

(No Model.)

J. H. POWELL & D. H. BARNET.
Finger Ring and the Art of Manufacturing the Same.

No. 237,318.

Patented Feb. 1, 1881.

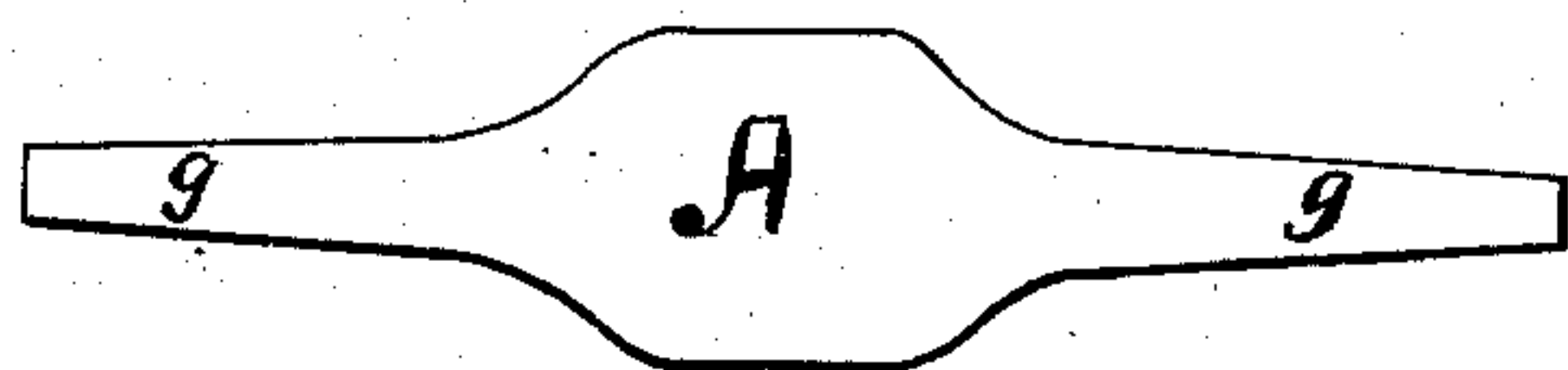


fig. 1.

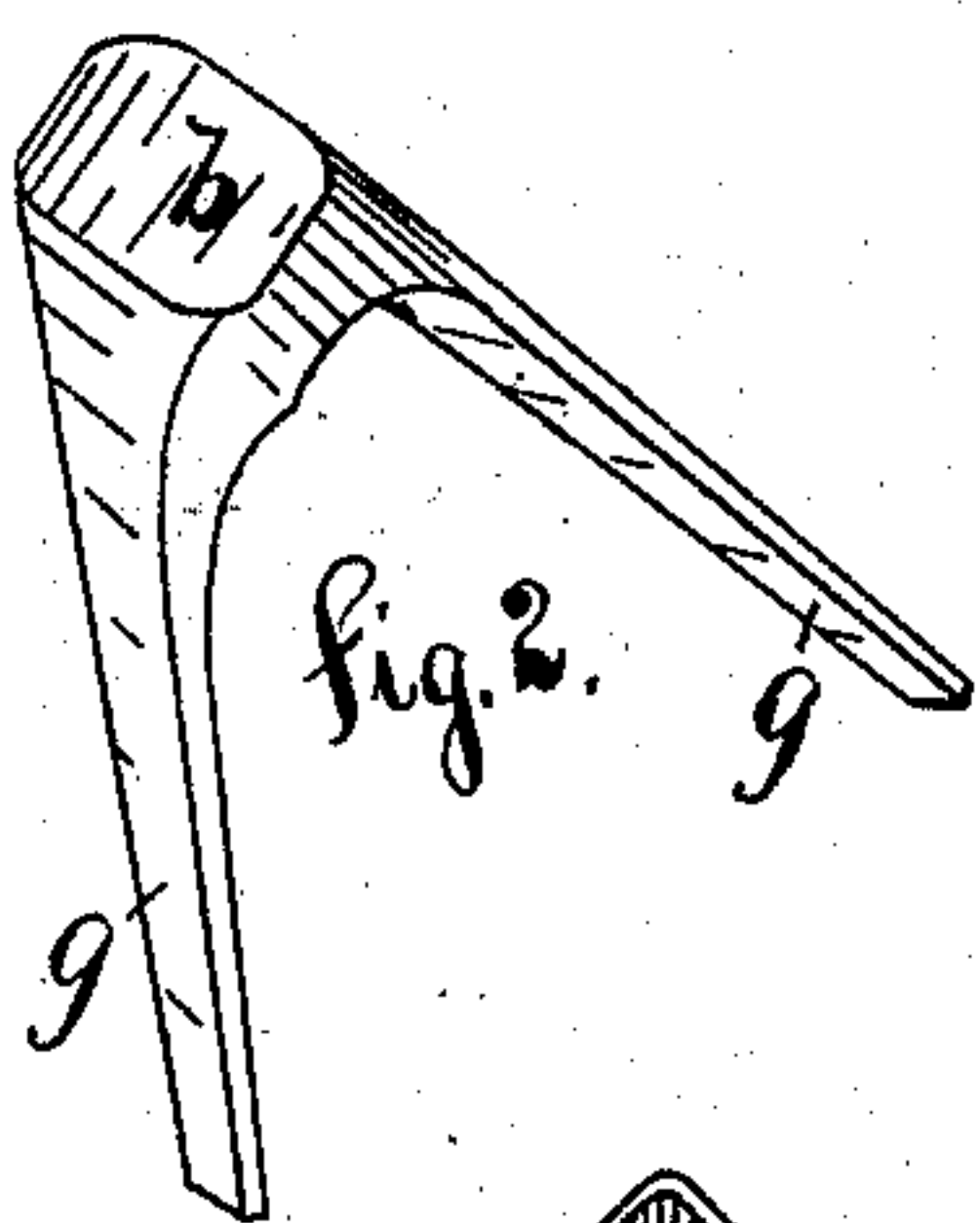


fig. 2.

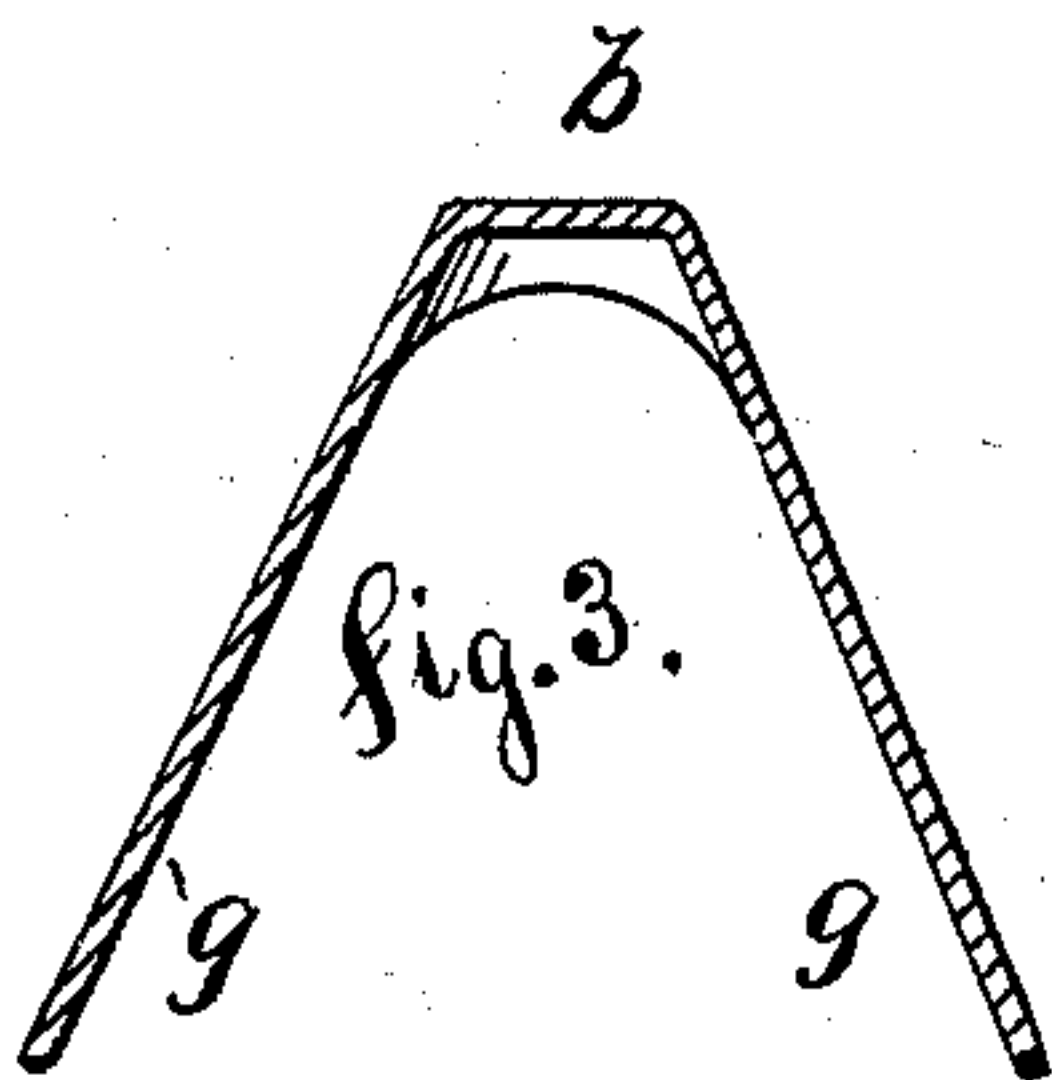


fig. 3.

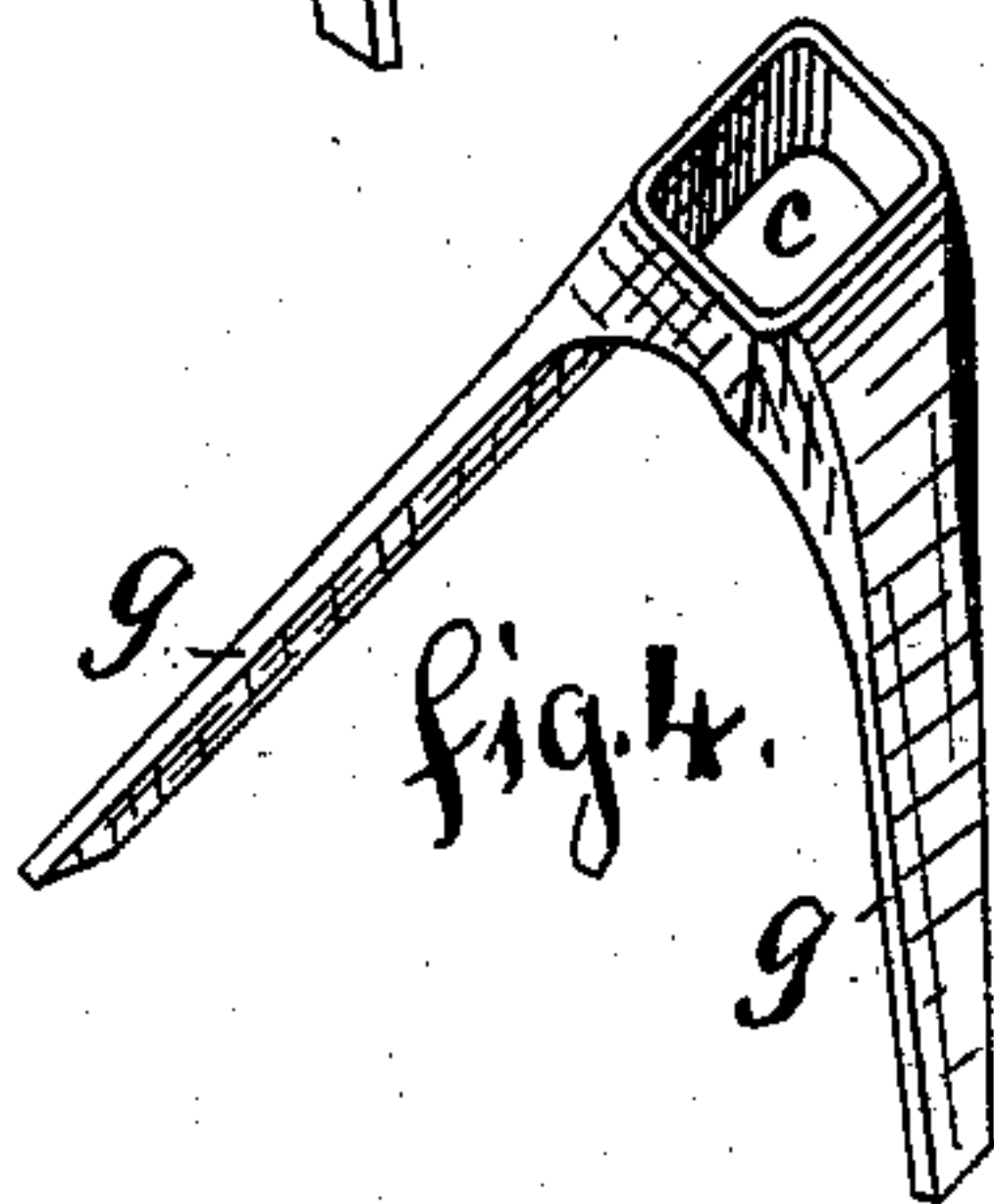


fig. 4.

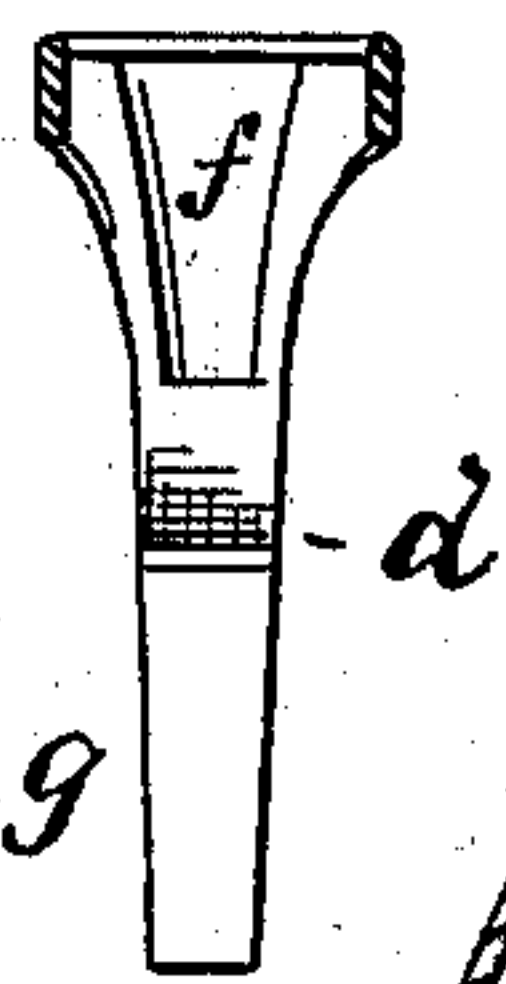


fig. 5.

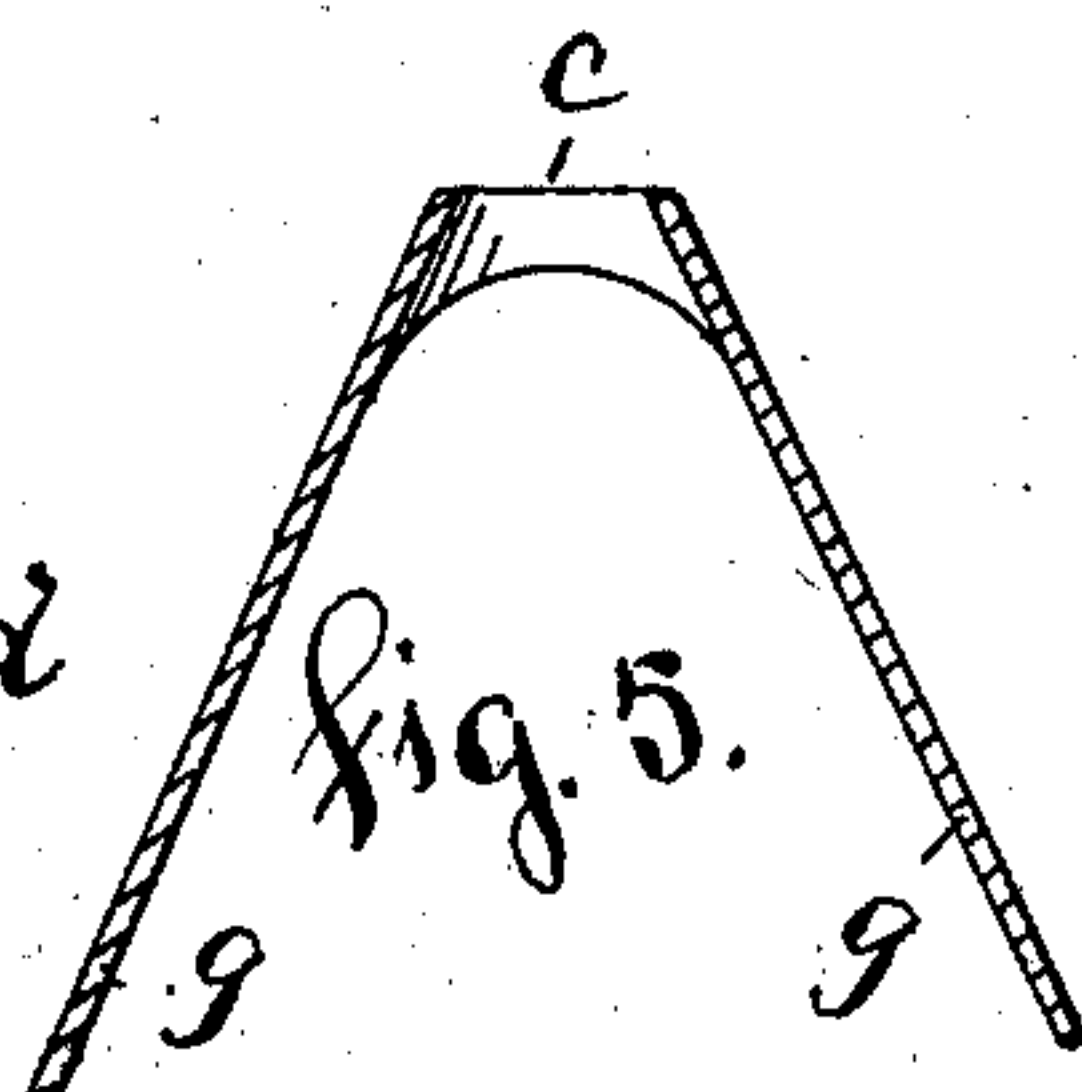


fig. 6.

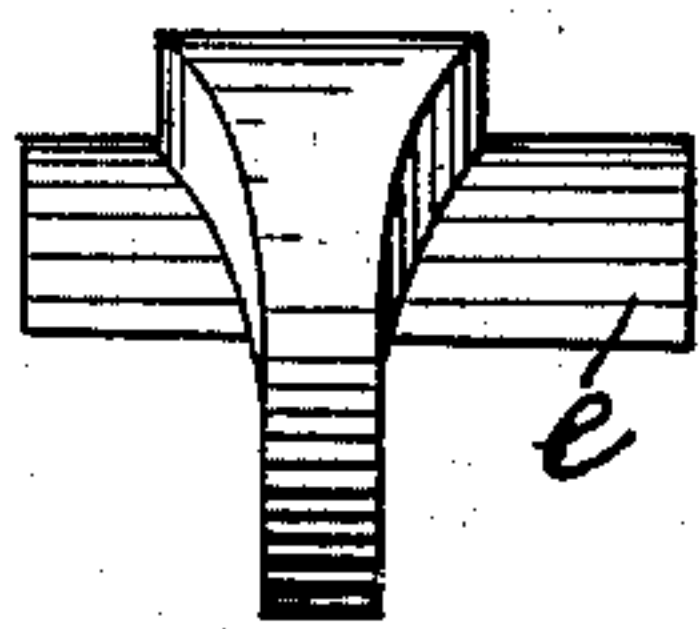


fig. 7.

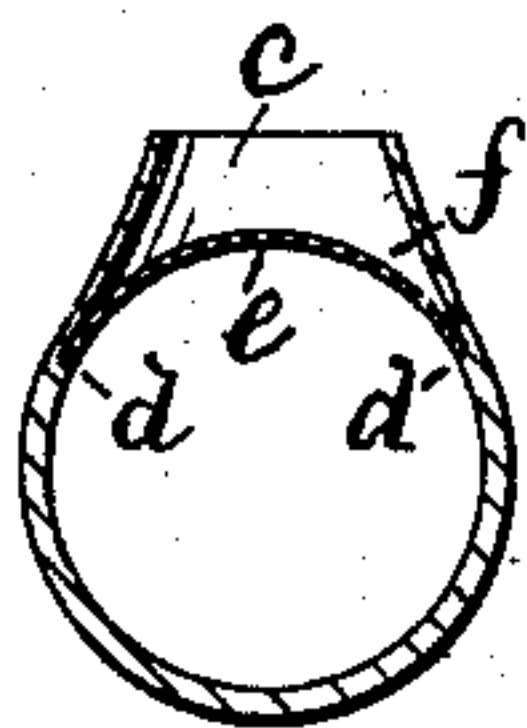


fig. 8.

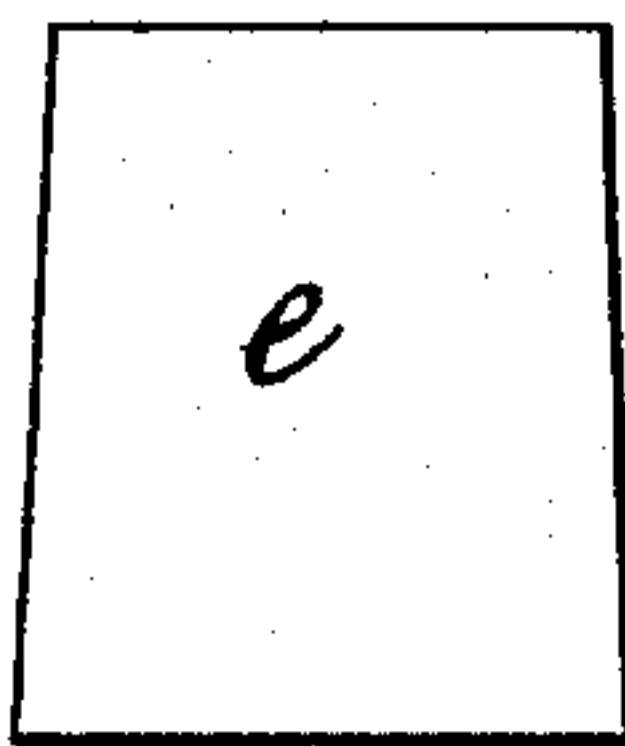


fig. 9.

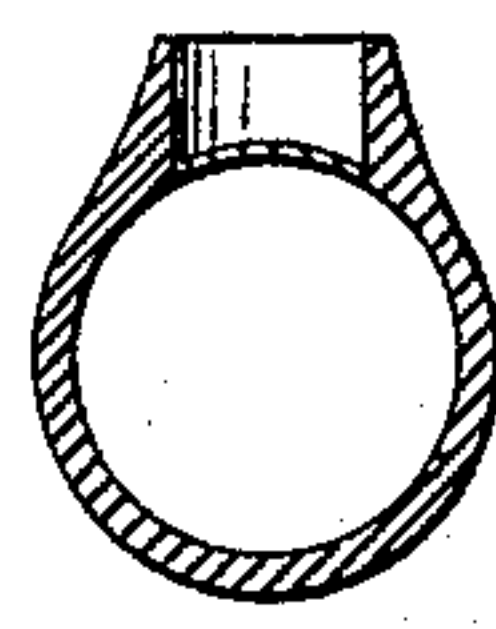


fig. 10.

Witnesses:
Charles H. Bell
Chas. Heir



fig. 11.

Inventors:
James H. Powell,
David H. Barnett,
By O. Drake, Att'y.

UNITED STATES PATENT OFFICE.

JAMES H. POWELL AND DAVID H. BARNET, OF NEWARK, NEW JERSEY.

FINGER-RING AND THE ART OF MANUFACTURING THE SAME.

SPECIFICATION forming part of Letters Patent No. 237,318, dated February 1, 1881.

Application filed May 7, 1880. (No model.)

To all whom it may concern:

Be it known that we, JAMES H. POWELL and DAVID H. BARNET, of Newark, in the county of Essex and State of New Jersey, have invented certain new and useful Improvements in Finger-Rings and the Art of Manufacturing the Same; and we do hereby declare the following to be a full, clear, and exact description of the invention, such as will enable others skilled in the art to which it appertains to make and use the same, reference being had to the accompanying drawings, and to letters of reference marked thereon, which form a part of this specification.

The object of this invention is to reduce the cost of constructing finger-rings, more especially of the style known in the market as "solid English seal" or "marquis" rings, by greatly facilitating the operation of manufacturing the same, reducing the quantity of gold heretofore necessarily used in their construction, and by enabling a less skilled, and therefore a less expensive, workman to accomplish substantially the same results.

The invention consists in striking up a finger-ring having a solid shank and a head, substantially as hereinafter shown and described, from a sheet-metal blank of the thickness of the shank of said ring.

It also consists in a ring having notches in its shank, and a wedge-shaped lining-plate adapted to be driven into said notches.

It still further consists in a ring having a solid shank, (contradistinguished from a filled or hollow one,) a head having recesses extending a short distance into said shank, notches formed in the shank, and a wedge-shaped lining-plate fitted into said notches.

Heretofore the method of constructing the peculiar style of ring above mentioned was, first, to punch out or form a thick blank, such as shown in Figure 10 of the accompanying drawings, of the thickness of the depths of the head, then to form the aperture therein, as shown in said figure, and to reduce the thickness of the arms which form the shank by the tedious process of filing or swaging, in which there is a loss of gold. By this process the head of the ring will be finally brought to about the shape shown in Fig. 9, where, it will be observed, and especially if compared with

Fig. 7, the head is so formed as to require a large amount of gold in its construction.

In further reference to the drawings, which form a part of this application, and in which similar letters of reference indicate like parts in each of the several figures, Fig. 1 represents the thin metallic blank from which our ring is formed. Fig. 2 is a view of the blank after having been further formed by the die. Fig. 3 is a section thereof. Fig. 4 illustrates the third operation of striking out the head, leaving the aperture for the reception of the stone, Figs. 5 and 11 being sections of the same, the latter showing a recess impressed in one side of the wall of said aperture by the same operation. Fig. 6 is a side view, showing the wedge-shaped plate passing through the ring, forming a lining to the head; Fig. 7, a section of the same, showing notches into which the wedge-shaped plate is adapted to be forced; and Fig. 8, a plan of the before-mentioned plate before it has been bent to be inserted into the ring. Figs. 9 and 10 have been already referred to and explained.

In carrying out our invention, we first strike out the blank A, Fig. 1, from comparatively thin sheet metal. We then place the blank thus formed into the die, and form it into the shape shown in Figs. 2 and 3, the head having the covering *b*, as indicated. It is then placed into a third die or "force," having a projecting head, which projects down the shank as far as necessary, forming the recesses, as shown in Fig. 11. The metal from these recesses enters into and forms a material part of the metal necessary for the enlargement of the head of the ring, thereby requiring less metal for the formation of the head than would be required if the metal were not taken from the inside of the head, where its absence, or the recess made by its absence, will not be noticed. This die also strikes out the covering *b*, leaving the aperture *c* for the reception of the stone.

Into the interior surface of the shank are formed notches *d*, for the reception of the plate *e*, which forms a lining for the head of the ring. One great advantage of the plate *e* extending down upon the shank is shown in the fact that it makes a much shorter soldering-joint, which can be more easily and quickly perfected, and leaves no "pin-holes," and is therefore neater in

appearance than those made by the old method. The plate *e* we prefer to make slightly tapering or wedge-shaped, as shown in Fig. 8, thus adapting said plate to be driven by any extraneous force into the notches *d*, which taper correspondingly, and thus enable a perfect joint to be produced with facility. After this the arms are united to form the shank, the plate soldered fast to the body of the ring, and trimmed off to conform to the shape of the ring, and the whole finished off in the usual manner, ready for the wearer.

Having thus described our invention, what we claim, and wish to have secured by Letters Patent, is—

1. As an improvement in the art of making finger-rings, the method consisting in striking up, by means of a die, a solid shank and a head from a metal blank of the thickness of the shank, then simultaneously striking out the head and forming recesses in the inside of the

ring next to the head, and finally securing a plate under the head, substantially as and for the purpose set forth.

2. In a finger-ring having a head and a shank, a wedge-shaped lining fitted under the head into correspondingly-shaped notches formed in the shank, substantially as and for the purpose set forth.

3. In a finger-ring having the recesses *f* and notches *d*, the plate *e*, fitted under the head and into notches *d*, substantially as and for the purposes set forth.

In testimony that we claim the foregoing we have hereunto set our hands this 29th day of April, 1880.

JAMES H. POWELL.
DAVID H. BARNET.

Witnesses:

OLIVER DRAKE,
CHARLES H. PELL.