

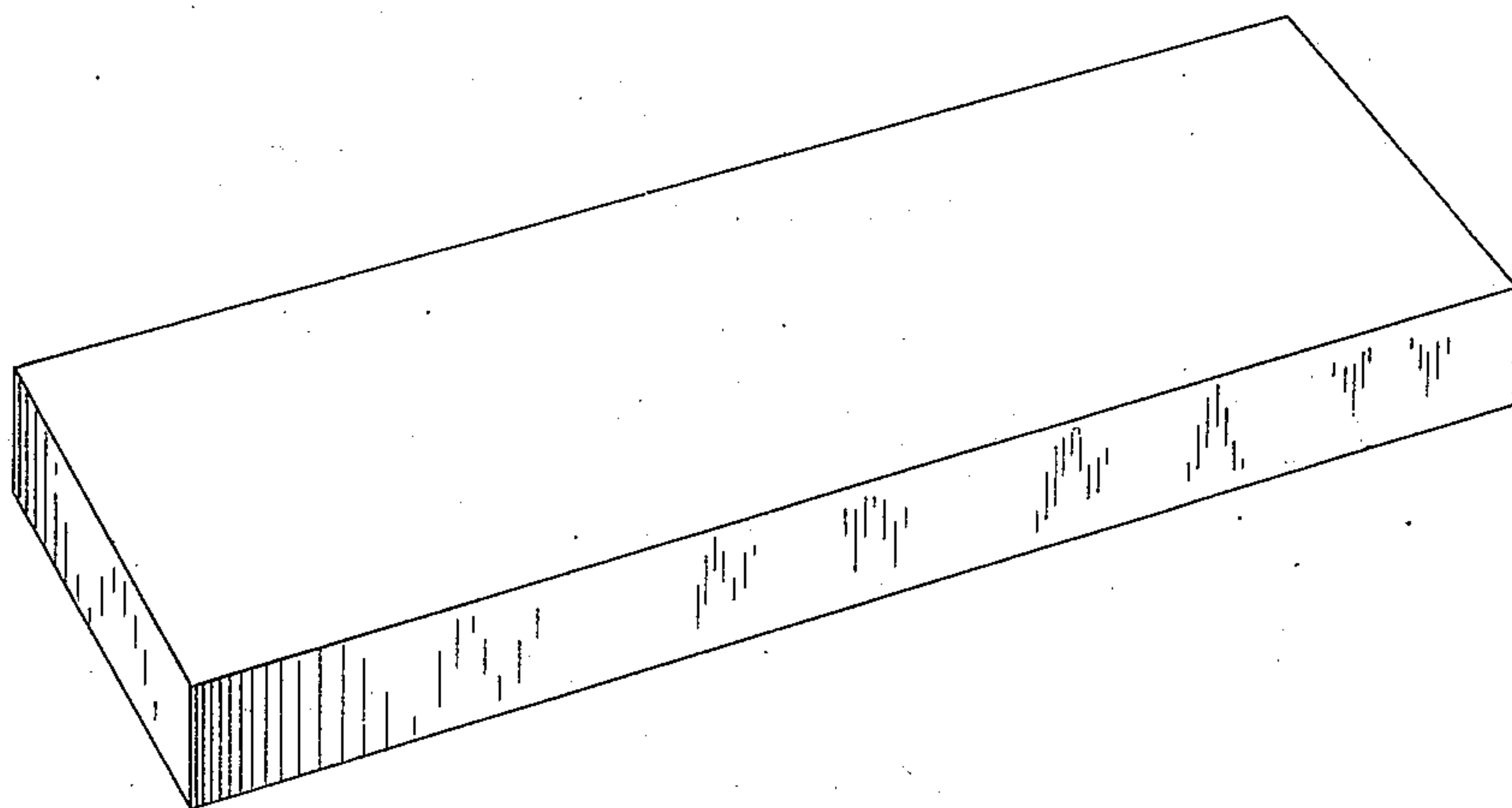
(No Model.)

E. D. TUTTLE.

PLATER'S BAR.

No. 333,432.

Patented Dec. 29, 1885.



Witnesses

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Inventor

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UNITED STATES PATENT OFFICE.

EDWARD D. TUTTLE, OF WATERBURY, CONNECTICUT, ASSIGNOR TO FRANK
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PLATER'S BAR.

SPECIFICATION forming part of Letters Patent No. 333,432, dated December 29, 1885.

Application filed October 23, 1885. Serial No. 180,781. (No model.)

To all whom it may concern:

Be it known that I, EDWARD D. TUTTLE, of Waterbury, in the county of New Haven and State of Connecticut, have invented a certain new and useful Improvement in Platers' Bars, of which the following is a specification.

It is common for jewelers to employ, in their manufacture of jewelry, bars of base metal, composed, generally, of copper, zinc, and lead, termed in the trade "platers' bars," and to secure to sides of these bars sheets of gold or other precious metal by means of soldering. These bars are rolled down till thin enough for the uses for which they are intended.

These platers' bars are made of standard sizes.

Heretofore platers' bars have been made by casting large ingots, rolling them down to a standard thickness, and then cutting them with saws to the required width. More or less of the rolled ingots at the lateral edges have been inevitably wasted in order to obtain from them a number of bars of the required widths. Waste has also been incurred through the loss of the portions of the rolled ingots which have been reduced to dust by the saws employed in cutting them. The waste incurred, as described, has rendered the cost of the finished bars to the platers unnecessarily expensive. It has been almost impossible to make the bars accurately of standard sizes according to this process, and any deviation has proved very objectionable, because the gold which is to be united to them is also reduced to standard sizes, and therefore will not be properly proportioned to the bars when the latter deviate from the standard sizes. Lead has necessarily entered largely into the composition of the ingots, in order that they may be practically cut with saws. The use of the lead has conduced to render the bars less tenacious or more brittle than otherwise they would be, and this quality has been found very objectionable, particularly when the bars have been rolled out thin by the platers, in order to utilize them in making articles of jewelry. Expense has been consequently incurred in working with

the bars. The sawing of the ingots to produce the bars has caused ragged or jagged edges, which have entailed more or less waste and consequently expense to the jewellers, because they have had very generally to be cut away in order to use the bars when rolled out thin. Not only have the jewelers suffered from the waste of brass in this way, but the gold soldered to the bars has also been wasted materially. The presence of lead renders soldering less easy than it otherwise would be. The presence of the lead in scraps is also objectionable to the jewelers in reclaiming the gold.

It is the object of my improvement to obviate all the waste to which I have alluded.

My improvement consists in a new article of manufacture consisting of a plater's bar made by casting an ingot of brass and then drawing it down to the standard dimensions. In this way I produce a bar which suffers no waste through sawing, which needs not the lead that is requisite in bars cut from ingots, and which has smooth even edges.

The bars made according to my improvement can not only be made more cheaply than those made heretofore, but they can also be used more economically by the jewelers.

The accompanying drawing is a perspective view of a plater's bar made according to my improvement.

In carrying out my improvement I cast an ingot of approximately the required size. Then I preferably roll it slightly. Ultimately I draw it with the aid of suitably-formed drawing-dies to the standard sizes. It will be compressed in the operation of drawing, and its edges will be rendered hard, solid, and even. Any superfluity in the width or thickness will be added to the length. The size will always be the standard required.

What I claim as my invention, and desire to secure by Letters Patent, is—

As a new article of manufacture, the drawn plater's bar herein described.

EDWARD D. TUTTLE.

Witnesses:

EDWIN H. BROWN,

DANIEL H. DRISCOLL.