

(No Model.)

J. C. DUEBER.
WATCH CASE CENTER.

No. 290,870.

Patented Dec. 25, 1883.

Fig. 2.

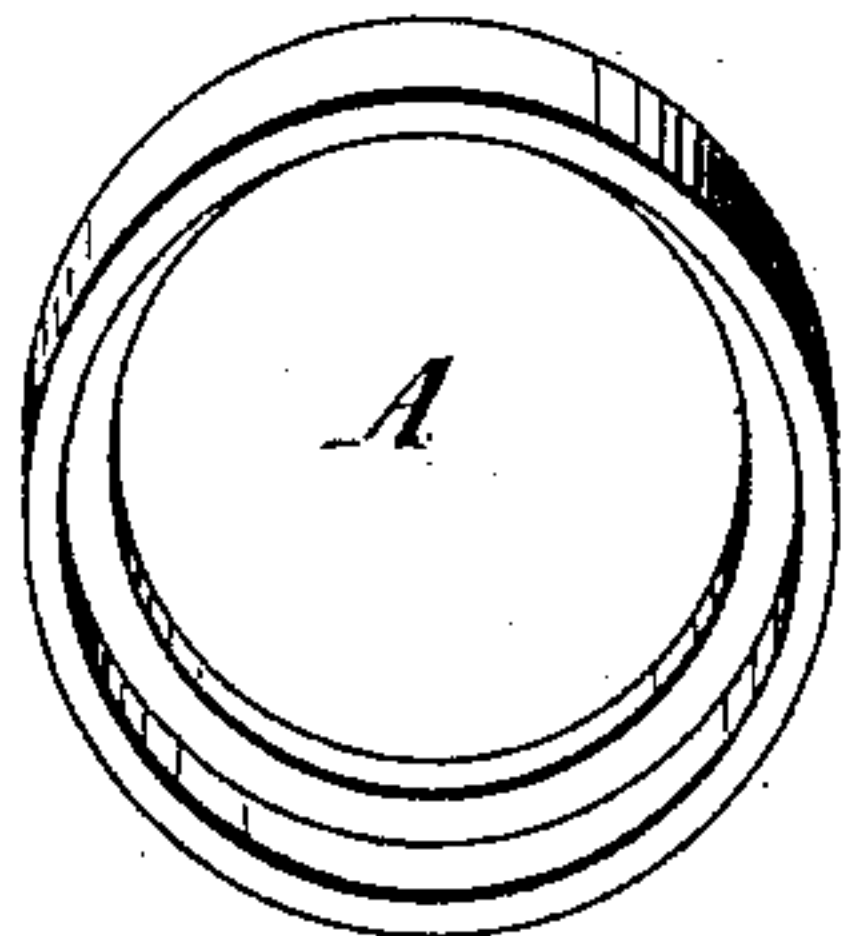


Fig. 1.

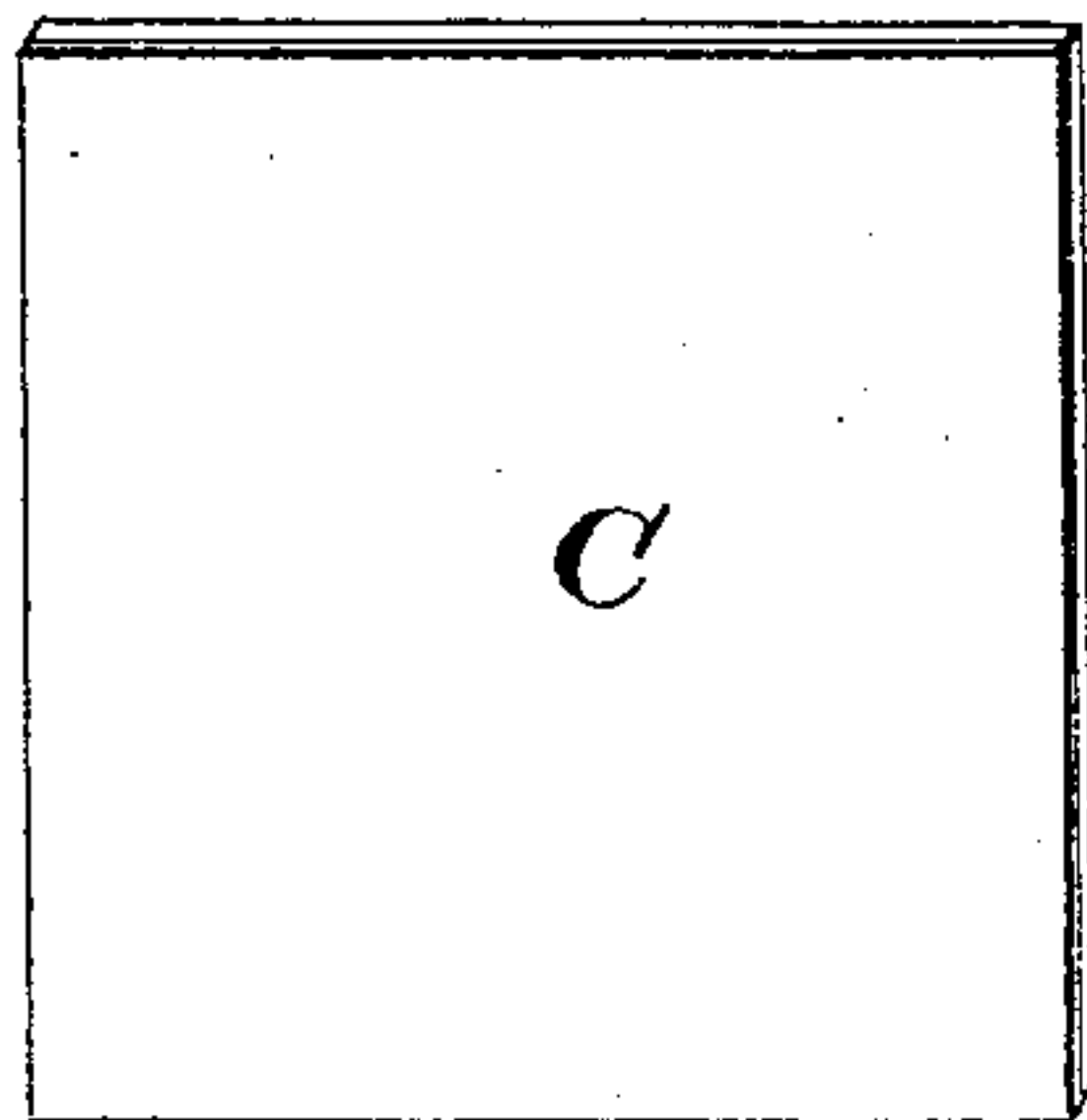


Fig. 3.

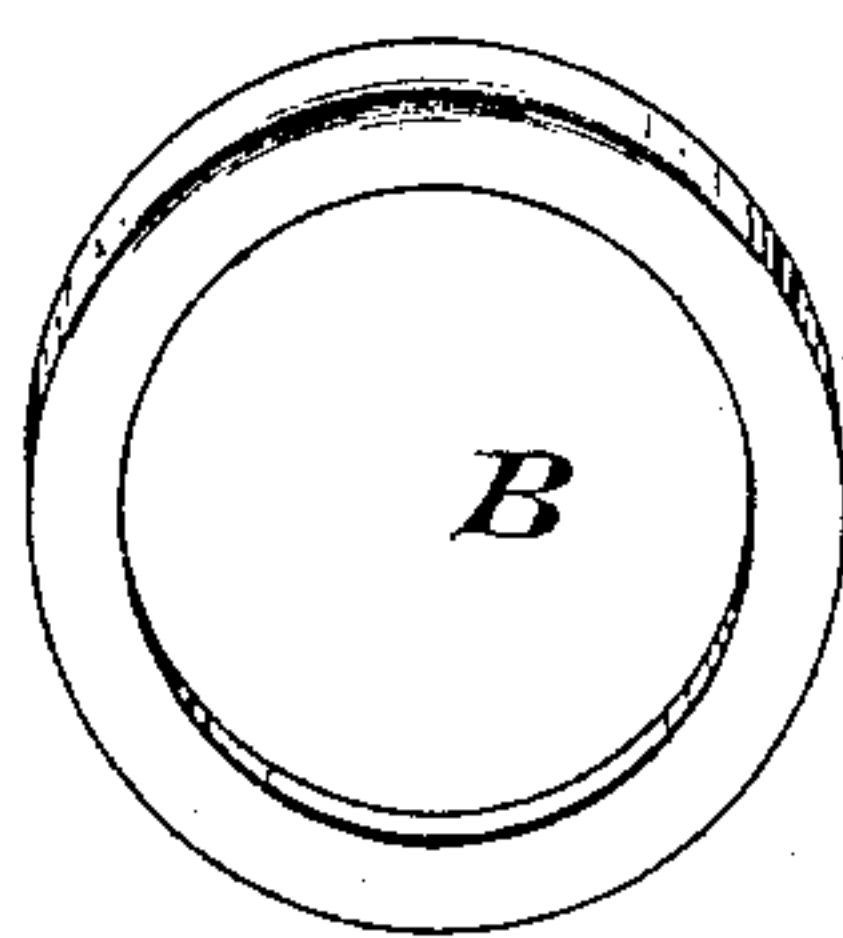


Fig. 5.

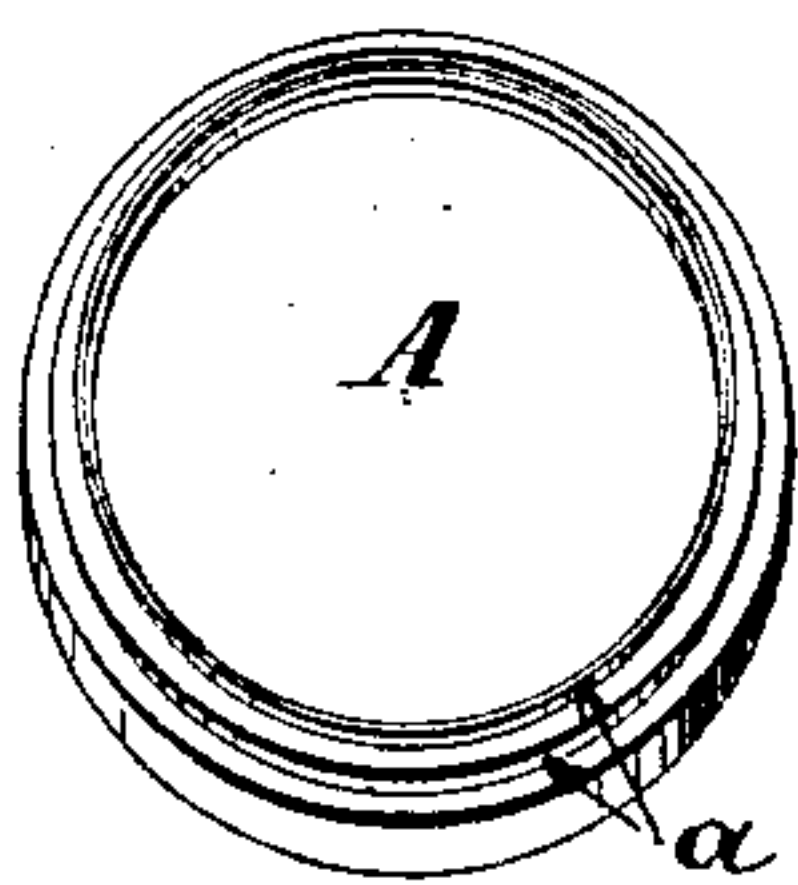


Fig. 4.

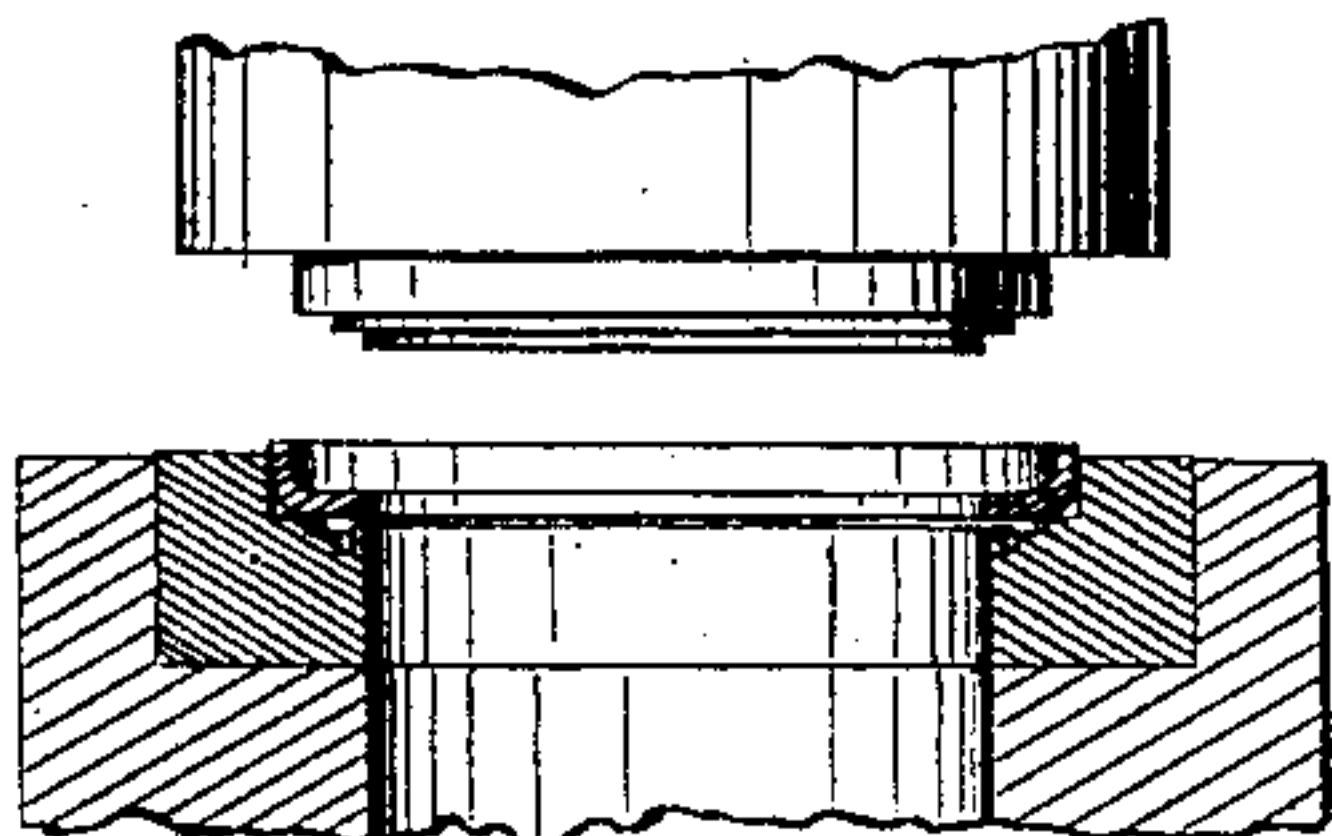


Fig. 6.

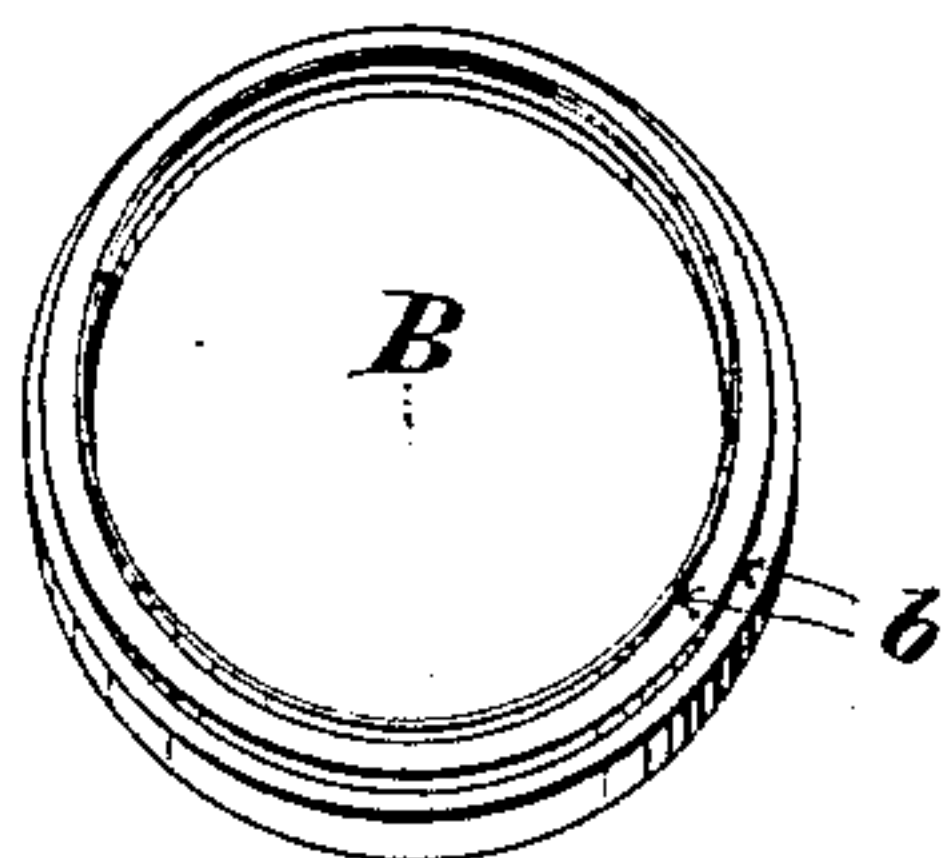


Fig. 9.

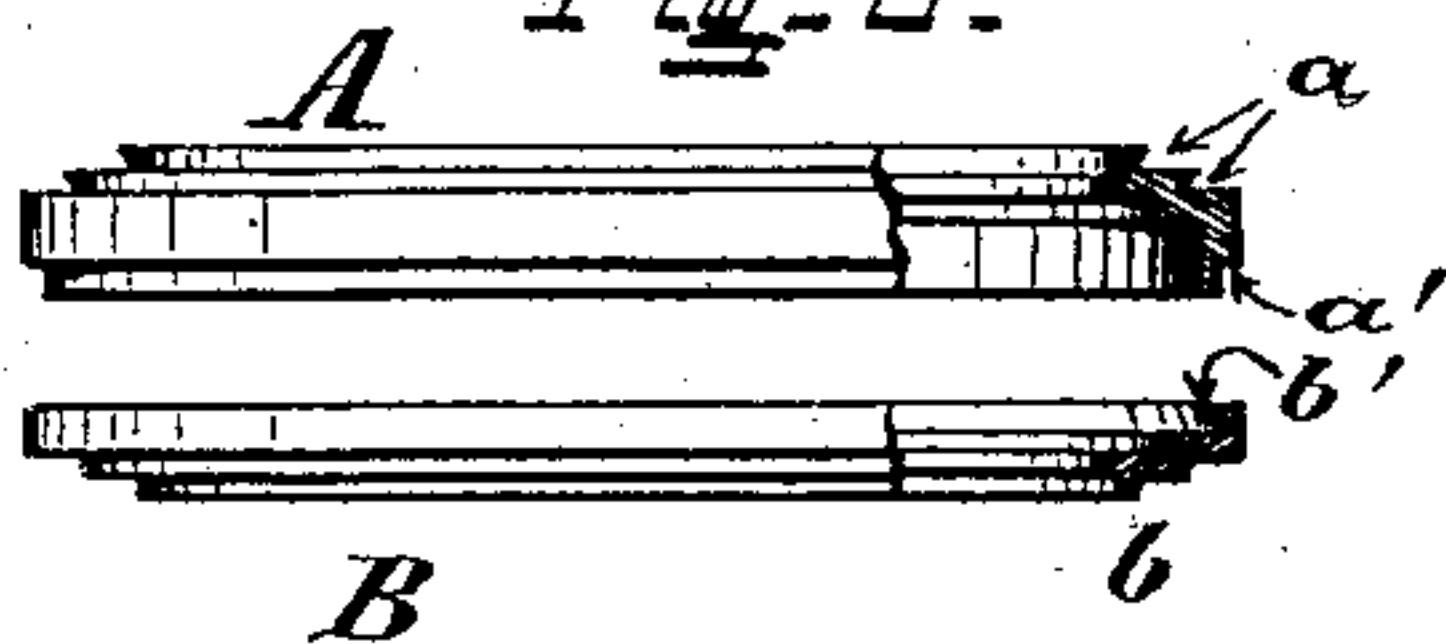


Fig. 7.

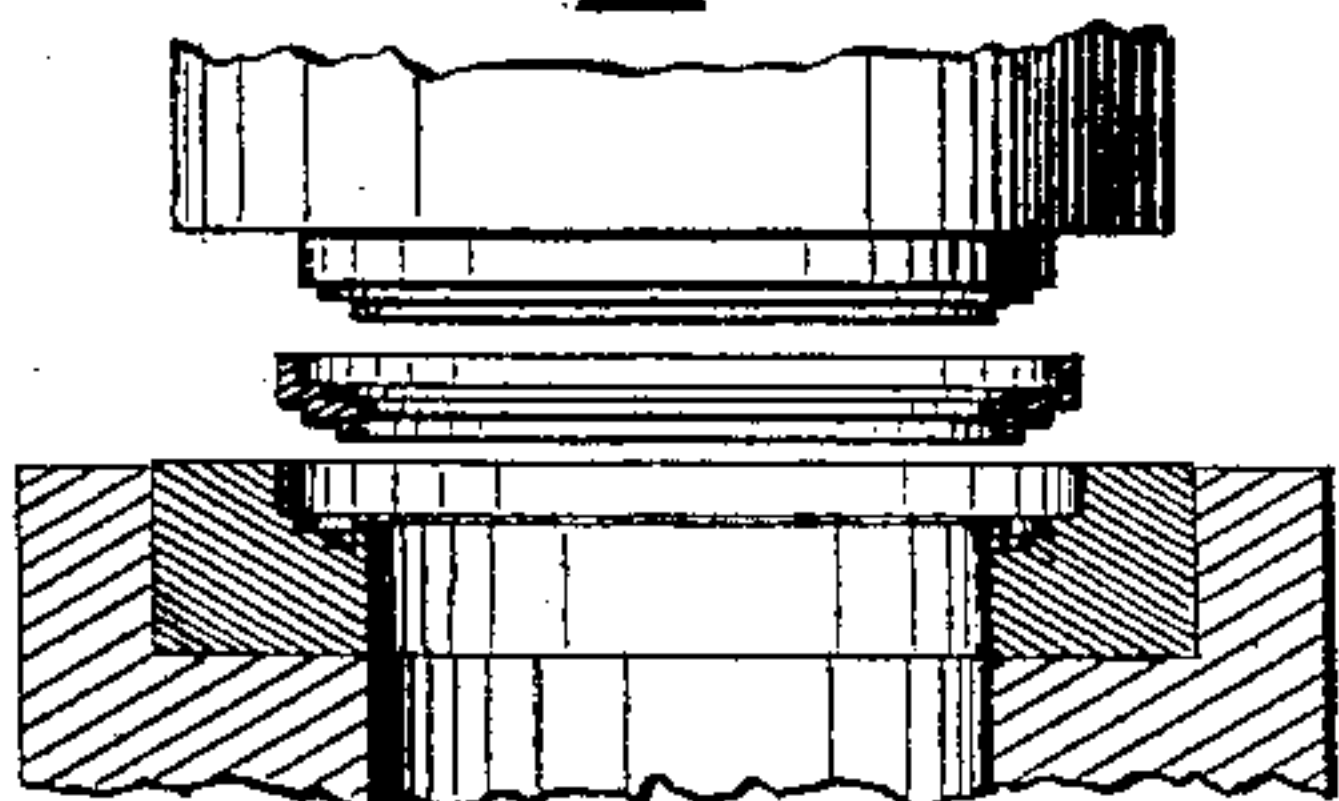


Fig. 10.

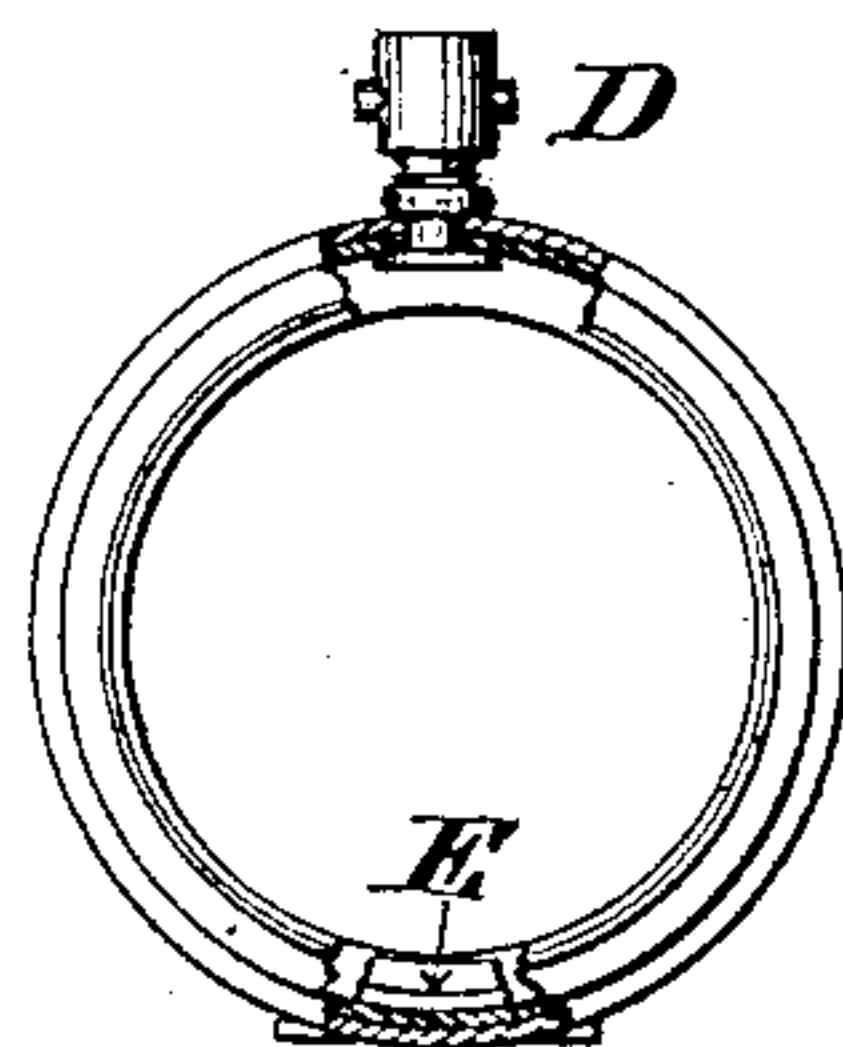


Fig. 11.

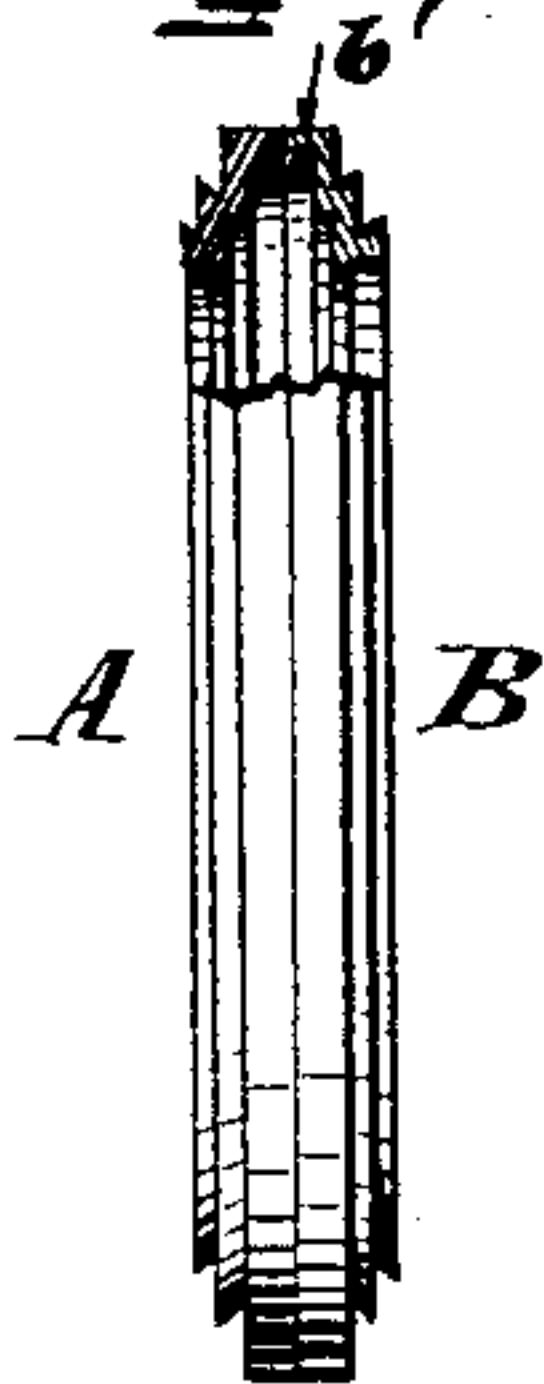
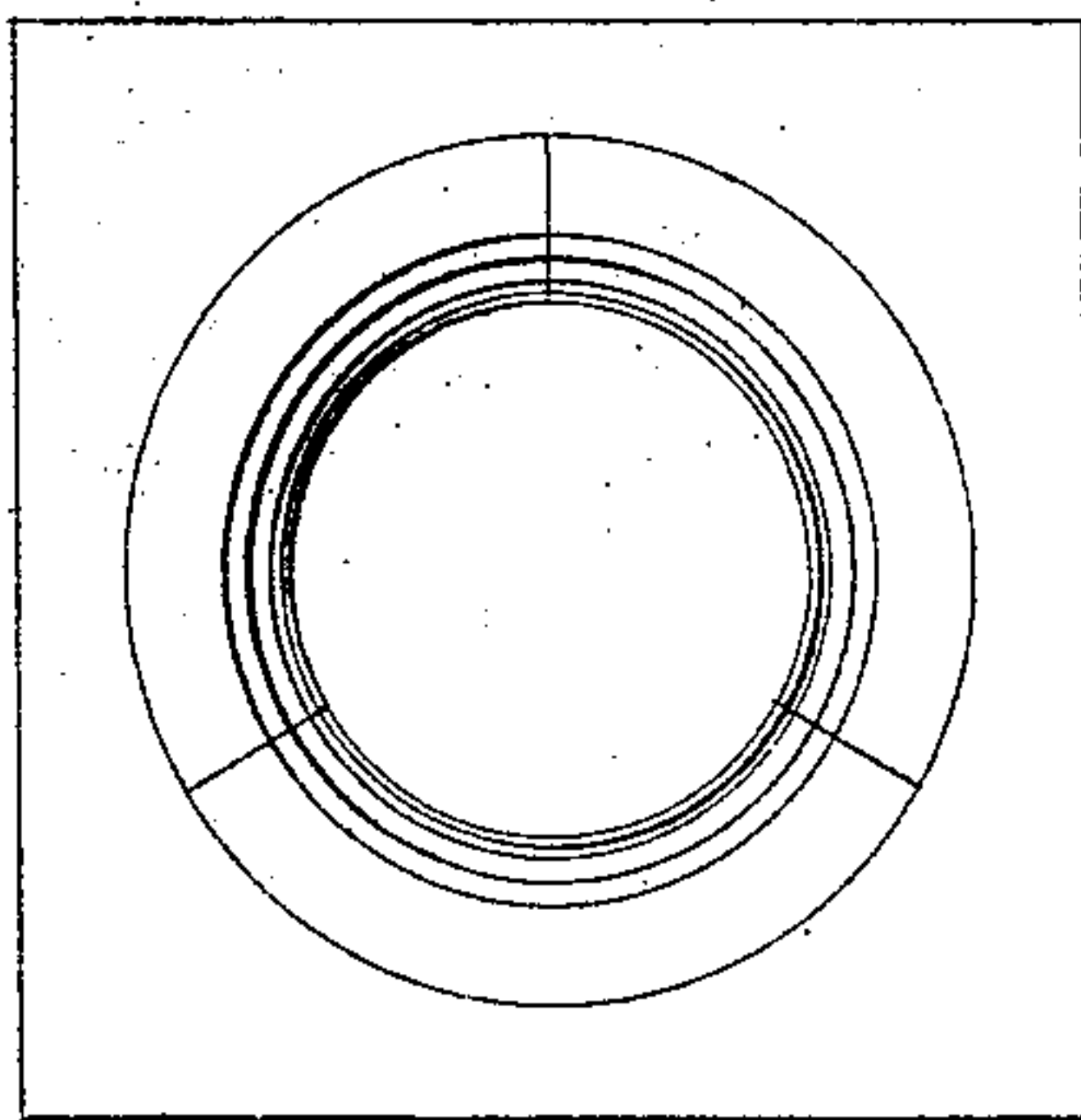


Fig. 8.



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UNITED STATES PATENT OFFICE.

JOHN C. DUEBER, OF NEWPORT, KENTUCKY.

WATCH-CASE CENTER.

SPECIFICATION forming part of Letters Patent No. 290,870, dated December 25, 1883.

Application filed September 26, 1883. (No model.)

To all whom it may concern:

Be it known that I, JOHN C. DUEBER, of Newport, Campbell county, Kentucky, have invented a new and useful Watch-Case Center, of which the following is a specification.

My invention relates to the construction of a two-part ring-formed middle member of a watch-case, technically known as the "center," and is more particularly designed to facilitate and perfect the manufacture of those watch-case centers that are formed from sheet-brass that has been gold-plated on one side, commonly known as "gold rolled plate." In the customary mode of forming such centers by "spinning" from a "hoop" of the plated material, it happens that (even in the hands of the highly-paid artisans usually employed on this work) very many pieces are rendered unfit for making up into cases, in consequence of the rupture of the skin of precious metal at the sharp salient angles of the "steps" ("snaps") required to enable the caps, backs, and bezels to snap snugly to the center. Moreover, the tools employed are very costly. This loss and damage I avoid by stamping out of the rolled plate two annular parts whose meeting edges are preferably coincident with the middle plane or equator of the watch-case, and are adapted to be lapped and then locked together, as hereinafter explained. Centers thus manufactured can be more perfectly and accurately finished, even by inferior workmen, at a great saving of material and wages, and also of expensive tools, as before stated.

In the accompanying drawings, Figure 1 represents an ordinary "blank" of "rolled gold plate." Figs. 2 and 3 represent annular pieces stamped out from such blanks. Fig. 4 represents by longitudinal section such a piece about to be subjected to the second operation in a suitable die. Figs. 5 and 6 represent two annular pieces (for the front and rear halves of the center, respectively) thus produced. Fig. 7 represents by longitudinal section such a piece about to be subjected to the third operation in a suitable die. Fig. 8 is a plan of the lower member of said die. Fig. 9 is a side view of the front annular piece, and partly side and partly sectional view of the rear annular piece as it appears after the desired acute angle has been imparted to the snaps and the desired joint to the overlapping lips. Figs. 10 and 11 are respectively

an equatorial and an axial section of a finished center constructed on my plan.

A and B represent annular pieces which, after undergoing a series of manipulations, about to be described, become the front or "male" and the rear or "female" members of my improved center. These members are stamped from customary rolled gold plate, of which C may represent a piece. These annular pieces A and B, having, by means of a suitable die, Fig. 4, been made to assume the form shown, respectively, in Figs. 5 and 6, in which the snaps *a b* are rectangular, are subsequently, by means of another die, Fig. 7, pressed into a form in which the snaps become acutely angular, as shown in Figs. 9 and 11. The two thus-formed annular pieces being then placed together in a suitable clamp or chuck within a lathe, the male lip *a'* is upset or turned outward, so as to interlock within the inwardly-receding lip *b'* of the female member by means of any convenient burnishing, spinning, or knurling tool, as shown in Fig. 11. The seam or joint may be closed and rendered invisible, either by burnishing or knurling. Finally, either a pendant-bearing, D, or hinge-bearing E, (one or both,) being soldered in place against the concave wall of the center, operates to permanently lock the parts immovably together. Soldering or brazing may also be applied over the joint on the concave interior wall, if desired.

In another application of even date herewith I have described a two-part center in which the lips are secured together by screw-threading, which is more accurate, generally; but in the present invention there is an advantage over the screw-thread, as in the spun joint there is less waste of metal and less labor in its production. Both forms have distinct advantages and are distinct articles of manufacture.

I claim as new and of my invention—

A watch-case center consisting of two annular parts or zones, one part having a lip, *b'*, projecting therefrom, and the other part having a lip, *a'*, "spun" to the other lip, and the locking-piece D, as set forth.

In testimony of which invention I hereunto set my hand.

Attest:

JOHN C. DUEBER.

GEO. H. KNIGHT,

SAML. S. CARPENTER.