

(No Model.)

J. C. DUEBER.
WATCH CASE CENTER.

No. 297,976.

Patented May 6, 1884.

FIG. 1.

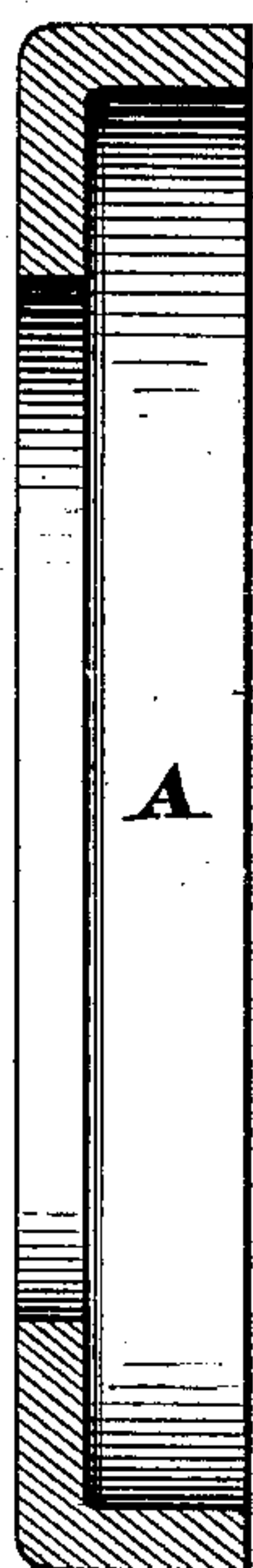


FIG. 6.

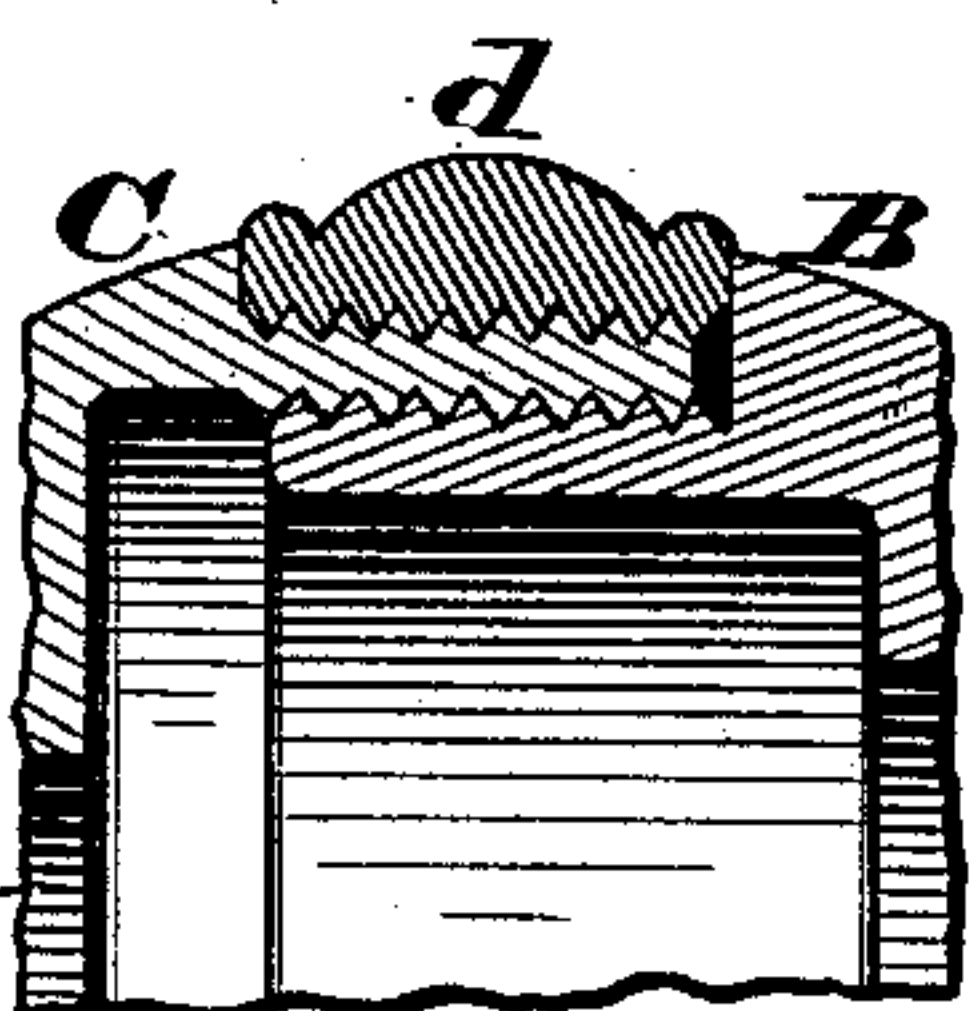


FIG. 7.

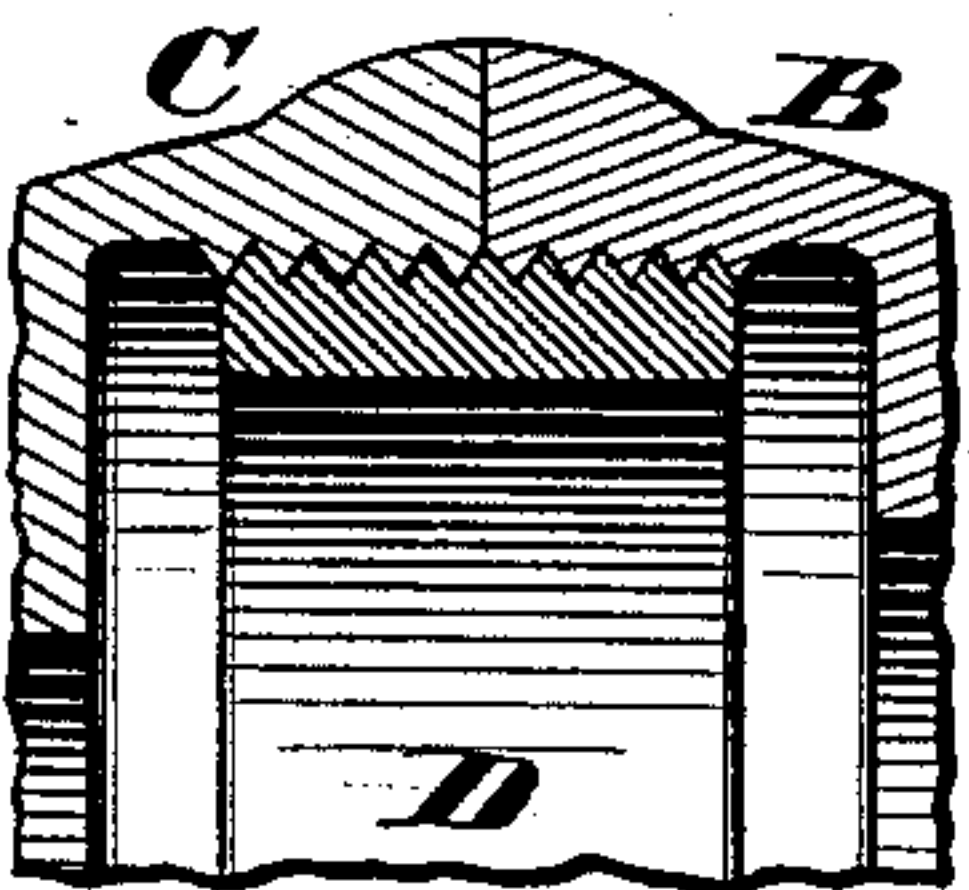


FIG. 2.



FIG. 3.

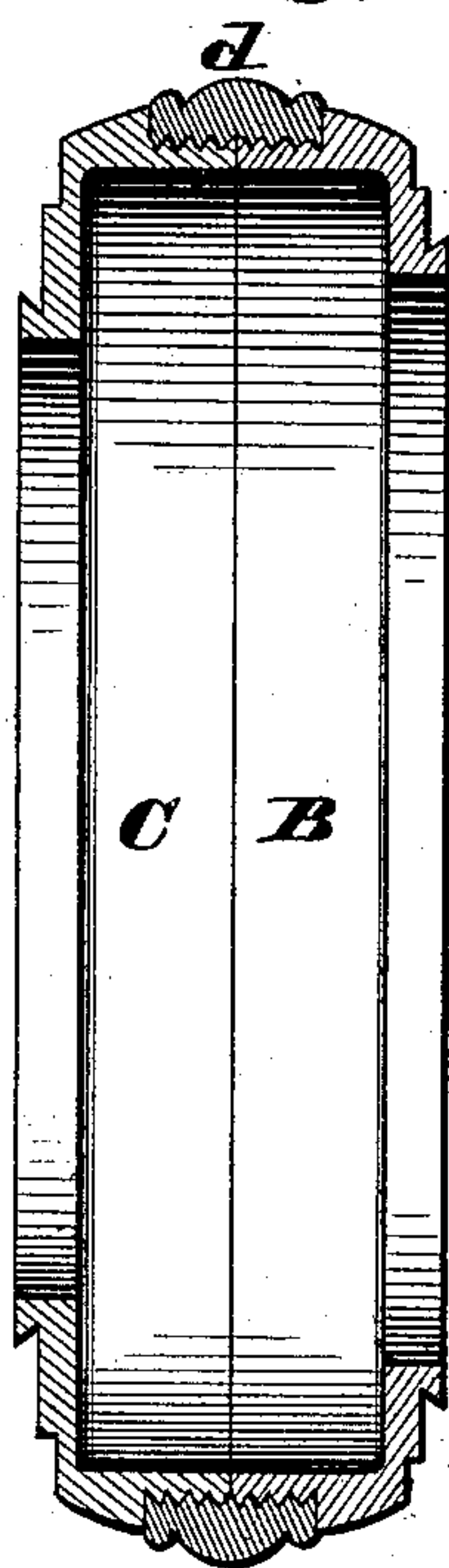


FIG. 4.

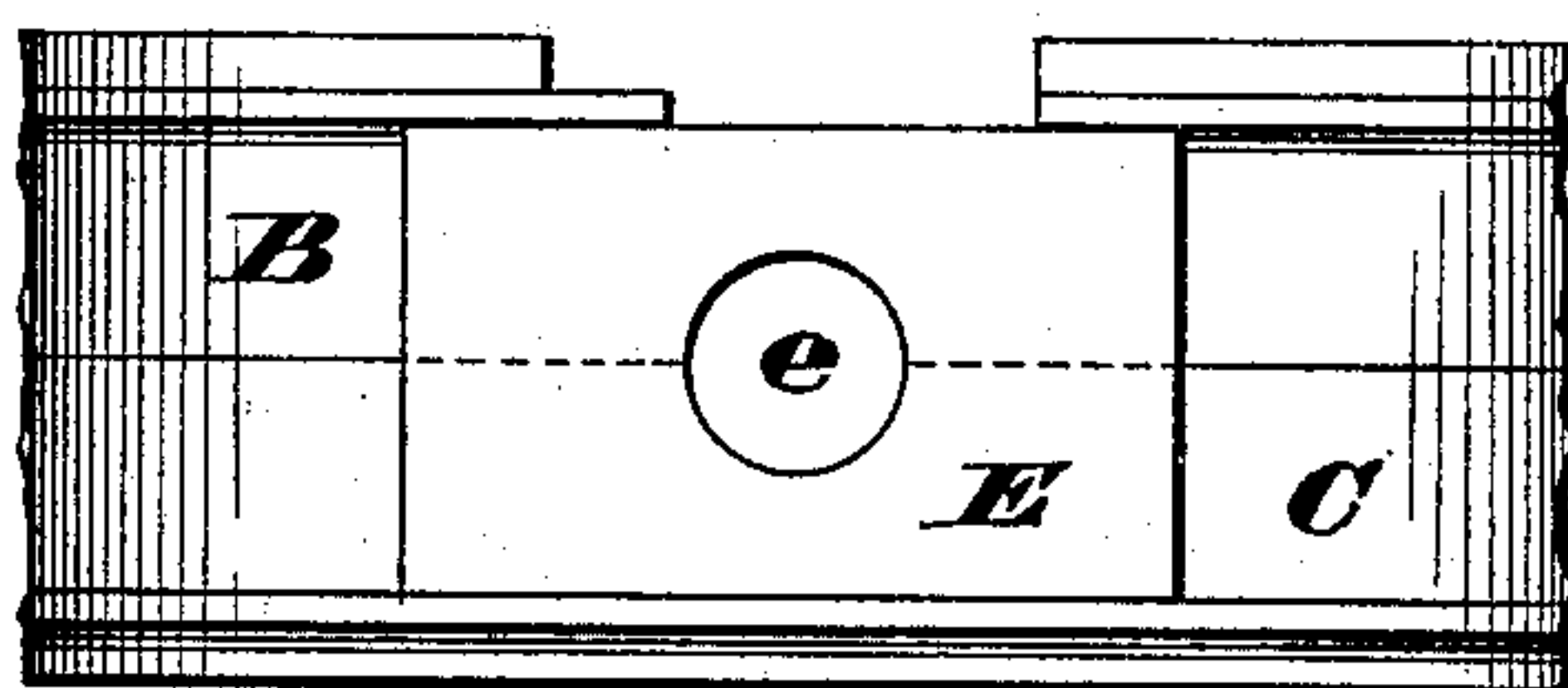
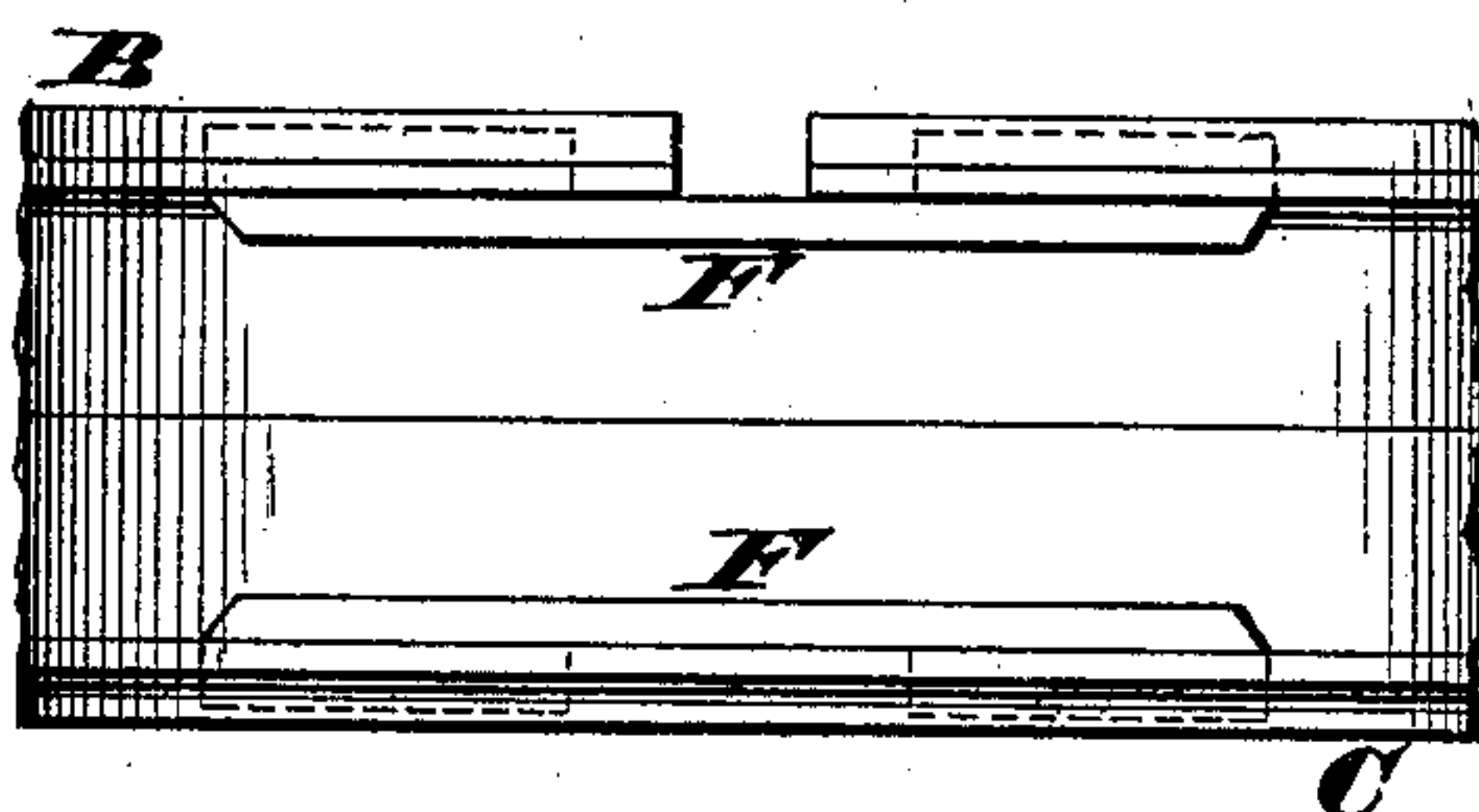


FIG. 5.



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UNITED STATES PATENT OFFICE.

JOHN C. DUEBER, OF NEWPORT, KENTUCKY.

WATCH-CASE CENTER.

SPECIFICATION forming part of Letters Patent No. 297,976, dated May 6, 1884.

Application filed September 17, 1883. (No model.)

To all whom it may concern:

Be it known that I, JOHN C. DUEBER, a citizen of the United States, residing at Newport, in the county of Campbell and State of Kentucky, have invented certain new and useful Improvements in Watch-Case Centers, of which the following is a specification, reference being had therein to the accompanying drawings.

10 My invention comprises a novel construction of those watch-case centers which are made of rolled-gold plate, the object of the improvement being to produce such "centers" in a neater and more uniform manner and at
15 less cost of manufacture than is possible with any of the ordinary appliances employed at the present time. This result is accomplished by making the center of three separate parts—to wit, a ring or annulus, and two other mem-
20 bers, termed the "front" and "back" halves, said ring being provided with a female thread for the engagement of male threads cut on the inner ends of said front and back halves. Consequently, when these "halves" are screwed
25 into the ring, the case is practically as firm and durable as though it were made of a single piece of metal; but to prevent any intentional separation of these three component members of the center, I solder them together at
30 the place where the "pendant-bearing" is secured, as hereinafter more fully described.

In the annexed drawings, Figure 1 is an axial section of the blank employed for producing the front and back halves of the center. Fig. 2 is a similar section of the three
35 different members of the center in one stage of manufacture. Fig. 3 is another axial section, but showing the front and back halves screwed into the ring. Figs. 4 and 5 are trans-
40 verse sections of the complete center or case. Figs. 6 and 7 are enlarged sections of two different modifications of my invention.

Referring to Fig. 1, A represents a blank, which is first cut out of the rolled-gold plate,
45 and is then brought to the desired shape by being preferably struck up in an ordinary forming or shaping press. This plate is made in the usual manner by rolling one or more sheets of gold onto a sheet of baser metal, al-
50 though the blank A may be composed of pure gold or other metal, if desired. Furthermore,

said blank is of such a diameter and thickness as to produce either the front half, B, or the back half, C, (seen in Fig. 2,) said members B C being provided with customary an-
55 nular flanges, shoulders, and snaps, and also with cylindrical necks *b c*, which latter are formed by turning down the blank.

D represents a ring or annulus that constitutes the inner or intermediate member of the
60 center, said ring being somewhat thicker than the halves B C, and being preferably knurled, chased, or otherwise ornamented on its outer periphery, as at *d*. This ring may be spun
65 up, but the better plan would be to make it with a die and shaping press, so as to insure the utmost uniformity of manufacture. After these component members B C D have
70 been brought to the desired shape, male threads are cut on the necks *b c* of the halves B C, and a female thread is chased on the inner periphery of ring D. Said halves B C are
75 then screwed into the ring D, as seen in Fig. 3, which operation completes the construction of the case and leaves it ready for the application of the pendant, the fitting of the hinges,
80 &c. As a watch-case center is seldom, if ever, subjected to a twisting action, there is no danger of either of the members B or C being
85 screwed out of the ring D; but to prevent said halves being intentionally disengaged, they are joined together by soldering to their inner peripheries a plate, E, perforated at *e*, to admit the shank or stem of the pendant, said
90 plate being technically called the "pendant-bearing." (See Fig. 4.)

The hinge-bearing F of the case is seen in Fig. 5.

As all the various parts of the center can be made with suitable dies and shaping-presses, 90
it is evident said parts will not require skillful workmen to produce them, but can be manufactured by boys in the most rapid and uniform manner. Furthermore, as the junctions of the halves B C with the ring D occur
95 circumferentially around said ring, they will not be perceptible.

As the leading feature of my invention consists in making a watch-case center of three component members, then screwing them to-
100 gether, and finally uniting them by soldering thereto the pendant-bearing, I do not propose

to limit the claim to any special detail of construction, provided this novel feature is retained. One modification is seen in Fig. 6, where the back half, C, is screwed into the
5 ring D, and the front half, B, is engaged with a female thread cut within the rim of said member C; but in Fig. 7 the ring D is wholly internal, and the halves B C are provided with female threads that engage with a male
10 thread cut on the outer periphery of said ring, the junction or parting of said halves being concealed by the subsequent burnishing or finishing operations. Finally, the exact proportions of the case have not been shown in the

drawings, the screw-joints having been intentionally enlarged, to render them perfectly clear. 15

I claim as my invention—

A watch-case center consisting of a ring having a pair of halves screwed thereto and
20 secured together by the pendant-bearing, substantially as herein described.

In testimony whereof I affix my signature in presence of two witnesses.

JOHN C. DUEBER.

Witnesses:

JAMES H. LAYMAN,
S. S. CARPENTER.