

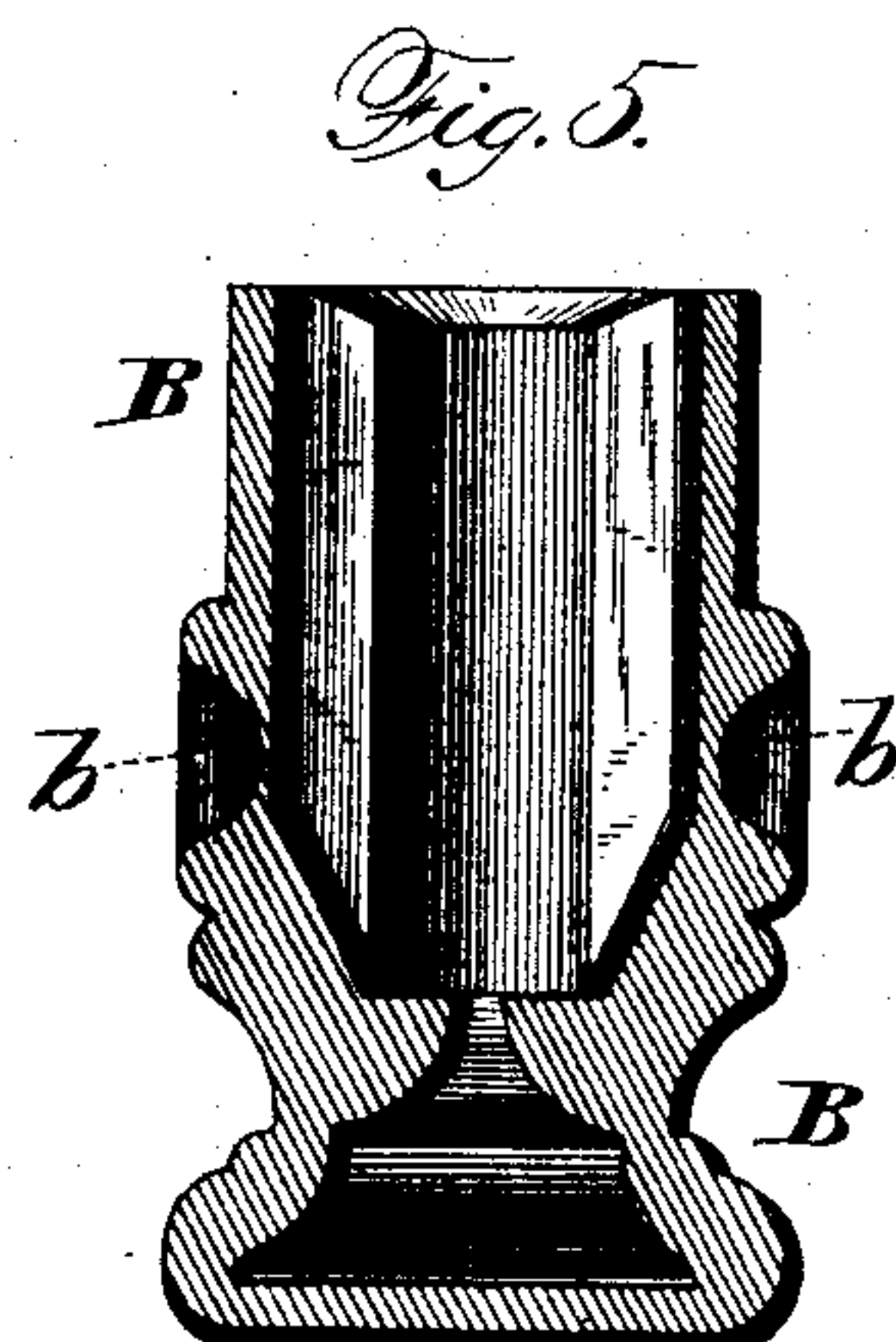
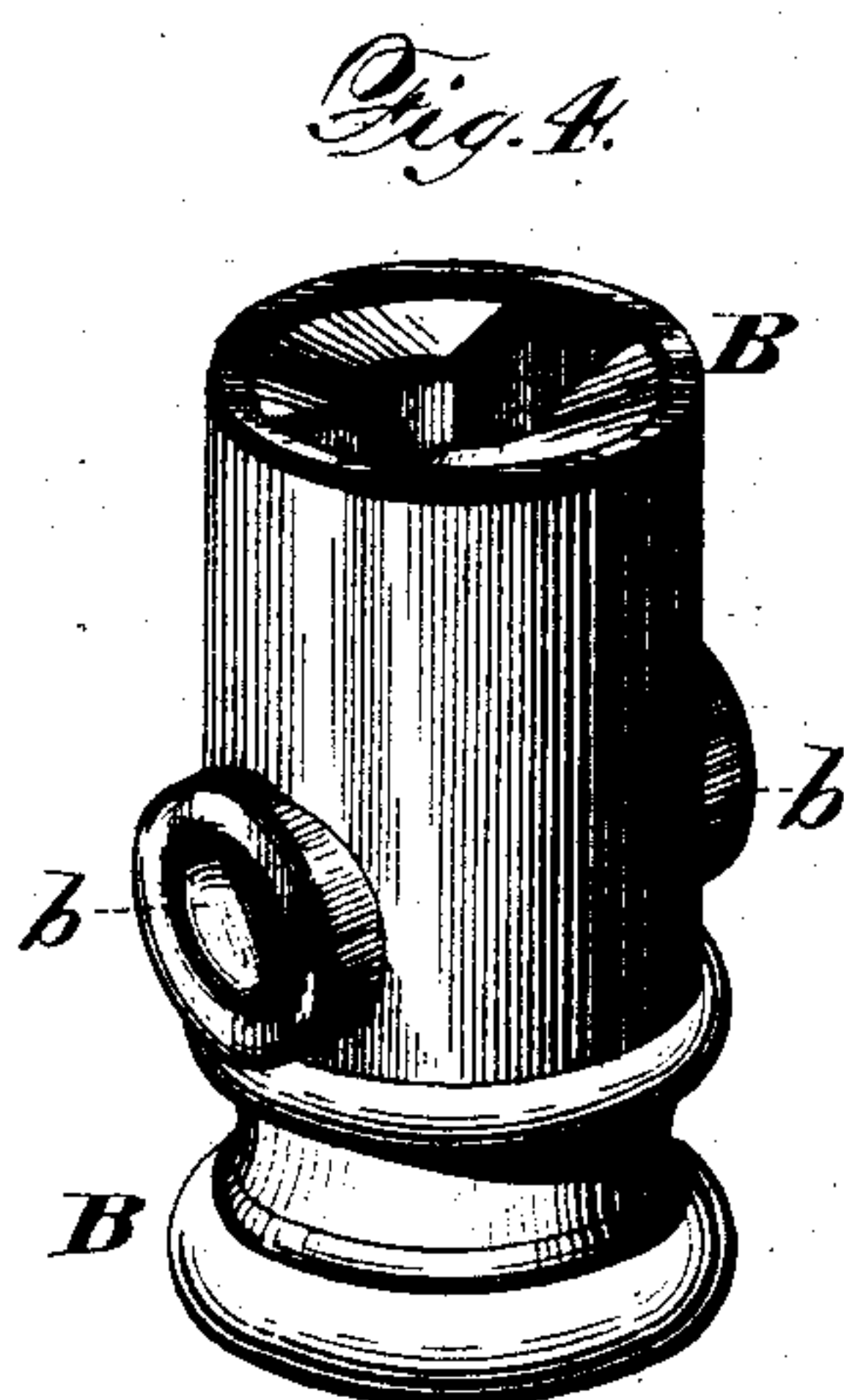
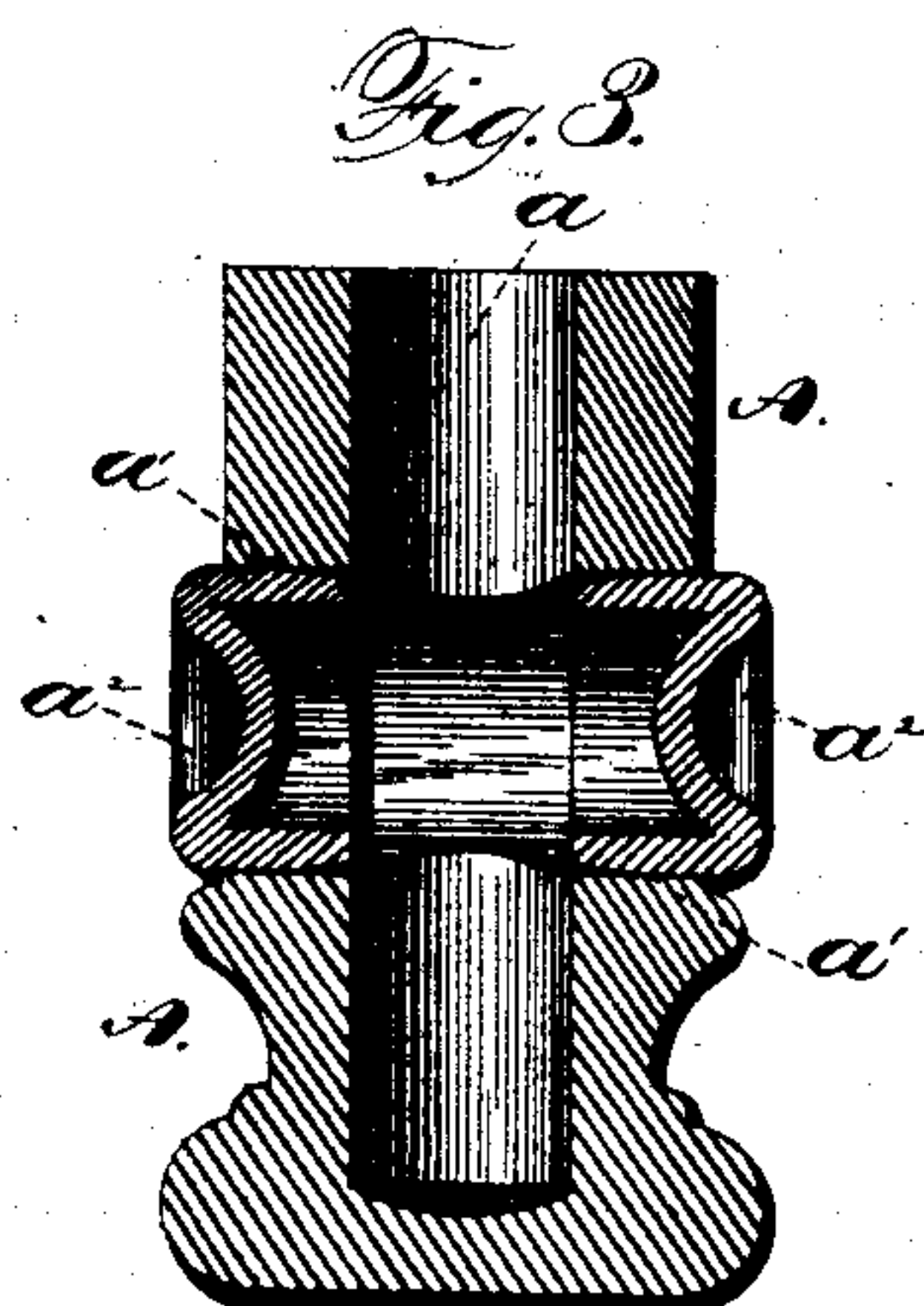
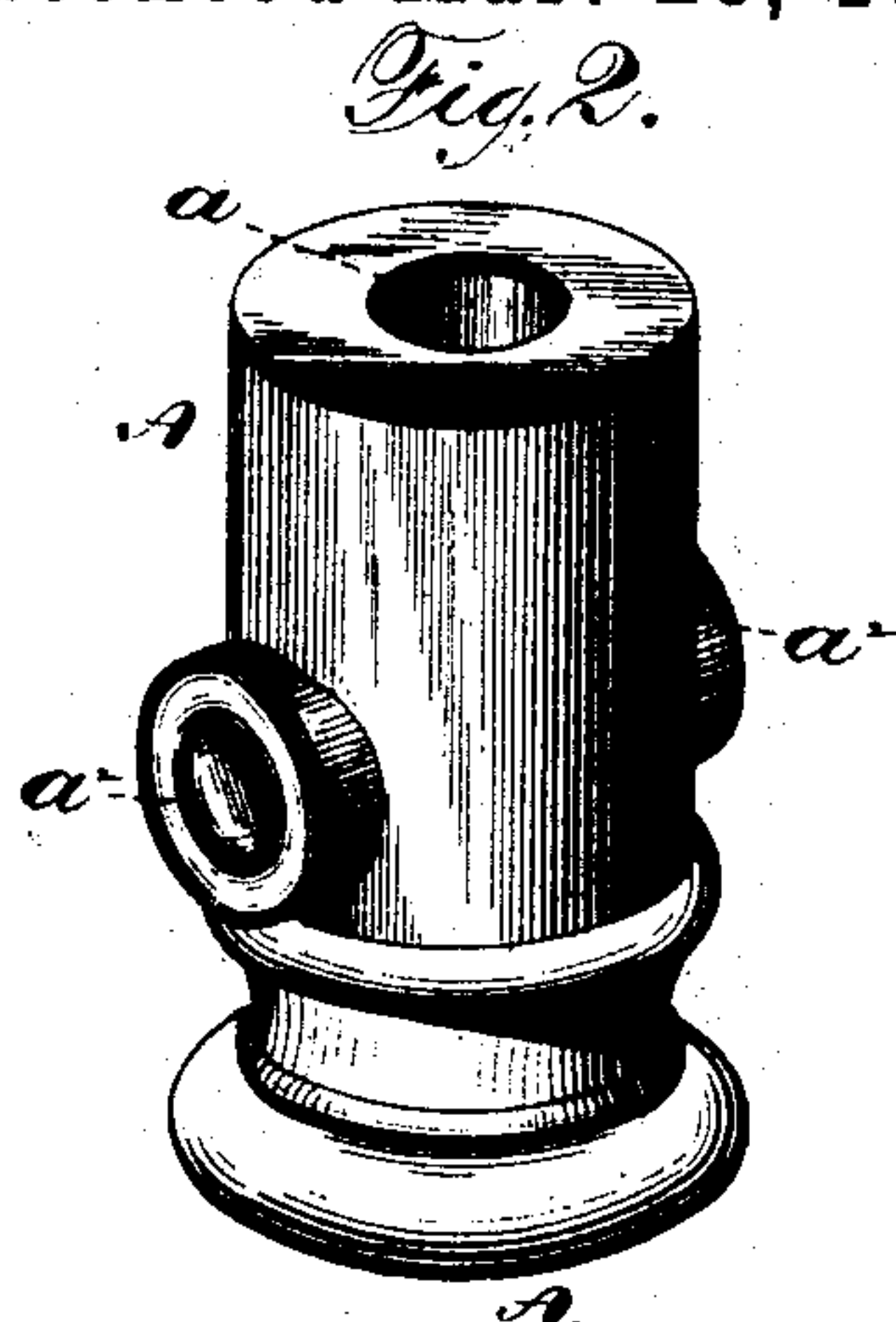
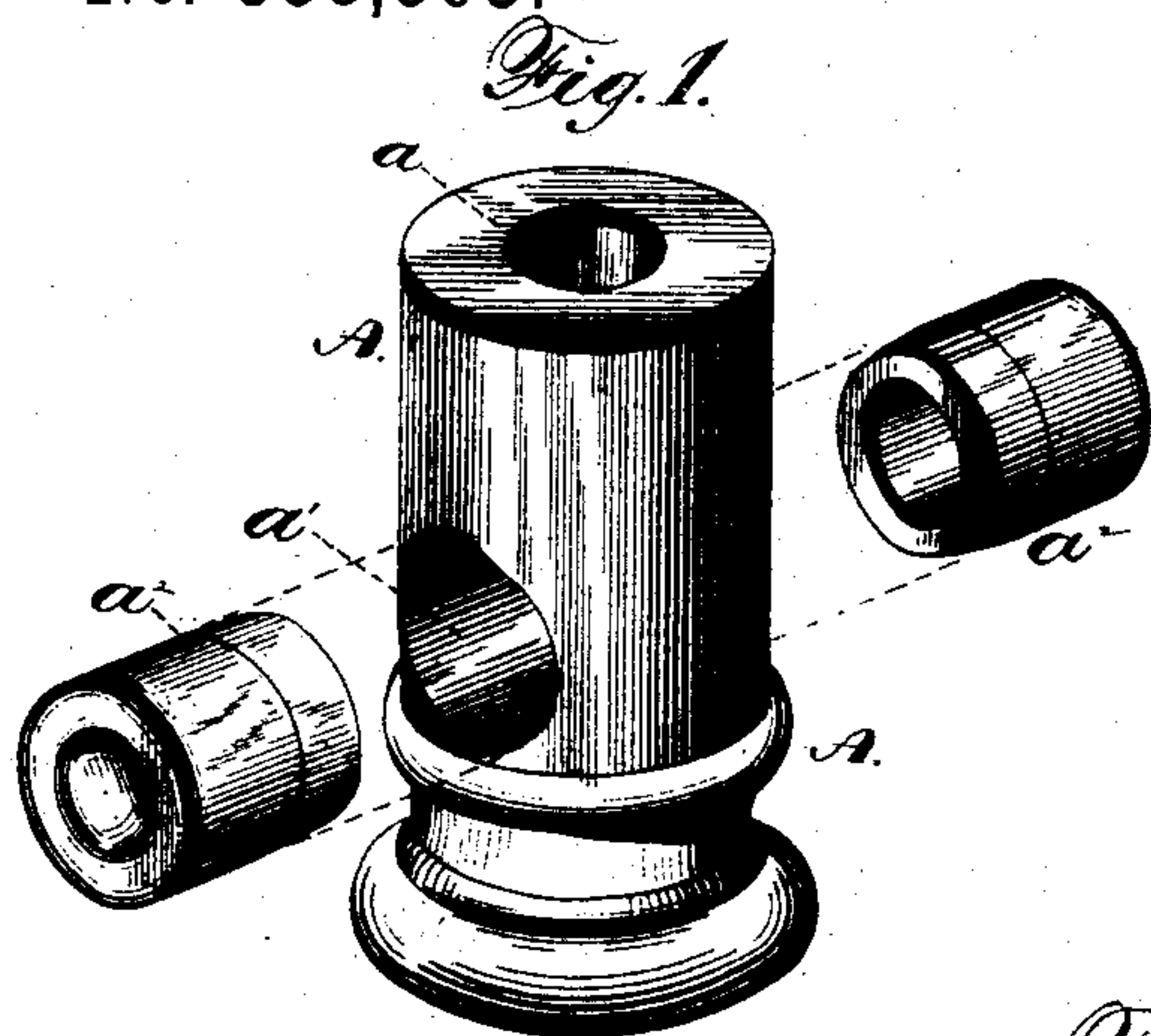
(No Model.)

W. H. FITZ GERALD.

WATCH CASE STEM.

No. 338,503.

Patented Mar. 23, 1886.



Witnesses:  
Chas. J. Williamson.  
Henry C. Hazard.

Inventor:  
W. H. Fitzgerald, by  
Cindle & Russell, his Attys.

# UNITED STATES PATENT OFFICE.

WALTER H. FITZ GERALD, OF BROOKLYN, NEW YORK.

## WATCH-CASE STEM.

SPECIFICATION forming part of Letters Patent No. 338,503, dated March 23, 1886.

Application filed October 3, 1885. Serial No. 178,923. (No model.)

*To all whom it may concern:*

Be it known that I, WALTER H. FITZ GERALD, of Brooklyn, in the county of Kings, and in the State of New York, have invented certain  
5 Improvements in the Manufacture of Watch-Case Stems; and I do hereby declare that the following is a full, clear, and exact description thereof, reference being had to the accompanying drawings, in which—

10 Figure 1 is a perspective view of the parts of a watch-case stem as ordinarily constructed. Fig. 2 is a like view of the same united. Fig. 3 is a central section of said stem through its axis. Fig. 4 is a perspective view of my  
15 case-stem, and Fig. 5 is a central longitudinal section of the same.

Letters of like name and kind refer to like parts in each of the figures.

In the construction of watch case stems it  
20 has heretofore been the custom to form the body by boring and turning the body from a solid piece of metal, and the ring-sockets from separate pieces of metal, and to then insert and solder the latter within radial openings  
25 which were drilled in said stem. Case-stems constructed in this manner are expensive, and in consequence of defects in workmanship, which are liable to occur, the ring-sockets will sometimes become detached, in which event  
30 injury to the watch-case or watch may result.

The object of my invention is to produce a case-stem which shall possess a maximum of strength and durability; and to this end said invention consists, as a new article of manu-  
35 facture, in a watch-case stem formed from one piece of metal and having protuberant ring-sockets which are a part of and integral with its body, substantially as and for the purpose hereinafter specified.

In the annexed drawings, A designates a 40 watch-case stem which is constructed from one piece of metal by boring through the same an axial opening, *a*, then turning its exterior to the required form, and then drilling within its body two coinciding radial openings, *a'*, 45 for the reception of ring-sockets *a''*, which sockets are separately formed, and after insertion within their said openings are secured in place therein by means of solder.

In the carrying of my invention into prac- 50 tice a disk of sheet metal is drawn into the form of an elongated cup, and the same then placed within suitable dies and expanded laterally until caused to conform thereto, the result being a stem, B, which has the desired 55 exterior form, and is provided with ring-sockets *b*, that are formed of and integral with the body.

The case-stem thus formed possesses strength and durability, which have not been obtainable by the construction heretofore employed, 60 as its surface has been compressed to shape instead of being cut, and its ring-sockets form part of and cannot be separated from its body.

Having thus fully set forth the nature and 65 merits of my invention, what I claim is—

As a new article of manufacture, a watch-case stem formed from one piece of metal and having protuberant ring-sockets which are a part of and integral with its body, substan- 70 tially as and for the purpose specified.

In testimony that I claim the foregoing I have hereunto set my hand this 18th day of September, 1885.

WALTER H. FITZ GERALD.

Witnesses:

STEDMAN H. HALE,  
A. M. CROMMELIN.