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Sturm et al.

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[54] **DECORATIVE RIBBON**

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[*] Notice: This patent is subject to a terminal disclaimer.

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[22] Filed: **Dec. 31, 1992**

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Reissue of:

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Appl. No.: **07/470,974**
Filed: **Jan. 26, 1990**

U.S. Applications:

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[51] **Int. Cl.**[7] **D05C 17/00**

[52] **U.S. Cl.** **112/436**; 112/417; 112/426; 112/475.06; 112/475.18

[58] **Field of Search** 2/244; 112/139, 112/417, 418, 419, 423, 424, 425, 426, 436, 429, 437, 439, 450

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[57] **ABSTRACT**

This invention relates to decorative ribbons, and to methods and machines for making them. More specifically, the invention relates to fabric ribbons that are edged with wire and trimmed with an overlay of decorative thread.

According to the invention, a run of fabric ribbon is simultaneously edged with wire and tightly bound with a binding filament (such as monofilament) and a trim filament (such as decorative thread). This is done in a single operation. The result is a unique ribbon construction, which has many desirable properties. The new ribbons are flexible, but will retain their shape when bent, twisted or tied into a desired configuration. They are elegantly simple in design and provide a novel streamlined finished product with components that are firmly bound together. The ribbons provide an improved edge and trimming where the wire meets the fabric. They represent an improvement in strength and design, by conveniently providing a two-sided edged ribbon rather than a one-sided edged ribbed with seams and having a definite front side and back side.

4 Claims, 4 Drawing Sheets

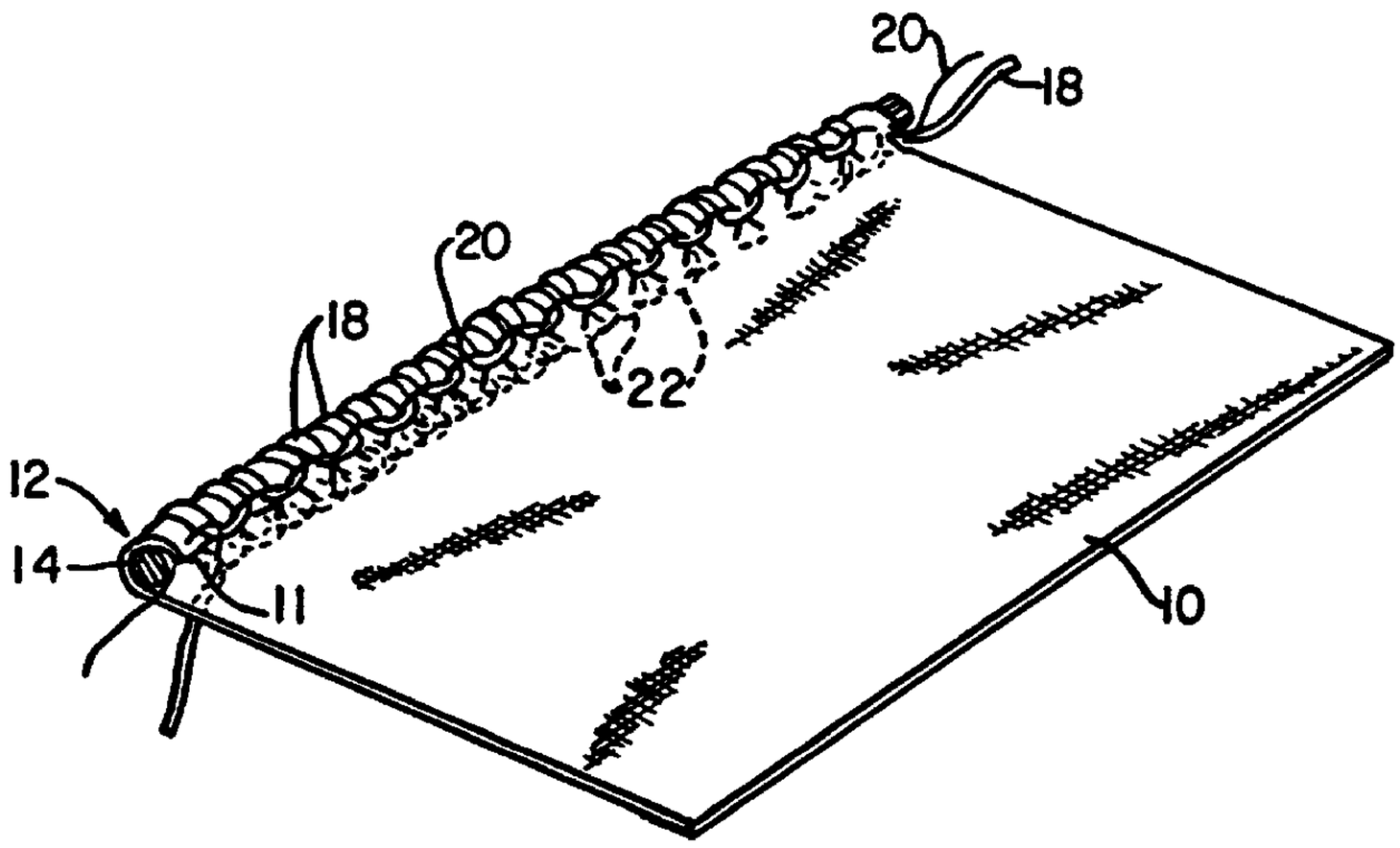


FIG. 1
PRIOR ART

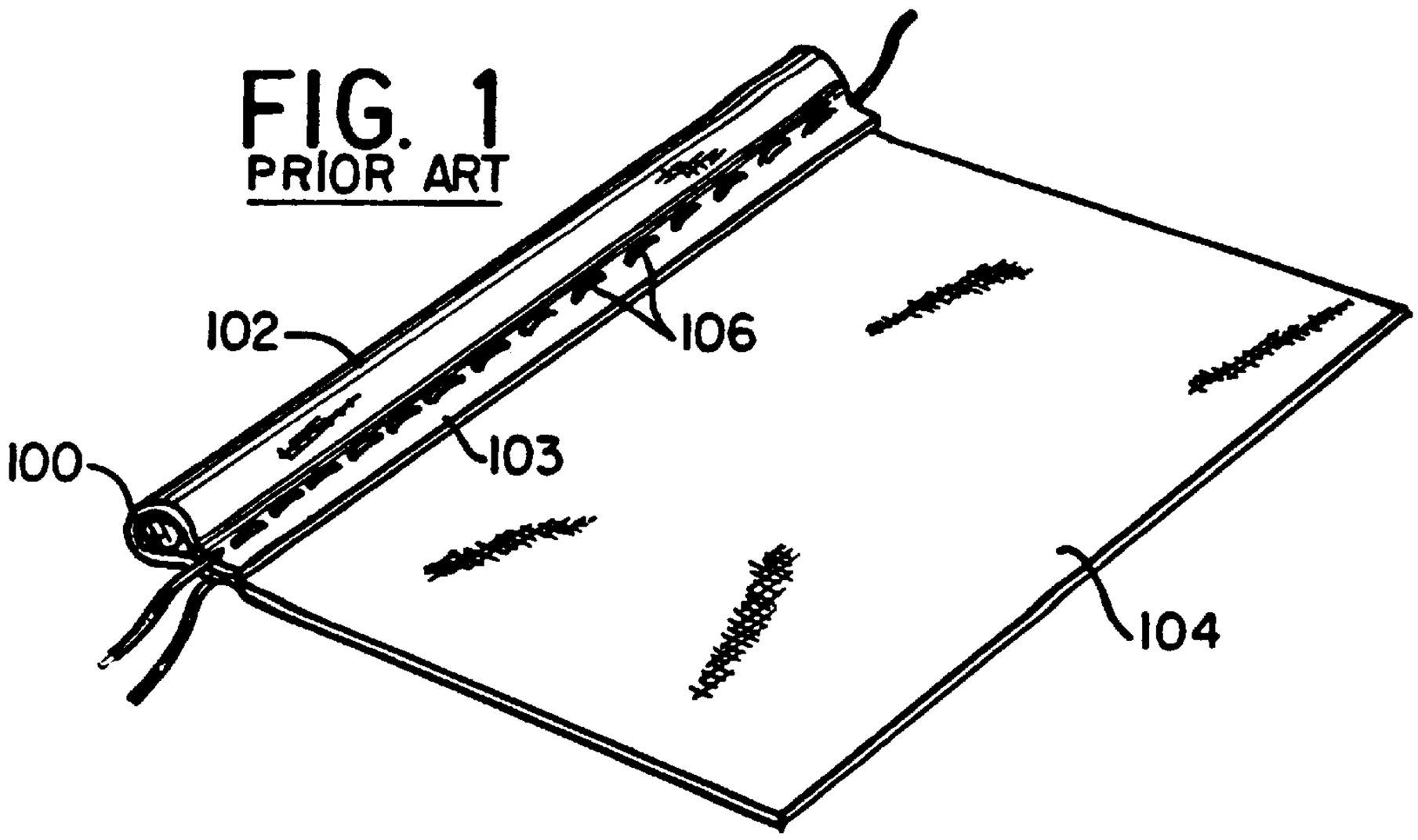
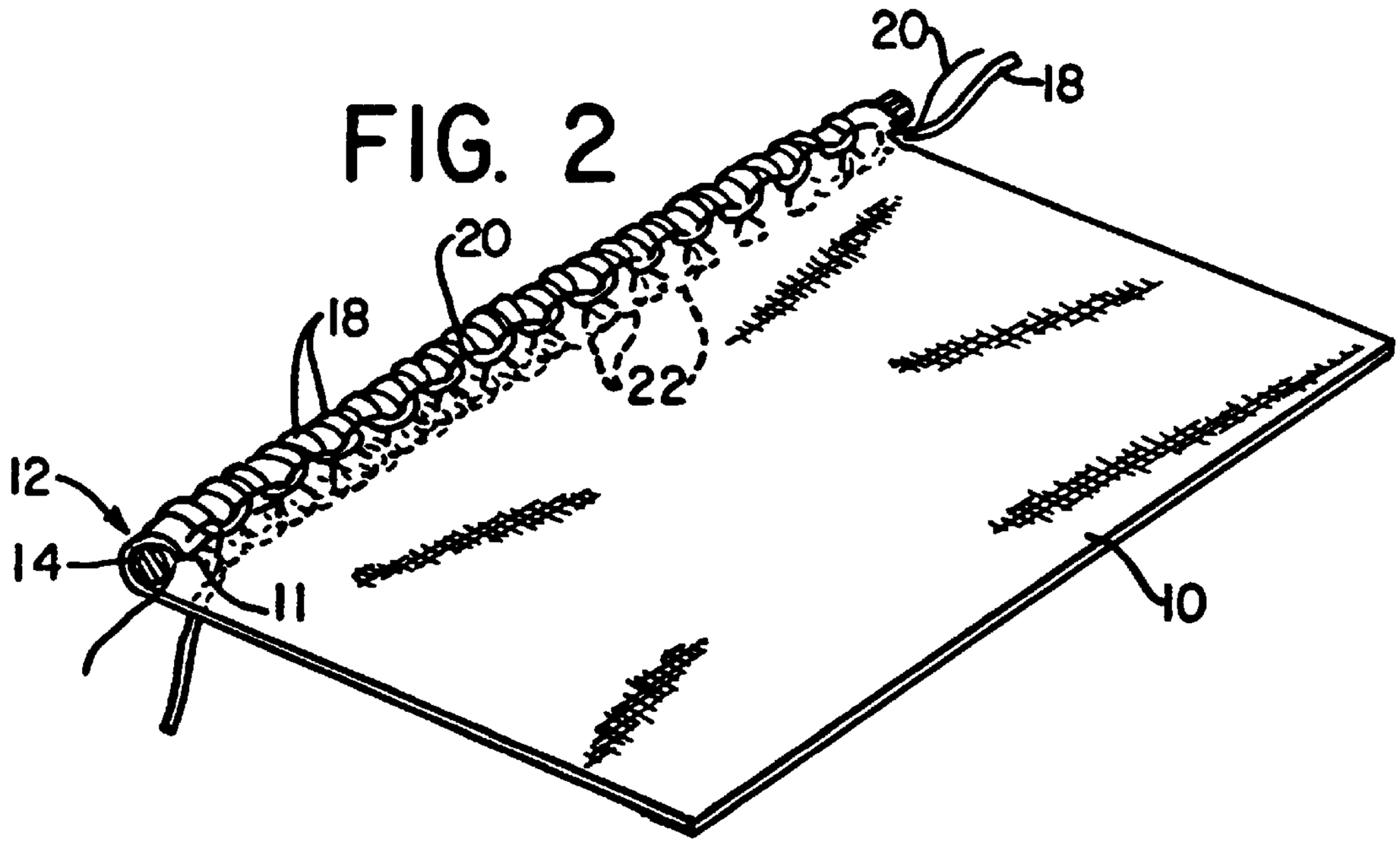


FIG. 2



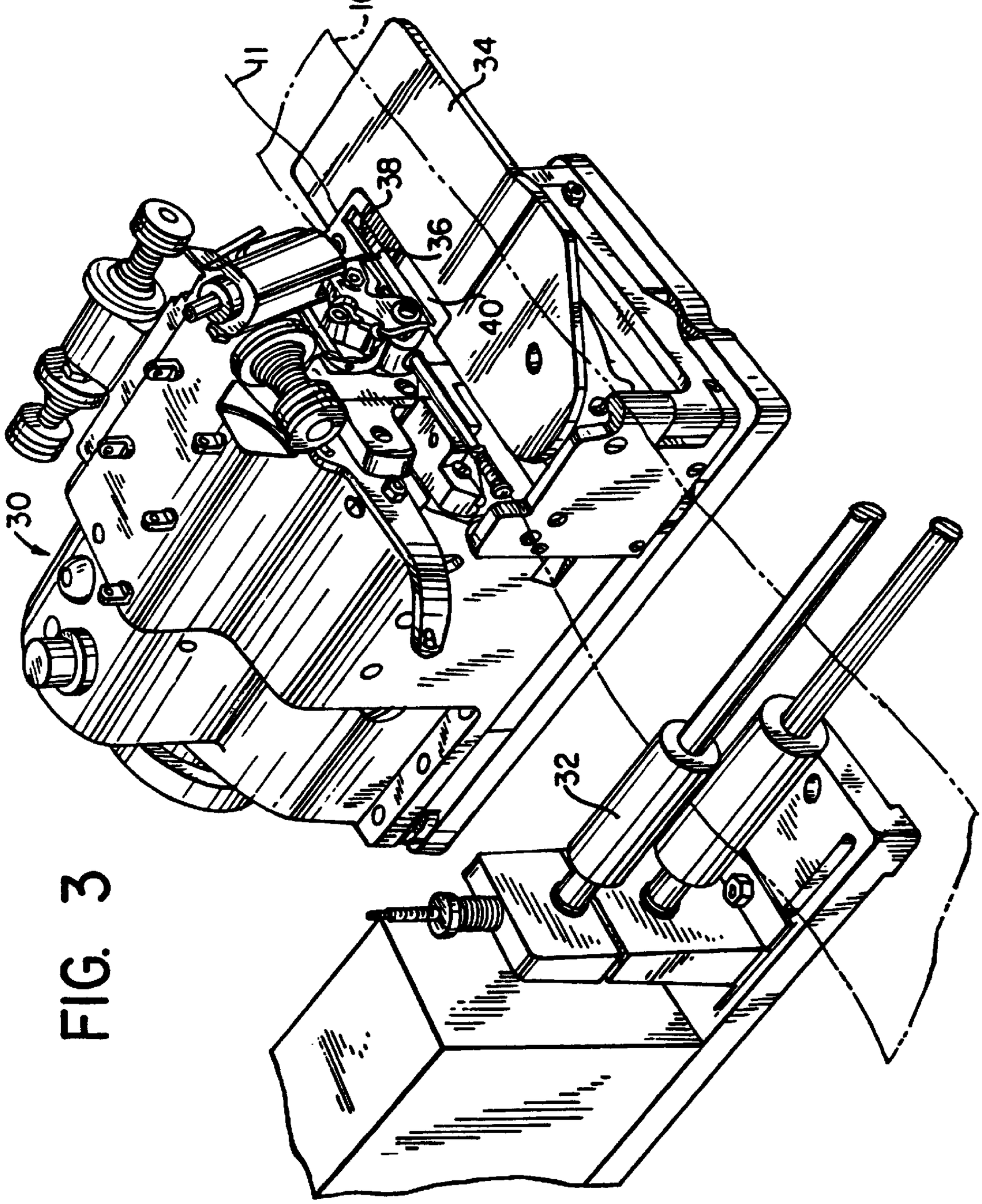


FIG. 3

FIG. 4

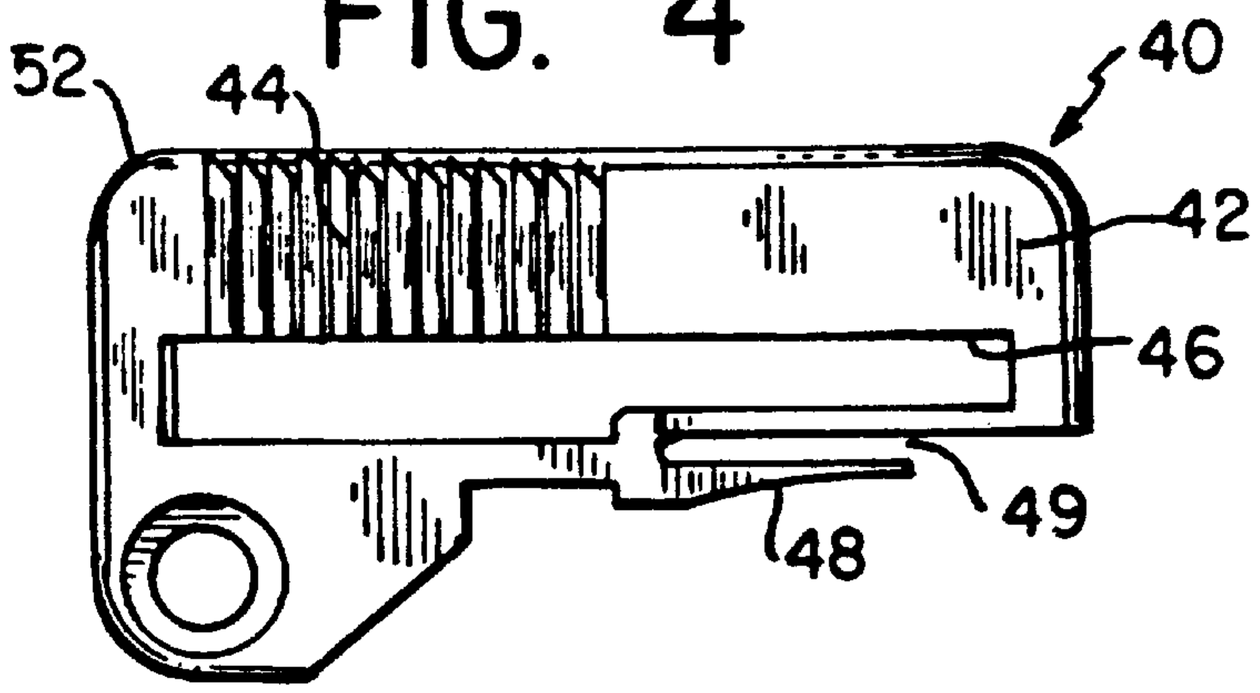


FIG. 5

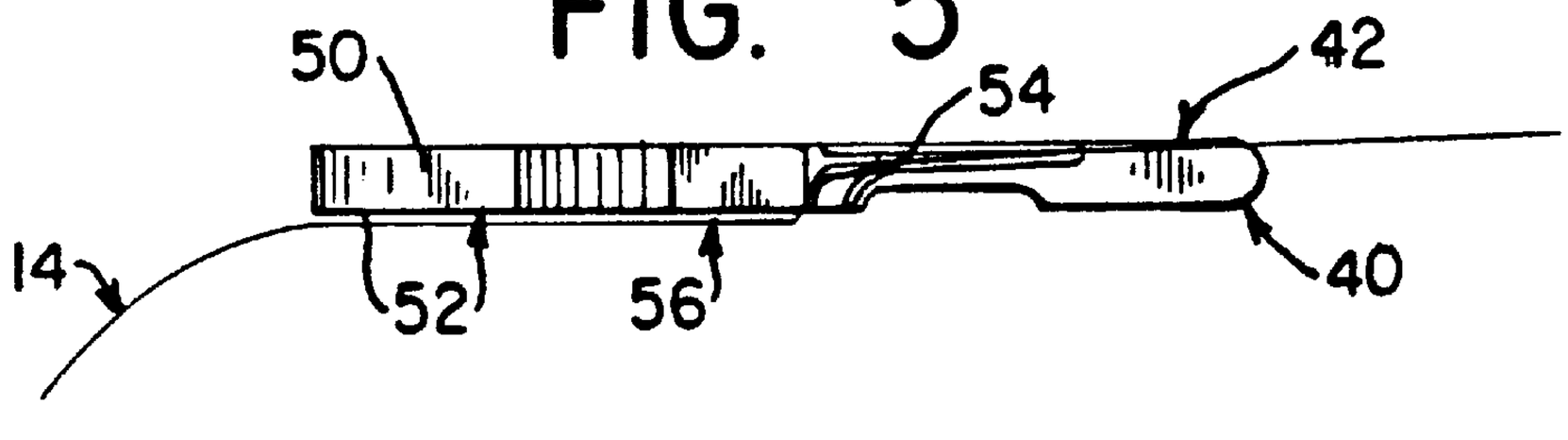
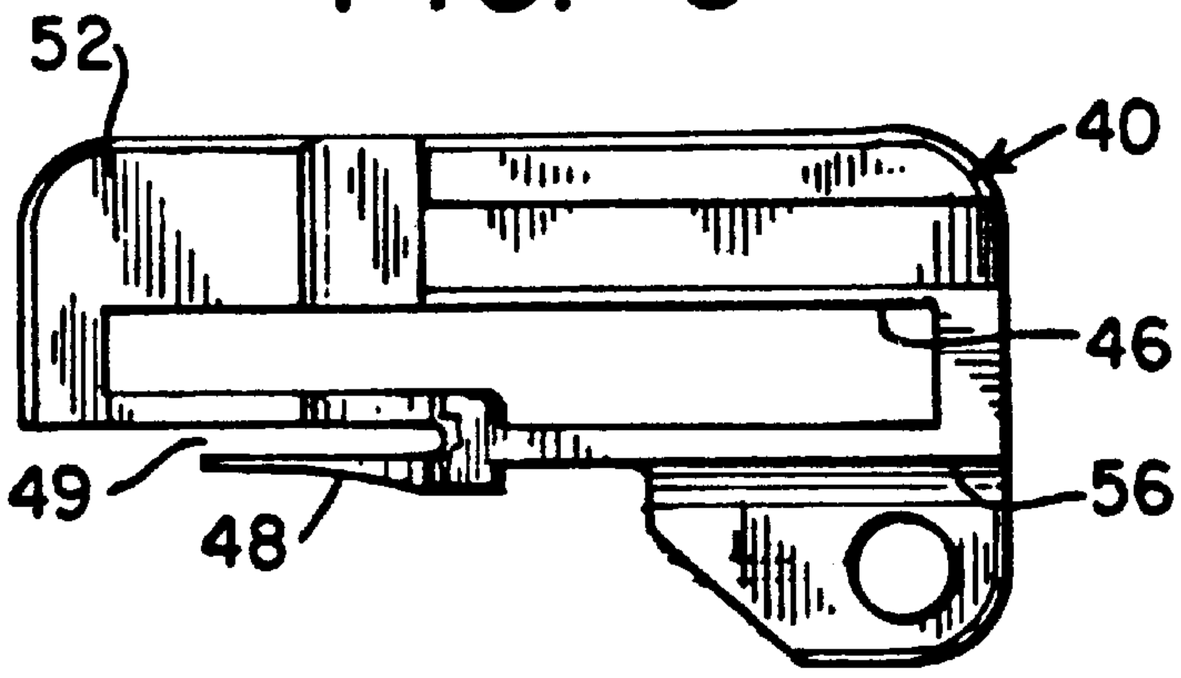


FIG. 6



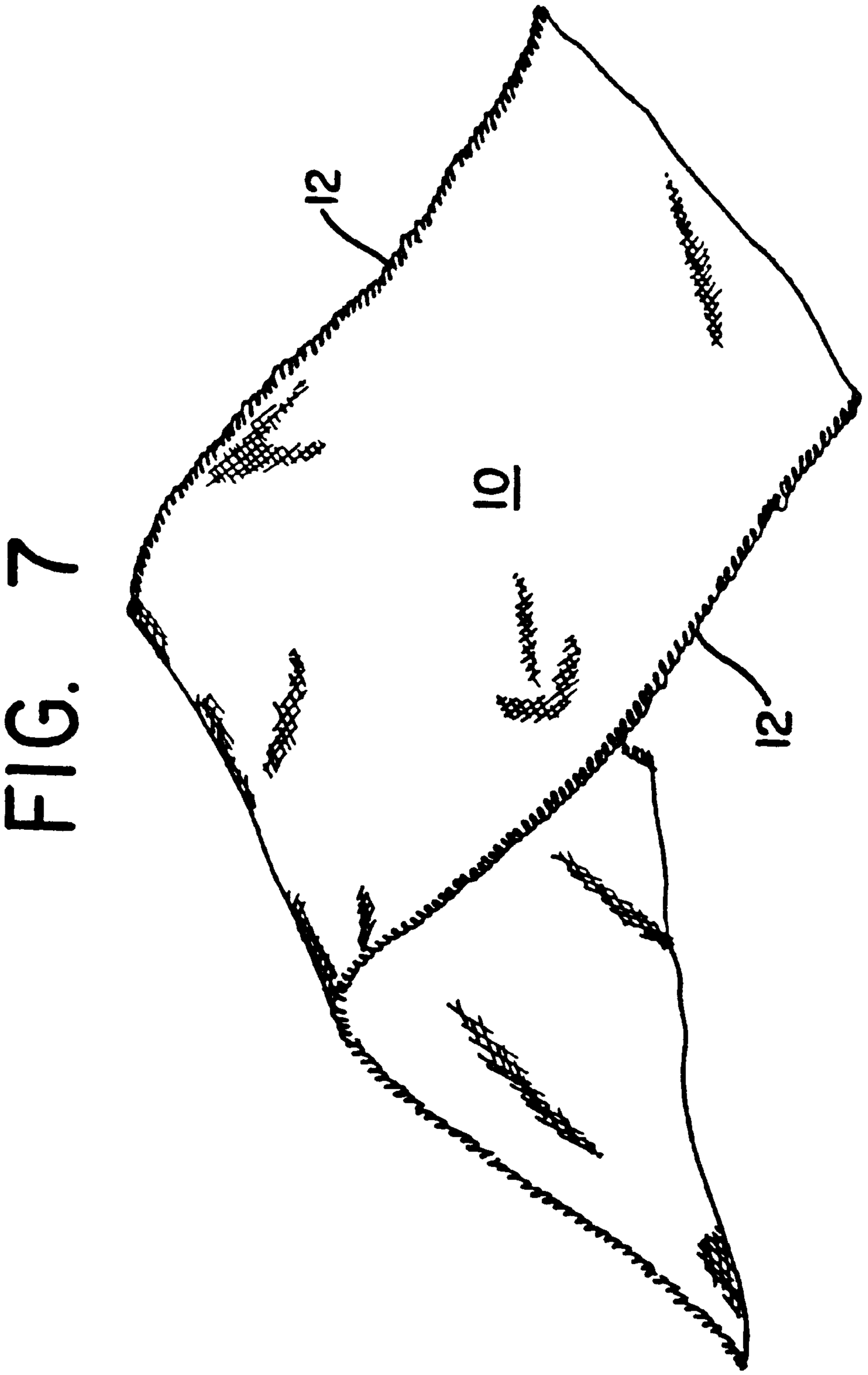


FIG. 7

DECORATIVE RIBBON

Matter enclosed in heavy brackets [ ] appears in the original patent but forms no part of this reissue specification; matter printed in italics indicates the additions made by reissue.

This is a continuation of application Ser. No. 321,720, filed [Nov.] *Mar.* 10, 1989, now U.S. Pat. No. 4,901,661.

This invention relates to decorative ribbons, and to methods and machines for making them. More specifically, the invention relates to fabric ribbons that are edged with wire and trimmed with an overlay of decorative thread.

According to the invention, a run of fabric ribbon is simultaneously edged with wire and tightly bound with a binding filament (such as monofilament) and a trim filament (such as decorative thread). This is done in a single operation. The result is a unique ribbon construction, which has many desirable properties. The new ribbons are flexible, but will retain their shape when bent, twisted or tied into a desired configuration. They are elegantly simple in design and provide a novel streamlined finished product with components that are firmly bound together. The ribbons provide an improved edge and trimming where the wire meets the fabric. They represent an improvement in strength and design, by conveniently providing a two-sided edged ribbon rather than a one-sided edged ribbon having a definite front side and back side. These and other advantages and objectives will become apparent from the detailed description of the invention below.

BACKGROUND OF THE INVENTION

Decorative fabric ribbons are known, as are fabric ribbons that have been edged with wire. However, the prior art wire ribbons are made by laying a wire near the edge of a fabric ribbon, folding the edge of the ribbon over the wire, and sewing or gluing down the folded edge to hold the wire in place.

This type of construction provides a ribbon that will retain its shape when bent, but which suffers from several significant disadvantages.

The folded edge in these known ribbons produces an unsightly seam, which gives the ribbon a definite front and a back, and which makes it more difficult to fashion the ribbon into pleasing shapes.

When the fabric edge is sewn down, the wire is only loosely held within a fabric sleeve, and thus it can move apart from the ribbon. This makes it more difficult to shape the ribbon, and a sliding wire can result in excess wire at one end of the ribbon and no wire at the other end. The sliding wire also makes the ribbon more difficult to control, and the ribbon is less likely to retain its shape over time. Side to side slippage of the wire can also cause undesirable bunching and/or buckling of the fabric.

Similar problems arise when glue is used. Although some glues may help keep the wire firmly in place, in general the bond is weak and cannot withstand the stress of normal use. Thus, the wire will eventually separate from the glue and ribbon over time, or when the ribbon is bent, twisted or tied in use. In addition, the application of the glue and the removal of excess glue results in significant production and quality control problems. For example, excess glue can deface the fabric ribbon, and glues of sufficient strength to hold the wire in place can degrade the fabric.

Another known method involves loosely sealing a wire between two laminated and/or embossed surfaces, which disadvantageously requires the use of two independent fabric surfaces. These ribbons typically are bulky and have an unsightly rear face. Additionally, the two surfaces have a tendency to separate, which defeats the purpose of having a reliable wired ribbon.

In view of these disadvantages, there has been a need for an improved decorative wired ribbon, especially one that provides a firm and integral union of fabric and wire, without the undesirable folds, seams and glue of prior ribbons.

Accordingly, it is an object of this invention to overcome the disadvantages of known wired ribbons, by providing a fabric ribbon edged with wire and bound with trim, so that the wire is hidden from view and yet is firmly affixed to the ribbon without folds, seams or glue.

It is another object of the invention to provide a method of making ribbons edged with wire and bound with trim.

It is yet another objective to provide an apparatus for making the ribbons of the invention.

SUMMARY OF THE INVENTION

The decorative ribbon of the invention comprises a fabric ribbon, a wire filament, at least one decorative or trim filament, and at least one binding filament. The trim and wire filaments are firmly bound and affixed to the fabric by the binding filament. In a preferred embodiment, this is achieved in one simultaneous and continuous operation. Also, the binding filament is preferably chosen and the trim filament is applied in a size, quantity and manner such that the wire filament and binding filament are both substantially or even completely hidden by the trim filament. This provides a seamless stitched border in one operation that holds the wire filament in place without slippage, and without intermediate folding, gluing, embossing or laminating steps.

The ribbon can be any known fabric ribbon, either flat or pleated. It has been found however that certain lighter weight flat fabrics should be sized, to provide added stiffness, while pleated fabrics generally do not benefit from sizing because the heat treatment used to pleat the fabrics generally increases the stiffness anyway. As the width of the fabric ribbon is increased, the need for sizing also increases, especially in sheer or flimsy fabrics. Any known sizing can be used, such as spray starch, and skilled practitioners can readily determine without undue experimentation whether a particular fabric should be sized in connection with the decorative ribbons of the invention. Other fabric finishes can also be used, as desired.

Preferred finished ribbon sizes according to the invention are widths of 1⁷⁄₁₆ (#9), 2¾ (#40), 4 (#100), 6, and 10 inches.

Pleated fabrics can be obtained from flat fabrics, for use in this invention, according to known means of pleating or texturing fabrics. Typically, a flat fabric is run through a pleating machine that is provided with knives. The fabric is scored with the knives, to produce the textured or pleated effect, which is preserved by heat treating the scored fabric to a temperature of about 250°–300° F. The pleated fabric is sandwiched between holding paper and rolled for storage, so that the pleats retain their shape without damage.

The wire filament can be any flexible filament that will hold its shape without breaking when bent or twisted. The preferred wire filament of the invention is galvanized steel, which can range in gauge from about 22 to 32. The wire filament should be both strong and light, and the most suitable compromise according to the invention, for ribbons ranging in width from 2 to 7 inches, is gauge 26 galvanized steel wire.

The trim filament of the invention can be any known decorative thread of a suitable strength and thickness, which can be wound around the wire filament and through the fabric on a needle, without breaking or snagging, and with enough weight and body to substantially or completely cover the wire filament. Metallic threads are particularly suitable, especially those comprising a metallic strand wrapped with one or two nylon strands. It has been found that a metallic strand that is 1/69th of an inch thick (about 150 gauge) that is wrapped with one, preferably two strands of 70 denier nylon strands is especially preferred. Non-metallic threads can also be used. According to the invention, threads ranging in thickness from 1/100th to 1/50th of an inch, and wrapped with one or two strands (or ends) of nylon ranging from 50 to 90 denier can be used.

The binding filament can be any filament chosen for strength and light weight, and preferably is one strand of monofilament ranging in thickness from 0.005 mil. to 0.009 mil. The preferred monofilament is 0.007 mil. in thickness.

The novel decorative ribbon of the invention is made by binding the wire filament and the trim filament to the fabric ribbon with the binding filament in one operation that both fixes the wire to the edge of the fabric, and hides the wire from view by covering it with turns of trim filament. This is done on a feed-driven stitching machine that is specially modified according to the invention, as further described below. Thus, the stitching machine supplies the fabric ribbon with a co-extensive length of wire filament that is simultaneously bound to the fabric by the binding filament and covered over by the trim filament.

The invention and specific examples and embodiments thereof are further described in connection with the following drawings and detailed description.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. **1** shows a prior art ribbon with the edge of the ribbon folded over the wire to form a sleeve and seam.

FIG. **2** shows the underside of a decorative ribbon according to the invention with a wire bound to the edge of the fabric and covered over with trim.

FIG. **3** shows a side view of an apparatus according to the invention.

FIG. **4** shows an enlarged top view of a portion of FIG. **3**, showing a needle plate according to the invention.

FIG. **5** shows an enlarged bottom view of a portion of FIG. **3**, showing a needle plate according to the invention.

FIG. **6** shows an enlarged side view of a portion of FIG. **3**, showing a needle plate according to the invention.

FIG. **7** shows a representative decorative ribbon

DETAILED DESCRIPTION OF THE INVENTION

Referring to FIG. **2**, there is shown a portion of a decorative ribbon including an edge wire secured according to the present invention. The ribbon material **10** includes an actual edge **11** and a side edge **12**. In this particular embodiment, a galvanized steel wire filament **14** is positioned along the actual edge **11** of the ribbon material **10** and is surrounded by a smooth fold created by the side edge **12**. The ribbon material **10** is secured to the wire filament **14** by a sewing stitch, such as the purl stitch shown. In this embodiment, the stitch includes two filaments, a decorative trim filament **18** and a binding filament **20**.

The purpose of the trim filament **18** is to substantially or entirely cover the wire filament **14**, the side edge **12** and the

actual edge **11**, thereby providing a clean, continuous and decorative edge to the ribbon material **10**. This can be achieved, as shown, by positioning the trim filament **18** in a curved serpentine fashion around both the wire filament **14** and the side edge **12** of the ribbon material **10**. The serpentine shape of the trim filament includes loops **22**.

During the stitching process, the binding filament **20** pierces the ribbon material **10** and inter-weaves through the serpentine loops **22** of the trim filament **18**. The binding filament **20** is kept taut during the stitching process, and the trim filament **18** and the interposed edge portion of the ribbon are pulled into engagement with the inner wire filament **14**. In this way, the decorative trim filament **18** becomes substantially wrapped around the otherwise exposed side edge **12** and the actual edge **11** of the ribbon material **10**, all of which are securely bound together by the binding filament **20**. Thus, the tight stitch created by the binding and trim filaments, acting together, secures the wire filament **14** to the ribbon material **10**. In a preferred embodiment, the binding filament is a natural monofilament, chosen for its strength and also because it is effectively invisible. This allows the trim filament to be seen, so that the ribbon is provided with a securely wired . and decorative edge.

Thus, according to the invention, resulting decorative ribbon product provides a tightly secured hidden wire filament **14** along each edge of the ribbon material to support the ribbon's shape, and a decoratively disguised stitch that permits dual-side ribbon applications.

FIG. **7** shows a portion of a finished ribbon product having the edge wire arrangement of the present invention. As shown, both sides of the ribbon have an even and clean appearance showing no ribbon edge material.

In contrast to the invention, FIG. **1** shows a typical prior art wire-edged ribbon which includes an exposed securing stitch and actual ribbon edge.

In this figure, a wire **100** is surrounded by a fold **102** created along the actual edge **103** of ribbon material **104**. The fold **102** is secured flat against the underside (topside as shown in FIG. **1**) of the ribbon material **104**, near the actual edge **103** using a conventional straight stitch **106**. Since no tight frictional force has been applied to the enclosed wire **100**, the wire is free to move laterally which could cause the straight stitch **106** to loosen. The wire arrangement shown in FIG. **1** can also move linearly (in a direction parallel to the ribbon edge) which could cause the wire **100** to become completely detached from within the fold **102**. In either case, the straight stitch **106** and the actual ribbon edge **103** are in full view along the under side of the ribbon material **104**. The resulting finished decorative ribbon product is therefore limited to one-side applications, and has a much less desirable non-uniform appearance. It also suffers from weaknesses in construction that the invention has overcome.

The present invention also provides an improved adaptation to a conventional high speed stitching machine to create the secured wire ribbon-edge arrangement of the present invention. Two examples of such a machine are the Merrow High Speed Trimming & Overseaming Machine (class M) manufactured by the Merrow Company of Hartford, Conn., and the Pegasus S32 manufactured by the Pegasus Sewing Machine Manufacturing Co., Ltd. of Osaka, Japan.

The stitching machine **30** is shown in FIG. **3**, adjacent to guide rollers **32** and includes a work plate **34** for supporting the ribbon material **10**, a moveable sewing needle **36**, a feed carrier **38** for feeding the ribbon material **10** and a needle plate **40** which is typically recessed into and coplanar with the work plate **34**.

The guide rollers **32** are preferably power driven using conventional methods so that the ribbon material **10** is drawn from the work plate **34** of the stitching machine **30** in time with the stitching operation. The purpose of the rollers **32** is to maintain tension in (prevent buckling) the ribbon material **10** during and after it has been stitched. If the ribbon material **10** is not pulled from the stitching machine **30**, the stitch can become distorted or otherwise uneven and unattractive and the various elements of the invention (ribbon, wire and filaments) will not be secured in a satisfactory manner.

The drive speed of the rollers **32** is dictated by the feed rate established by the internal feed carrier **38** (not shown in detail), typically protruding from within the needle plate **40**. The feed carrier **38** pulls the ribbon material **10** from a supply roll (not shown). It is conventionally known that the drive speed of the guide rollers **32** and the feed rate of the feed carrier **38** should be matched during high speed edge stitching so that the ribbon material **10** can be drawn from the supply roll, stitched, and drawn to a collection roll (also not shown) in a smooth flow.

As understood in the stitching industry, a typical edge stitch comprises two filaments of thread. One thread is usually supplied to the fabric (in this case to the ribbon material **10**) by "loopers" from below the needle plate **40** (not shown), while the other thread is fed to the needle **36** usually above the needle plate **40**. In the present invention, the first thread (below the needle plate **40**) is preferably the trim filament **14** and the second thread (fed to the needle above the needle plate **40**) is preferably the binding filament **20**. The normal operation of the stitching machine **30** provides a conventional stitch by interweaving the binding filament **20** with the trim filament **18**, as further described below.

By the present invention, a wire filament **14** is provided within the fold of the side edge **12** of the ribbon material **10**, before the stitch is produced by the stitching machine **30**. It is desireable to form the side edge **12** of the ribbon material around the wire filament **14** immediately prior to the stitch so that a consistent and even ribbon edge can be secured by the stitching filaments without the need for expensive and complex assemblies to maintain the shape of the side loop **12** during its feed to the needle plate **40**.

The present invention provides a needle plate **40** which has been improved such that a wire filament **14** can be guided to and incorporated with the side edge **12** of the ribbon material **10** during the stitching process. The needle plate **40** of the present invention is shown in FIGS. **4–6**. The needle plate **40** includes a top portion **42** having conventional fabric engagement teeth **44**, a feed carrier access slot **46**, a fabric support tine **48** for supporting the fabric (ribbon material) adjacent to the moving needle, and a needle stitching slot **49**. The needle plate **40** also includes a side portion **50** and a bottom portion **52**. The side portion **50** includes a side groove **54** along the side of the support tine **48**. The side groove **54** is of proper dimensions to effectively guide a sliding wire filament of a chosen size from a wire filament source (not shown) to the ribbon material **10**, specifically along the ribbon's edge. A similarly shaped bottom groove **56** is disposed substantially inline with that of the side groove **54**. As shown in FIG. **5**, the wire filament **14** is guided by both side and bottom grooves **(54, 56)** without stress or deformation. The wire filament **14** is first guided from its source, and under the work plate **34** (FIG. **3**), by the bottom groove **56** along the bottom portion of the needle plate **40** and then, by the side groove **54** along the side of the support tine **48** following a gradually inclined

direction. The wire filament **14** eventually becomes located adjacent to the top portion of the needle plate **40** where it can easily be positioned within a fold of the ribbon's side edge **12** and secured to the ribbon material **10** during the stitching process.

Referring to FIGS. **2** and **3**, one edge **11** of the ribbon material **10** is folded towards the center of the ribbon (downwardly in a preferred embodiment), forming a side edge **12** through which the wire filament **14** may positioned and secured. It is known in the stitching industry to loop the edges of a fabric. Any of the known techniques can be incorporated with the stitching machine **30** so that a side edge **12** of the ribbon material **10** is formed around the wire filament **14** just prior to the stitching process. It is preferred, however that the fold in the side edge **12** be limited according to the size of the wire used. It is preferable that with any wire used, the side edge **12** be such that when it is in tight engagement around the wire filament **14**, the actual edge **11** of the of the ribbon material **10** will at most, just contact the surface of the adjacent ribbon material **10**. If a larger fold is formed, the ribbon material **10** may buckle and fold when it overlaps the ribbon material **10** and an undesirable seam will result. Such buckling may also cause the secured ribbon edge to be uneven and could create spots along the wire filament **14** where the ribbon material is not in tight engagement with the wire.

In operation, a supply of an appropriate decorative trim filament **18** and a supply of binding filament **20** are loaded in a conventional manner into a standard stitching machine, like the preferred Merrow or Pegasus machine. A wire filament **14** is fed through the needle plate **40**, guided by both the side groove **54** and the bottom groove **56** and is ultimately drawn with the ribbon by the rollers **32**. The ribbon material **10** is positioned in a conventional manner onto the work plate **34** of the stitching machine **30**. As the machine operates, the edge of the ribbon material **10** is formed into a fold around the adjacent wire filament **14**. The previously described stitch is then produced around the edge loop **12** and the enclosed wire **14**. The stitching process creates the necessary pull required to ensure tight engagement between the wire filament **14** and the ribbon material **10**.

The tightness of the stitch can be regulated by adjusting the cams of the stitching machine. In a preferred embodiment, the cams are adjusted so that the trim filament is wrapped tightly, with each turn of the filament just touching or overlapping each adjacent turn, so that the wire and the edge of the ribbon are covered over. It will also be appreciated by skilled practitioners that more than one trim filament or binding filament can be used on each edge of the ribbon. Preferably, one or two trim filaments is used and one binding filament is used.

Although preferred embodiments of the invention are described in detail herein, it will be appreciated by skilled practitioners that the invention can also be practiced in other embodiments, and the present examples do not serve to narrow the appended claims.

We claim:

1. A decorative ribbon comprising:

a web of ribbon material having two faces and a folded edge therebetween;

a wire filament disposed along and within said edge; and

stitch means for securing the edge of the web to said wire filament, said stitch means including a trim filament, said trim filament substantially covering the edge and the wire filament from view from at least one said face,

and a binding filament passing through said web proximate to said edge and interlocking with the trim filament to secure the wire filament and the trim filament to the edge, said binding filament and trim filament being of different constructions.

2. A method of securing a wire filament along an edge of a fabric ribbon, comprising the steps of:

positioning a wire filament adjacent to and in parallel contact with said edge;

folding the edge of the ribbon around the wire filament such that at least some of the circumference of the wire filament is coextensive with and covered by the ribbon, thereby creating a sleeve of fabric for engaging the wire filament; and

stitching said wire filament to said edge using at least two additional filaments, such that the wire filament is in tight engagement with the edge, said stitching step including, in a single continuous operation, passing a trim filament at least partially around the edge and the wire filament, said trim filament covering substantially all of the wire filament from view from at least one face of the ribbon, and passing a binding filament through the ribbon proximate the edge, and intermingling said binding filament with the trim filament and the wire filament to secure the wire filament to the edge.

3. A method of securing a wire filament along an edge of a web of fabric ribbon having top and bottom faces and at least a first edge therealong, said method comprising the steps of:

positioning a wire filament along said web of fabric in parallel relationship with and adjacent to said first edge of said web; and

stitching said wire filament to said fabric web using at least two additional filaments, such that said wire filament is in tight engagement with of said web, said stitching step including, in a single continuous operation:

passing a binding filament through said web and around said wire filament to secure said wire filament against said web, and

interlocking a trim filament with said binding filament along said web such that said trim filament substantially covers said wire filament and said edge from view along at least one of said faces.

4. A method as claimed in claim 3, wherein said wire filament is positioned along said bottom face of said web.

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