

(No Model.)

F. J. HAFNER.

MANUFACTURE OF IMITATION JEWELRY.

No. 330,230.

Patented Nov. 10, 1885.

FIG. 2.

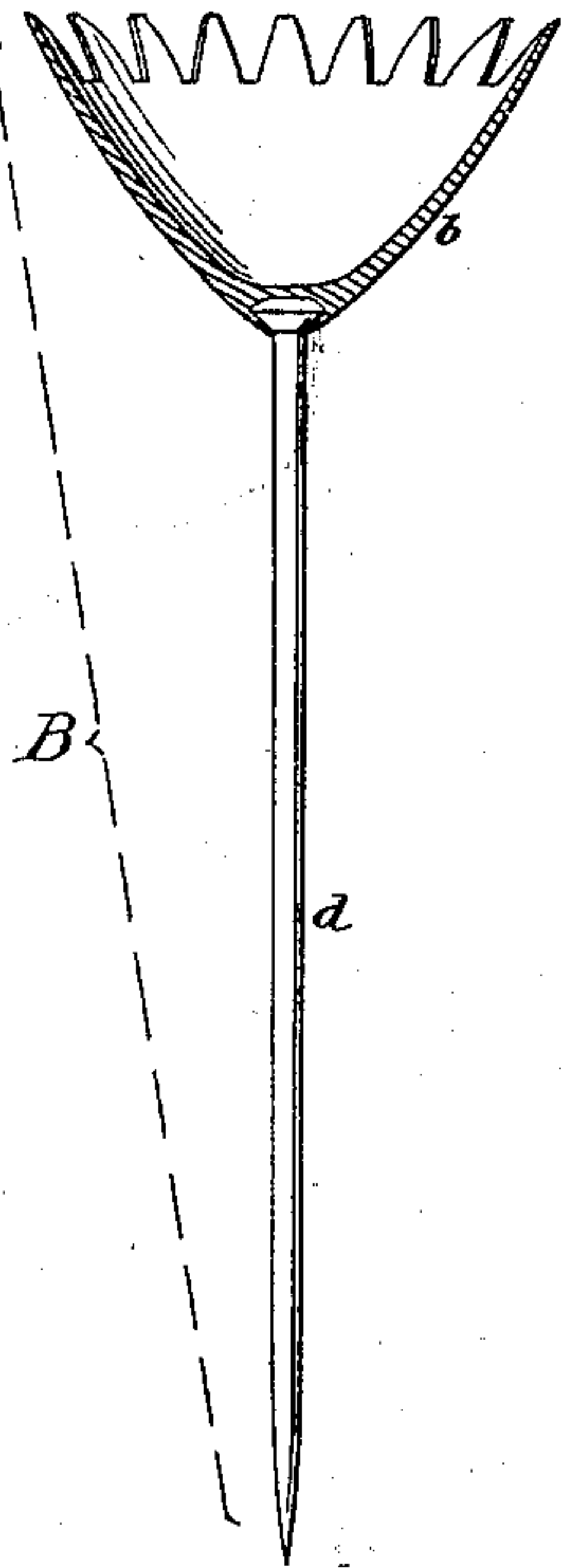


FIG. 1.

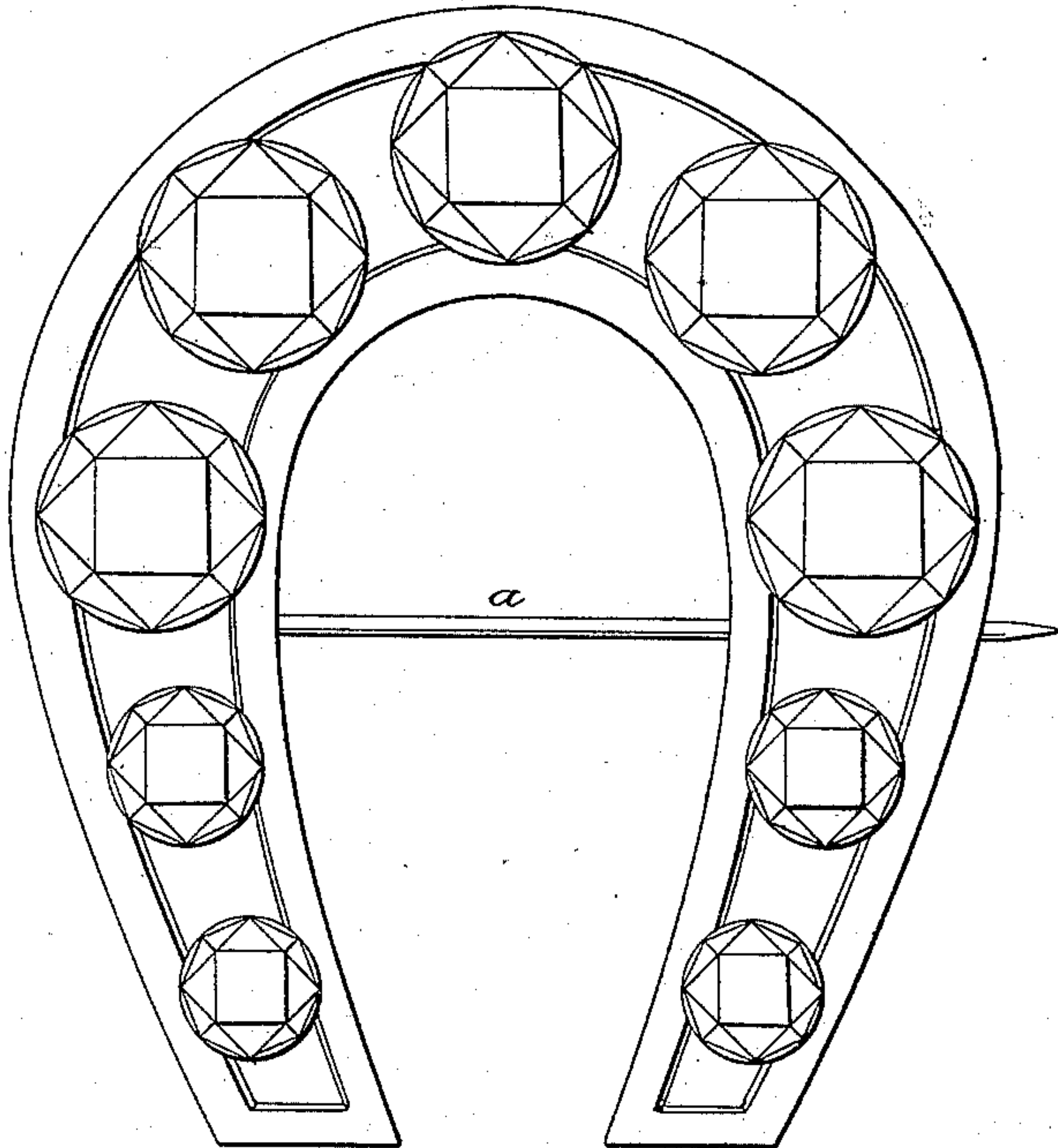


FIG. 3.

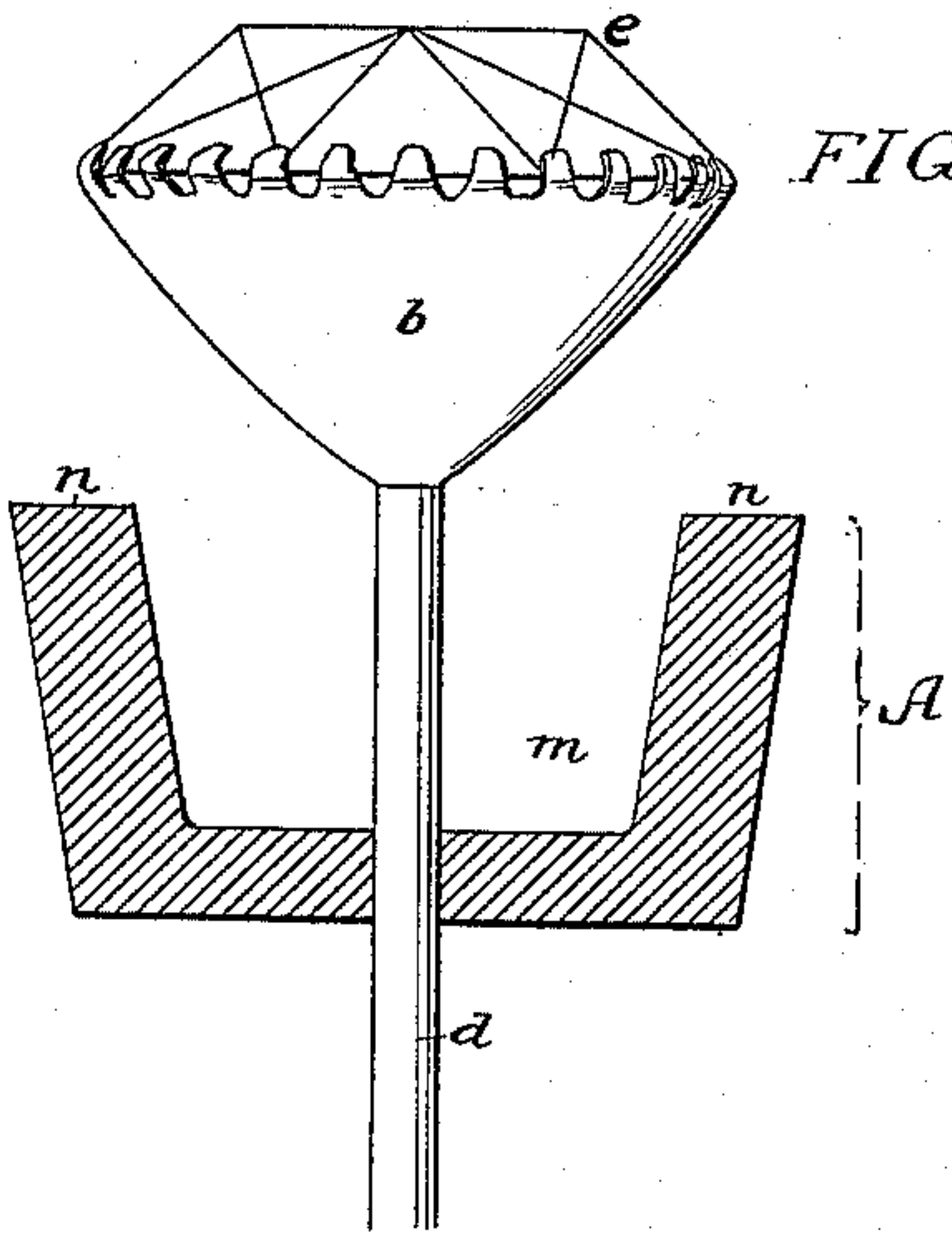
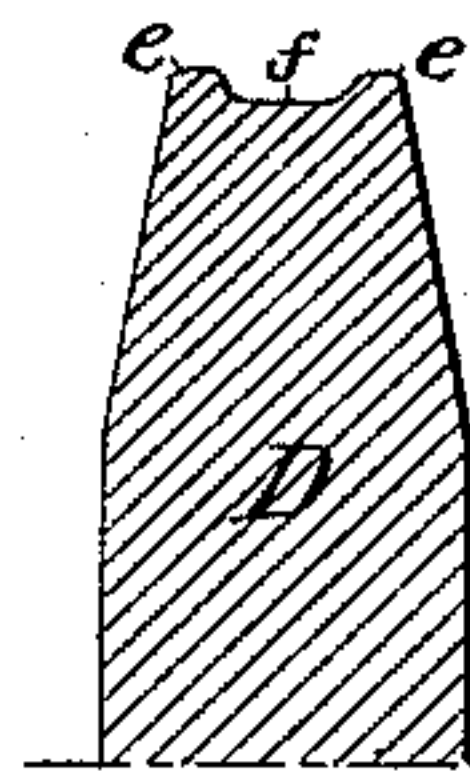
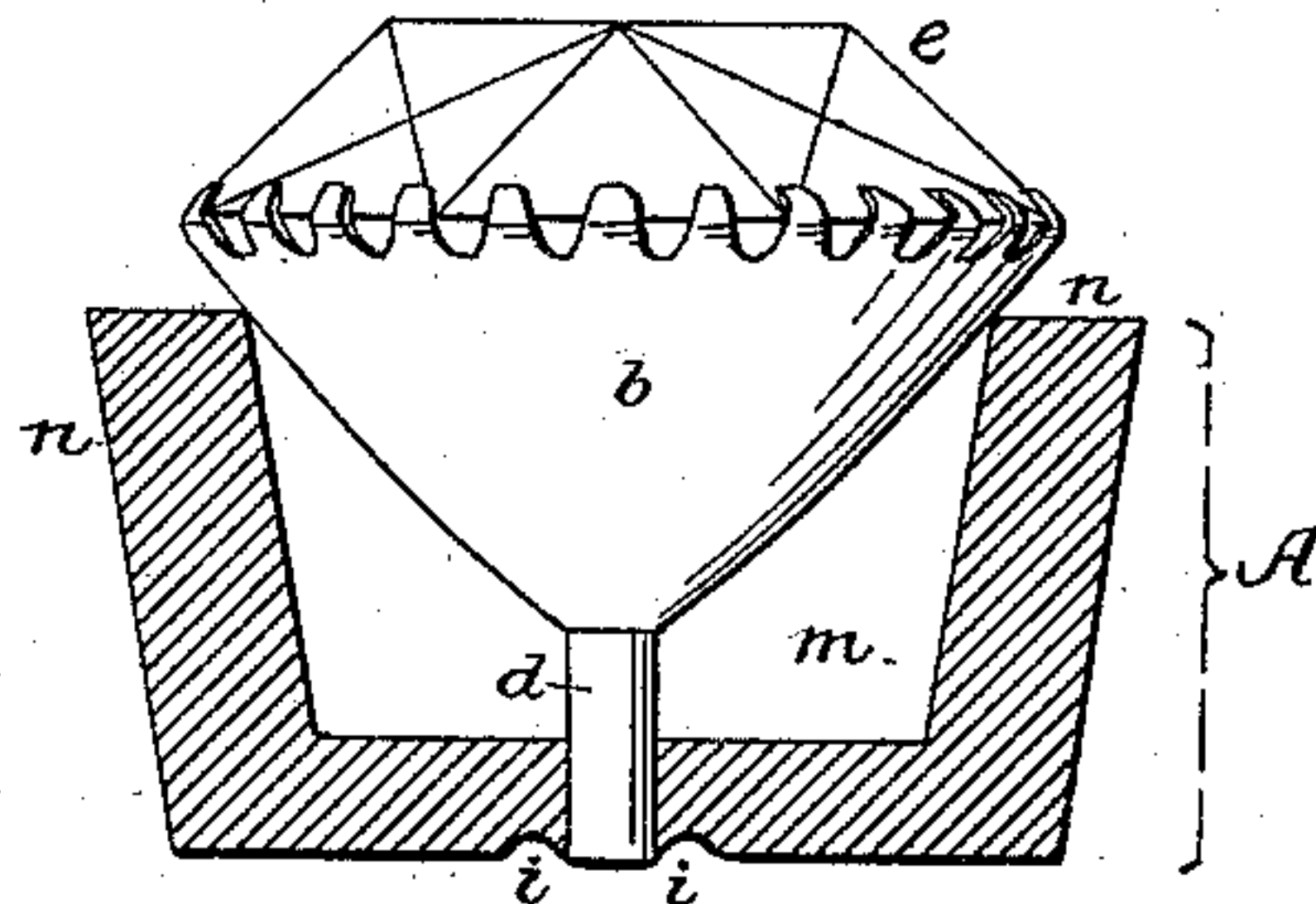


FIG. 4.



Witnesses
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MANUFACTURE OF IMITATION JEWELRY.

SPECIFICATION forming part of Letters Patent No. 330,230, dated November 10, 1885.

Application filed November 24, 1884. Serial No. 148,746. (No model.)

To all whom it may concern:

Be it known that I, FREDERICK J. HAFNER, a citizen of the United States, residing in Philadelphia, Pennsylvania, have invented certain Improvements in the Manufacture of Imitation Jewelry, of which the following is a specification.

My invention consists of a simple and economical mode, described and claimed herein-after, of making cheap articles of imitation jewelry—such as brooches, shawl-pins, hair-pins, &c.

In the accompanying drawings, Figure 1 is a front view, drawn to an enlarged scale, of a brooch studded with imitation jewels, and made according to my invention; Fig. 2, a view, drawn to a still larger scale, of one of the jewel-holders, showing the socket in section; and Figs. 3 and 4, views illustrating the final steps taken in carrying out my invention.

The base A is preferably made of what is known as "white-metal"—that is, an alloy somewhat softer than brass and fusible at such a low temperature that it can be cast in metal molds. In the present instance the base A of a brooch is made of a horseshoe shape, and is furnished with the usual pin and keeper; but bases of different shapes and designs may be used in carrying out my invention. The base A, however, whatever its shape may be, should have a recess, *m*, bounded by ribs *n*.

The jewel-holder B (shown in Fig. 2) consists of a pin, *d*, and a socket, *b*, the latter being of the above-mentioned white-metal, and cast in a mold, into which the head of the pin is inserted, so that the socket will be united to the pin, when both are withdrawn from the mold. The imitation jewel *e* is fitted in the socket, and lips on the edge of the latter are turned over and against the jewel.

Through the base A, within the limits of its recess *m*, are drilled as many holes as there are imitation jewels to be applied to the said base, there being nine such jewels in the present case.

Through each hole is passed the pin *d* of one of the jewel-holders B, until the socket bears

against the inner edge of the ribs *n n* of the base, after which the pin is pinched off, so as to be flush, or nearly so, with the rear surface of the said base. After this, the base with the pin of the jewel-holder, in the condition shown in Fig. 4, is applied under pressure to a rapidly-revolving spindle, D, which has at the end a recess, *f*, bounded by an annular rib, *e*, the tendency of this being to form an annular indentation at the rear of the base round the pin to curve the metal against the same, and at the same time to slightly round and extend the end of the pin and secure it to the base.

The common plan of soldering, as a means of securing jewel-holding pins to the bases of imitation jewelry, has a tendency to disfigure the same, and the same may be said of riveting; but by adopting the mode described of crowding the metal against the pin, a neat finish is made at the recess of the base wherever a pin occurs.

I claim as my invention—

1. The mode herein described of making a cheap article of imitation jewelry, the said mode consisting in first making a cast-metal socket for jewels by casting the same in a mold, and uniting the pin to the socket during the process of casting the same, and then fitting the imitation jewel into the socket and turning the lips of the socket over against the said jewel, all substantially as set forth.

2. The mode herein described of making a cheap article of imitation jewelry, the said mode consisting in first casting a recessed base, drilling holes therein, passing the pins of jewel-holders through the holes of the base, and securing the pins thereto by crowding the metal of the base against and around each pin, substantially as specified.

In testimony whereof I have signed my name to this specification in the presence of two subscribing witnesses.

FREDERICK J. HAFNER.

Witnesses:

JOHN M. CLAYTON,
HENRY HOWSON, Jr.