

D. H. PEARCE & A. W. TAFT.  
Center-Rim for Watch-Case.

No. 202,458.

Patented April 16, 1878.

Fig. I.

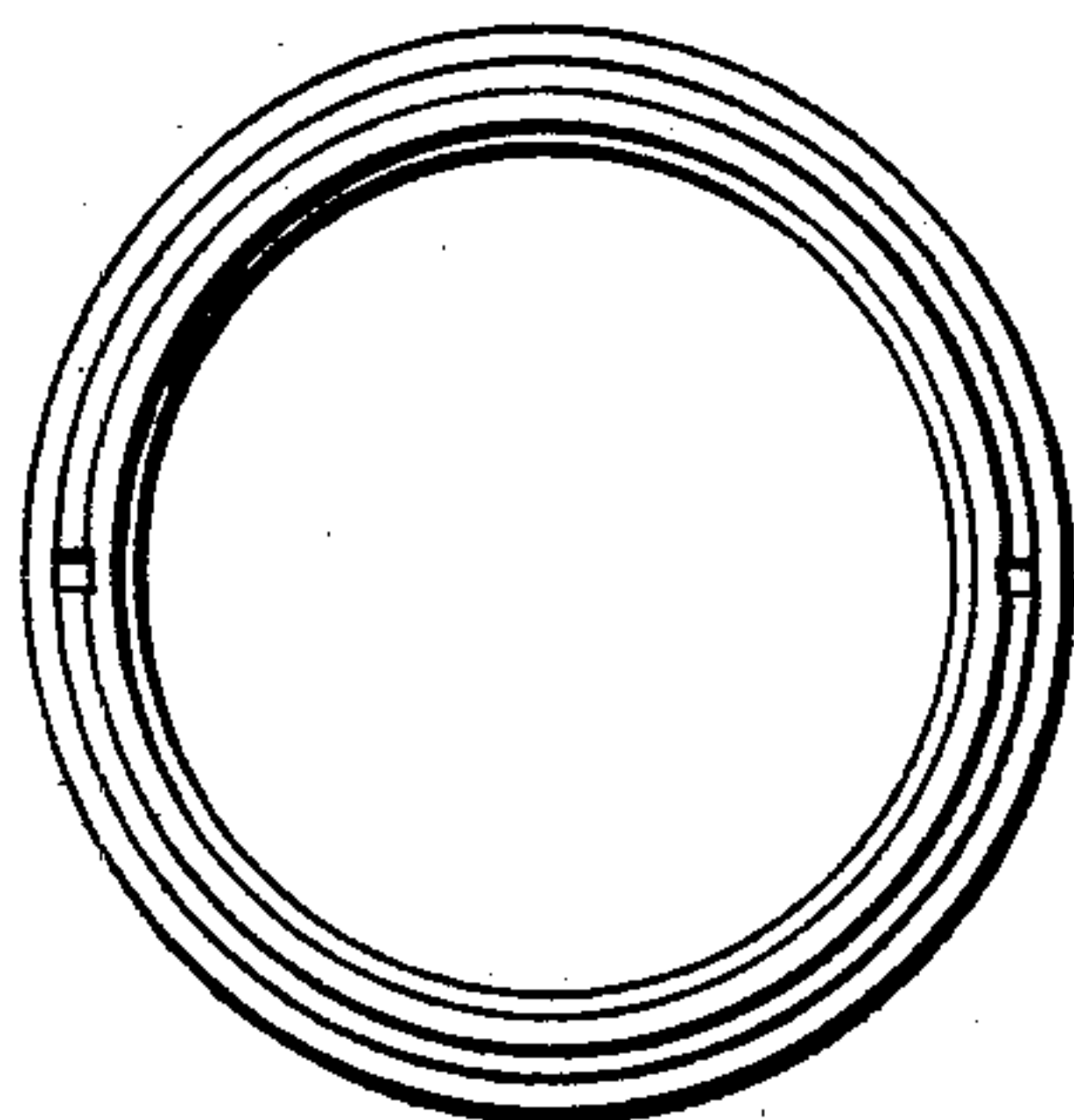


Fig. II.

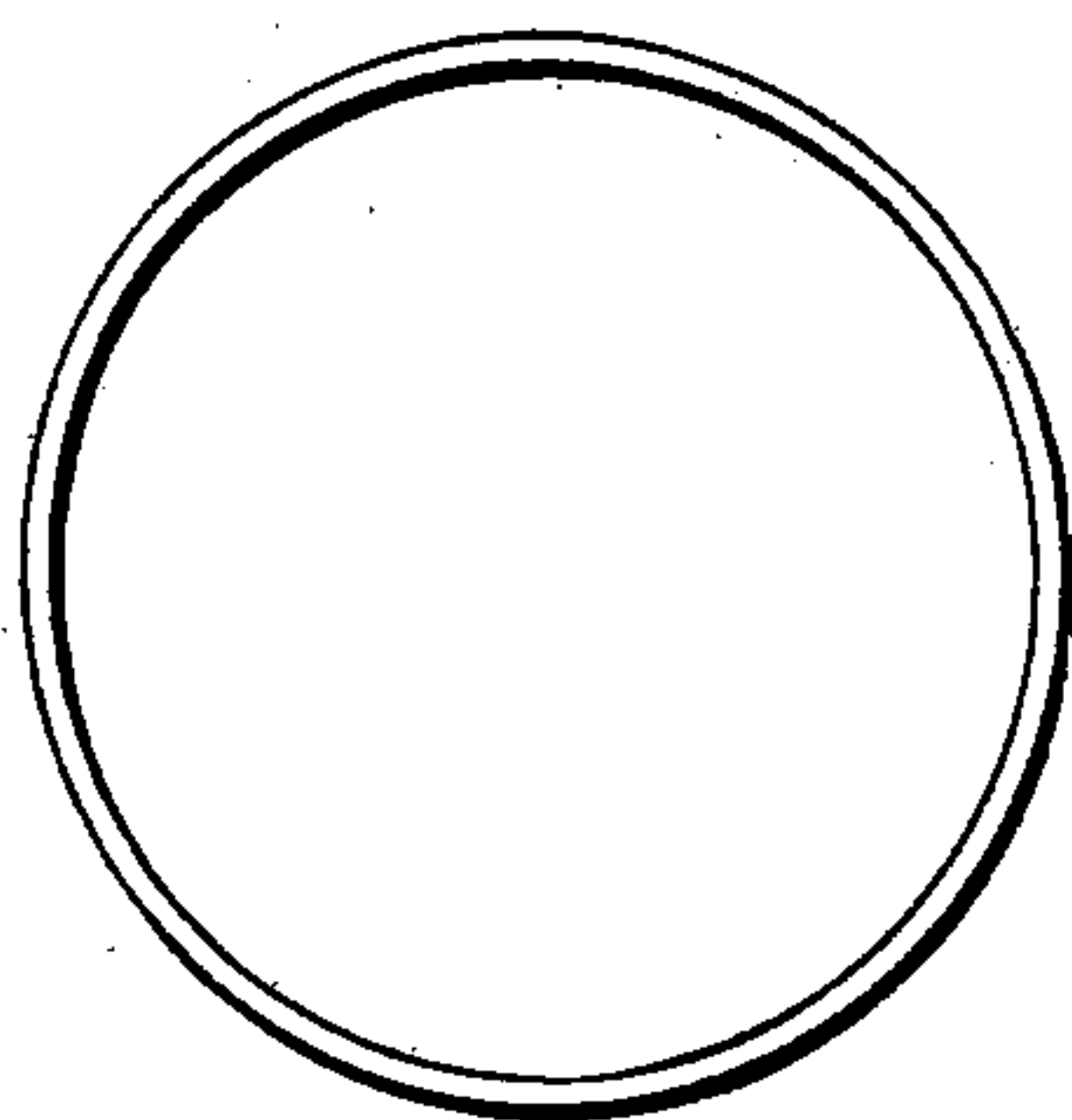


Fig. III.

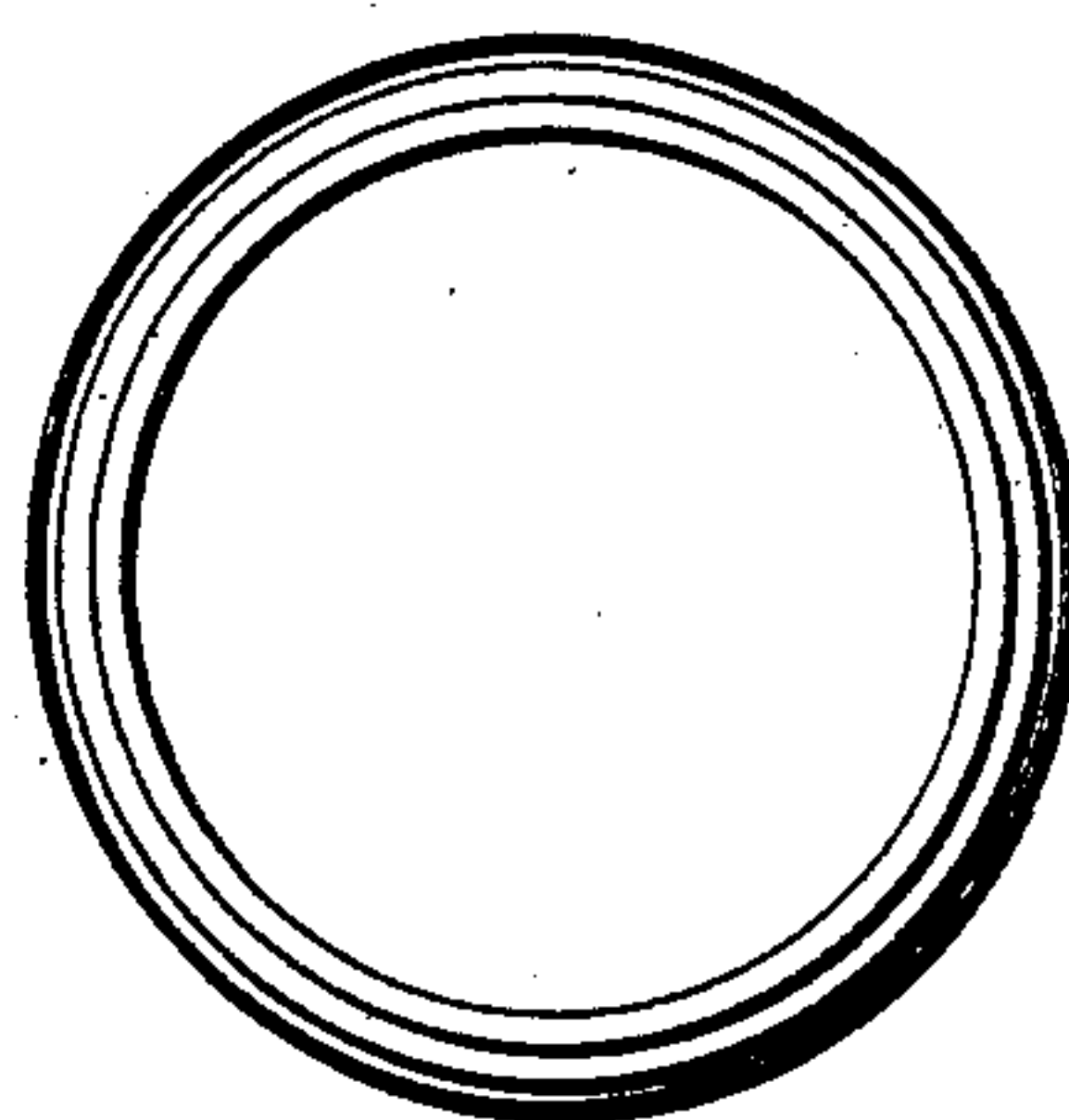
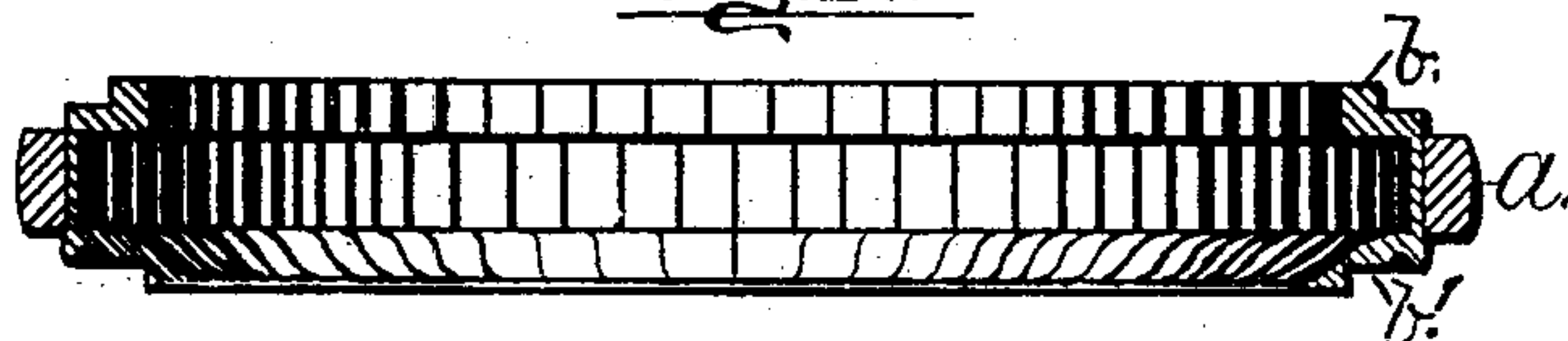


Fig. IV.



WITNESSES.

Henry J. Miller  
Joseph A. Miller Jr.

INVENTOR.

David H. Pearce

Alanson W. Taft  
by Joseph A. Miller  
Attorney

# UNITED STATES PATENT OFFICE.

DAVID H. PEARCE AND ALANSON W. TAFT, OF PROVIDENCE, R. I.

## IMPROVEMENT IN CENTER RIMS FOR WATCH-CASES.

Specification forming part of Letters Patent No. **202,458**, dated April 16, 1878; application filed July 5, 1877.

*To all whom it may concern:*

Be it known that we, DAVID H. PEARCE and ALANSON W. TAFT, both of the city and county of Providence and State of Rhode Island, have invented new and useful Improvements in Center Rims for Watch-Cases; and we hereby declare that the following is a full, clear, and exact description of the same, reference being had to the accompanying drawings, forming part of this specification.

This invention consists in the novel construction of the center rim, by which the two side bands are made in one piece of sheet metal, and the soldering of each side band to the center bead avoided, as will be more fully set forth hereinafter.

Figure 1 represents the center rim with the side bands on one side, and Fig. 2 the opposite side of the same. Fig. 3 is a view of the center bead; Fig. 4, an enlarged sectional view of the center rim, showing the center bead and the side bands.

The center rim for watch-cases is that central portion to which the works of the watch, the bezel to hold the watch-glass, and the inner cover, as well as the outer cover, are secured; and consists of the center bead *a* and the two side bands *b* and *b'*. These side bands have heretofore been made separately, and were each secured to the center bead by soldering, requiring considerable time and skill. After they were secured to the center bead they were required to be finished so that the bezel and covers would accurately fit and spring on the bands.

In the manufacture of watch-cases it is important that all parts should at times be made of stock-plate, either of pure precious metal, alloys of metal, or of inferior metal covered at the sides with precious metal of the same or different grades of fineness.

Our improved side bands are formed out of strips of stock-plate, which is formed between suitable rollers by rolling or drawing so as to conform to the section required, and as the central portion uniting the two side bands can be reduced more in thickness than the rest, the metal forms a spiral, from which the rings are cut, the ends soldered together, and the whole finished in suitable dies, when the center bead is forced over the side bands, and thus firmly secured, making a stronger, better, and cheaper center rim than when the two side bands are separately made and secured to the center bead.

Having thus described our invention, we claim as new and desire to secure by Letters Patent—

In a center rim for watch-cases, the combination, with the two side bands *b* and *b'*, made of one piece of drawn or rolled metal, of the center bead *a*, substantially as and for the purpose described.

DAVID H. PEARCE.  
ALANSON W. TAFT.

Witnesses:

JOSEPH A. MILLER,  
JOSEPH A. MILLER, Jr.