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"Method for coating shaving parts of an electric dry shaver with a solid lubricant preparation"

The invention relates to a method for coating the shaving parts of an electric dry shaver with a solid lubricant preparation.

From CH-A-519 582 covering the whole surface of the shaving parts of an electric dry shaver with solid lubricant by electroplating is known.

The disadvantage of this method is that the shaving parts so coated also have solid lubricant coating on the cutting teeth and within the hair entrance apertures. In the first instance this leads to a rounding of the cutting teeth and in the latter instance to a narrowing of the hair entrance apertures, altogether this leads to a considerable lessening of the shaving capability.

The invention has the object of providing a method of coating shaving parts of an electric dry shaver with a solid lubricant preparation by clearance of the cutting teeth and avoidance of a narrowing of the hair entrance apertures, whereby such apertures can be spaces between the teeth of comb-type shaving parts or screen holes in shaving foils.

The invention performs this object by introducing the solid lubricant preparation by means of a gauze lying on the shaving parts on the upper surface of the shaving part which is to be coated.

The solid lubricant preparation penetrates through the gauze and adheres only to the upper surface of the shaving part lying beneath it whilst it (the lubricant) remains stuck to the gauze in the hair entrance apertures.

In shaver foils with extended edges the adhesion of the solid lubricant preparation on the extended edges is taken off with the removal of the gauze.

The gauze is preferably made of polyester fibres.

Advantageously the viscosity of the solid lubricant preparation amounts to 10 to 14 Pascal-seconds, measured with a Haak rotation viscosimeter.

In a further construction of the invention a solid lubricant preparation which hardens to a firm coating, described in the trade as 'slide lacqueur' , is used.

For the coating of shaving foils a gauze with a mesh opening of 45 - 50 micrometers and a thickness of 90-05 micrometers is preferred.

For the coating of comb-type shaving parts a gauze with a mesh opening of 25-30 micrometers and a thickness of 67-72 micrometers is preferred.

Example 1

A gauze of polyester fibres with a mesh opening of 49 micrometers and a thickness of 93 micrometers is laid on the under side of a shaving foil with extended edges and a molybdenum disulphide in 40% by weight is

introduced in a preparation containing a binding agent hardened by air, with a viscosity of 10 Pascal-seconds. The preparation is pressed through the gauze by a rubbing tool. Then the gauze is taken off. The shaving foil is kept in an air-circulating oven at 100°C for 20 minutes. You obtain a shaving foil in which only the groove between the extended edges is coated with a firm solid lubricant.

Example 2

A gauze of polyester fibres with a mesh opening of 27 micrometers and a thickness of 70 micrometers is laid on the top side of a blade of a long hair cutter and a molybdenum disulphide in 40% by weight is introduced in a preparation containing a binding agent hardened by air, with a viscosity of 10 Pascal-seconds. The preparation is pushed through the gauze by a rubbing tool. Then the gauze is taken off. The blade is kept in an air-circulating oven at 100°C for 20 minutes. A blade of a long hair cutter is obtained in which only the top side is coated by a firm solid lubricant whilst the openings between the teeth are uncoated.



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Claims

1. A method for coating the cutting parts for an electric dry shaver with a preparation containing a lubricant, characterised in that the preparation containing lubricant is applied to the surface of the cutting parts to be coated by means of a gauze lying on the cutting parts.
2. A method according to claim 1, characterised in that a gauze of polyester fibres is used.
3. A method according to claims 1 and 2, characterised in that a preparation with a viscosity of 10-14 Pascal seconds, measured by a Haak rotation viscosimeter, is used as the preparation containing lubricant.
4. A method according to claims 1 to 3, characterised in that a preparation which hardens to a solid coating is used as the preparation containing lubricant.
5. A method for coating shaving foils, the apertures of which have extended edges, according to claims 1 to 4, characterised in that a gauze is used with a mesh of 45-50 micrometers and a thickness of 90-95 micrometers.
6. A method for coating comb-like cutting parts according to claims 1 to 4, characterised in that a gauze is used with a mesh of 25-30 micrometers and a thickness of 67-72 micrometers.