New York and State of New York, have invented an Improved Method of Forming Cuff-Buttons, of which the following is a specification.

My invention relates to a method of making or forming cuff buttons, and more particularly to a button of the style or type usually known and referred to as a link cuff button, that is, a button comprising two disks connected by a bar or shank, the object of the invention being to devise a method whereby a button of this character may be readily and economically formed from a single continuous piece of metal, the bar connecting the disks being of somewhat greater thickness than the disks, whereby to impart sufficient strength to the finished article to withstand any strain or stress likely to be imposed upon it.

With these and other ends in view, the invention consists of a method comprising the novel steps hereinafter described and pointed out in the claims.

In the accompanying drawings, Figure 1 is a plan view of the blank from which the button is formed, the button in one stage of its formation being shown in dotted lines. Fig. 2 is an edge view of the blank. Fig. 3 is a plan view of the blank showing in dotted lines the button in one stage of its formation to be cut from said blank lengthwise of the rib on the latter. Fig. 4 is a plan view of the button at one stage of its formation, Fig. 5 an edge view of the same, and Fig. 6 an end view thereof. Fig. 7 is a bottom plan view of the button in its next stage of formation, Fig. 8 an edge view thereof, and Fig. 9 an end view. Fig. 10 is a plan view of the finished button, Fig. 11 a side view thereof, and Fig. 12 a longitudinal sectional view. Fig. 13 is a sectional view of a modified form of the blank. Fig. 14 is a plan view of the partially formed button when cut lengthwise of the rib on the blank, and Fig. 15 an end view of the same.

By reference to the drawings, and particularly Fig. 12, wherein is illustrated a sectional view of a finished button, it will be seen that I form the button of a single continuous piece of metal, the button comprising two disks set at an angle to each other, and connected by a bar of greater thickness

than that of the disks, the bar merging into the metal of which the disks are formed, preferably at points within the outer edges of said disks. No claim, however, is made to the button itself, as the same is disclosed and claimed in my Patent No. 973,864, dated October 25, 1910, for cuff buttons. In the production of this button, I start with the blank A, having a rib or thickened portion B extending transversely across the same, as illustrated in Figs. 1, 2 and 3. From this ribbed blank A Fig. 1 is formed, by means of dies or otherwise, the partially shaped button C, as illustrated in Figs. 4, 5 and 6, and comprising a smaller disk D and larger disk E, connected by the thickened metal F, the disks D and E being formed from the thin portions of the blank A, and the thickened portion F from the rib B of the blank A. The button thus partially formed is then, by means of dies or otherwise, converted into the shape as illustrated in Figs. 7, 8 and 9, the two thin disks being provided with the flattened or flanged edges G, and the connecting metal F converted into the comparatively thick bar or post H. It will be seen that thus far the disks D and E with their flattened edges G—G lie in substantially the same plane, the thickened bar H connecting the two disks and gradually merging into the metal of which said disks are formed. The button is then bent into its finished form, as illustrated in Figs. 10, 11 and 12, that is, the two disks I of comparatively thin metal are set at an angle to each other, and the connecting bar K, of comparatively thick metal, being at the same time curved or bent and then dressed into its finished form.

If desired, the form of the ribbed blank A may be somewhat modified, as illustrated in Fig. 13, that is, may comprise the comparatively thin portions L and rib M, a groove or recess N being formed in the under side thereof, it being understood, however, that the thickness of the rib M in this instance will also be somewhat greater than the portions L, in order to impart to the finished article a proper thickness of post or connecting bar. Furthermore, instead of cutting or stamping the partially formed button C transversely of the rib B, as illustrated in Fig. 1, it may be formed lengthwise with relation to said rib B, as illustrated in Figs. 3, 14 and 15, in which instance the rib may be made somewhat narrower than in the for-

mer instance. In either event, the rib or thickened portion B becomes the comparatively thick connecting bar or post K of the finished button.

5 From the foregoing it will be understood that the above described method, comprising as it does, first, forming the button with two disks of comparatively thin metal connected by a partially formed bar of thicker metal
10 from a ribbed blank, secondly, completing the formation of said disks and bar, and finally bending said disks at an angle to each other, is a simple and economical one, and results in the formation of a particu-
15 larly strong article from a single continuous piece of metal, the method, as I have practiced it, being largely carried out by the use of dies for partially forming the button from the ribbed blank, and from the par-
20 tially completed form to the completed form.

What I claim is:—

1. The method hereinbefore described of forming cuff buttons, comprising the partial
25 formation from a ribbed blank of the two disks of metal from the thin portions of said blank, and a connecting bar from the rib of said blank, and finally converting said partially formed button into its finished
30 shape.

2. The method hereinbefore described of

forming cuff-buttons from a single continu-
ous piece of metal and comprising the for-
mation of two disks of comparatively thin
metal with a connecting portion of thicker
35 metal from a ribbed blank, the two disks being formed from the thin portions of said blank, and the connecting portion from the rib of said blank, secondly completing the
40 formation of said disks, and then bending said disks at an angle to each other.

3. The method hereinbefore described of forming cuff buttons from a single continu-
ous piece of metal, consisting in first cutting
45 from a ribbed blank the partially formed button, the thinner portions of said blank forming the disks, and the rib of said blank forming the connecting metal between said disks, secondly, completing the formation of
50 the thickened connecting bar between said disks and also the shape of the comparatively thin disks while in the same plane, and finally converting the article into its finished shape.

Signed at New York, borough of Man- 55
hattan, in the county of New York and State
of New York, this 29th day of July, A. D.
1910.

JOSEPH L. HERZOG.

Witnesses:

A. V. WALSH,
W. R. EDSON.