

(No Model.)

W. H. FITZ GERALD.
MANUFACTURE OF WATCH CASES.

No. 353,932.

Patented Dec. 7, 1886.

Fig. 1.

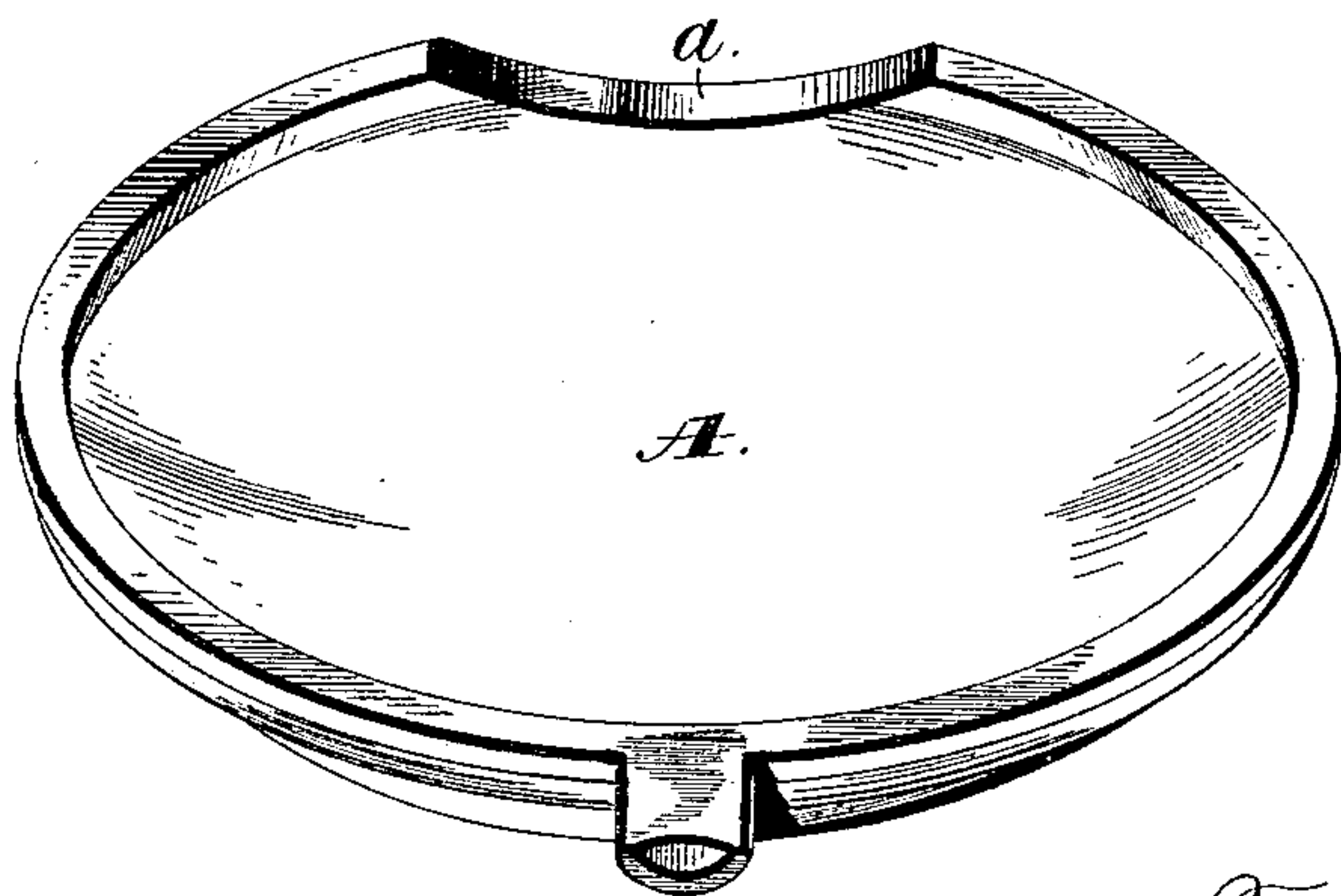


Fig. 2.

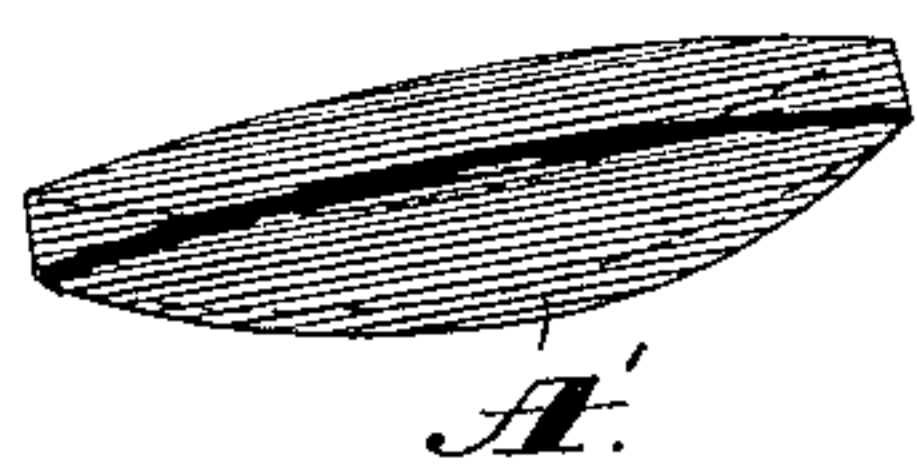


Fig. 3.

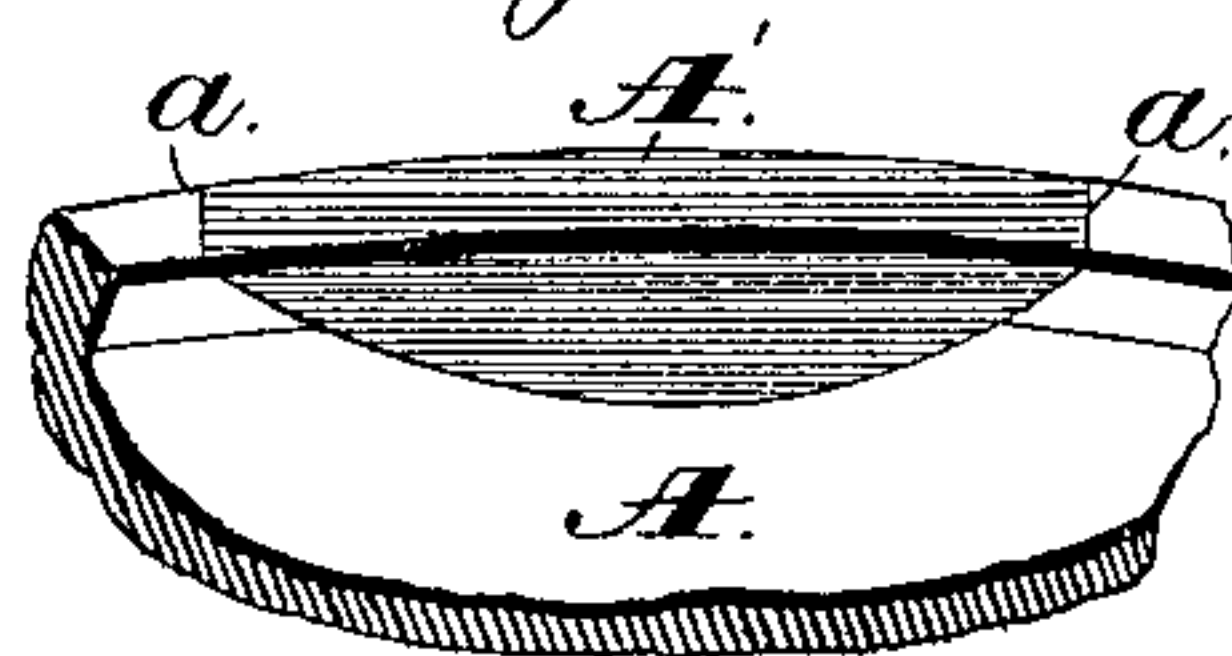


Fig. 4.

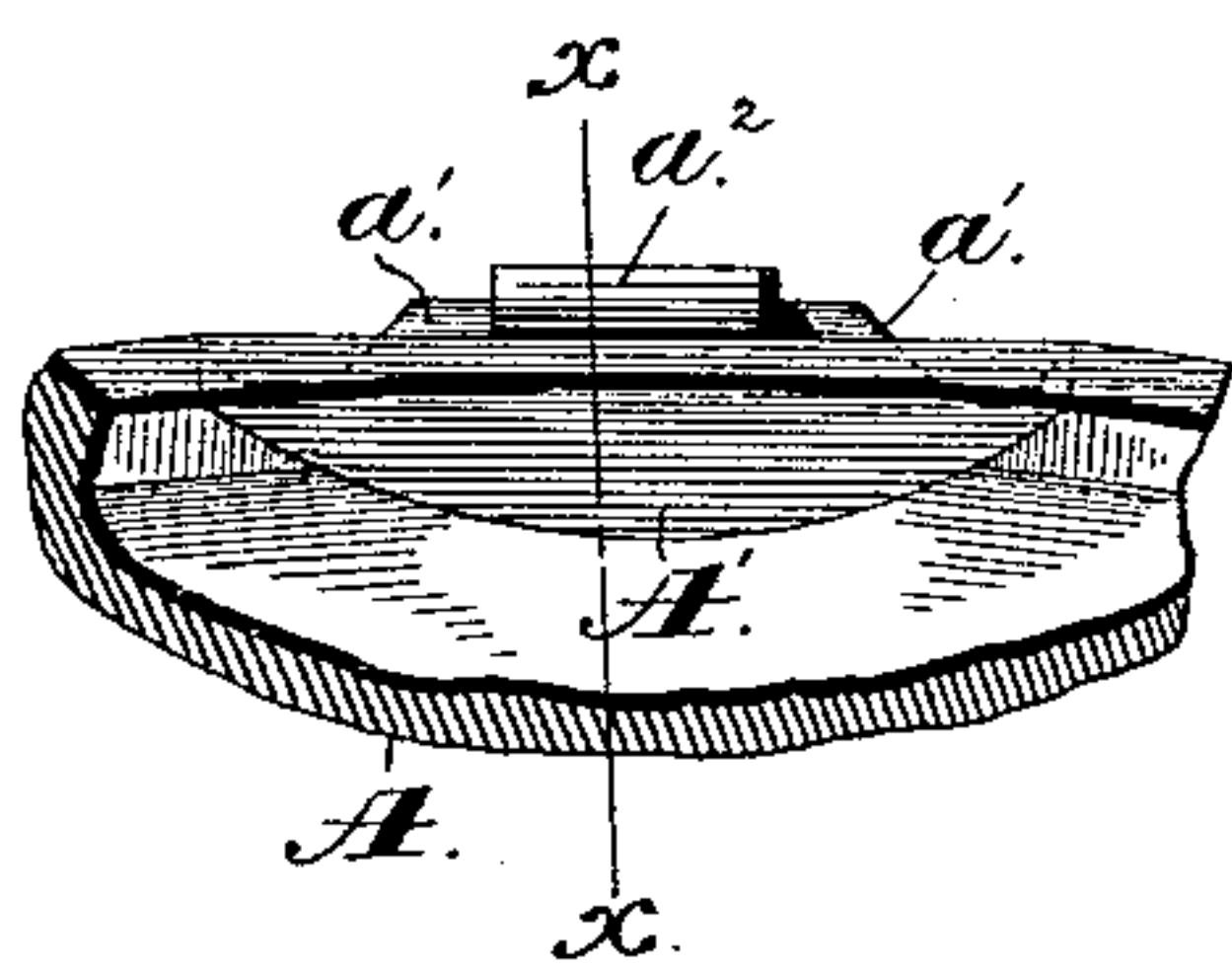
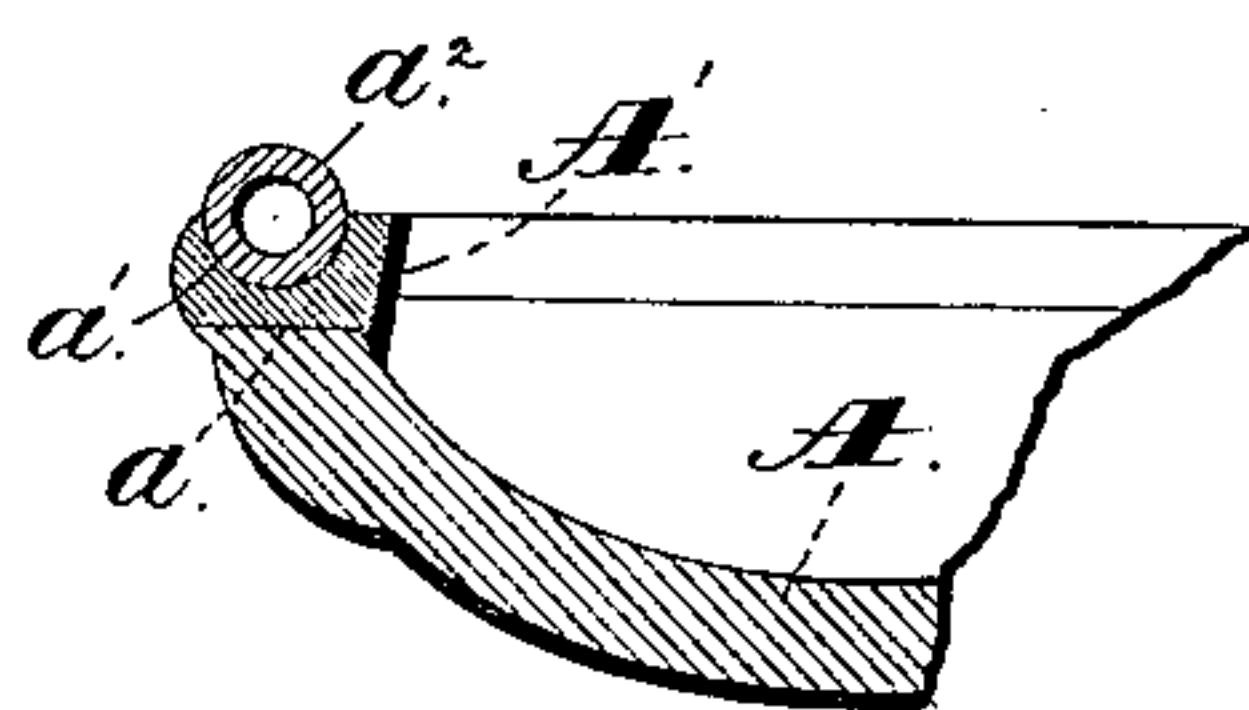


Fig. 5.



Witnesses:

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W. H. Fitz Gerald, by
Prindle & Russell, his Attys

UNITED STATES PATENT OFFICE.

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

MANUFACTURE OF WATCH-CASES.

SPECIFICATION forming part of Letters Patent No. 353,932, dated December 7, 1886.

Application filed June 29, 1886. Serial No. 206,641. (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 new and useful Improvements in the Manufacture of Watch-Cases; 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 cover of a case prepared for the reception of a hinge-stay. Fig. 2 is a like view of a hinge-stay before attachment to a cover. Fig. 3 is a perspective view of said parts as combined. Fig.
15 4 is a like view of said cover with its part of the hinge completed, and Fig. 5 is a section upon line *xx* of Fig. 4.

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

20 In the construction of watch-cases the portion of the edge of each cover or bezel which is immediately over the hinge forms a stop for limiting the outward movement of said part when opened, and requires to be dressed with
25 a file in order that the cover or bezel may open to just the required distance. Where the case is solid, no difficulty is found in dressing the hinged parts without change of its appearance; but in the manufacture of filled cases it
30 has heretofore been impracticable to attach the hinge portion of a cover or bezel and fit the same to the center without removal of more or less of the plating, so as to cause the
35 such defect filled cases have been readily distinguished from solid ones.

The object of my invention is to enable the hinged parts of a filled watch-case to be fitted to or upon the center without exposing the
40 base metal; and to this end my said invention consists, principally, as an improvement in the manufacture of filled watch-cases, in the method of adapting a cover or bezel to be fitted to a case-center by first forming a recess within
45 such part wherever it requires to be dressed, and fitting into and securing within such recess a correspondingly-shaped piece of solid fine metal, substantially as and for the purpose hereinafter specified.

50 It consists, further, in the method of forming

the hinge portion of the cover or bezel of a watch-case by first forming within the edge of such part a recess that has a length substantially equal to the length of the hinge, next, inserting into and securing within such recess
55 a correspondingly-shaped piece of finer solid metal, next, forming within such inserted piece a groove or rabbet for the reception of the hinge-tube, and, lastly, securing said tube in place within such groove or rabbet, substantially as and for the purpose hereinafter
60 shown.

In the carrying of my invention into practice I form within the edge of each cover or bezel A a semicircular recess, *a*, which has a
65 length substantially equal to the length of the proposed hinge, and into such recess fit a correspondingly-shaped piece of solid fine metal, A', and secure the same in place therein by solder. Said block or stay A' may have such
70 size and shape as to exactly restore the original lines of said part A; but I prefer to have it extend downward upon the inside, as shown in Fig. 5, so as to furnish increased strength
75 for the hinge. The cover A is now fitted upon a case-center and a groove or rabbet, *a'*, cut within the stay A', for the reception of a hinge-tube, *a''*, after which said tube (together with the tubes upon said center) is broached out, a
80 pin inserted, and the portion of said stay immediately above said tube is dressed off until said cover will open to just the desired distance, which operations are performed in solid fine metal and without liability to expose the
85 filling of said cover. When the covers are fitted around the pendant of the case, a piece of fine metal, like the hinge-stay, is inserted at such point, and the fitting done entirely within such solid piece. The result of the operations described is the production of a filled
90 case in which no portion of the filling of the covers or bezels is exposed; but a fine metal surface is secured upon both the inside and outside of the hinge-joint and where the parts are fitted around the pendant.

95 Having thus described my invention, what I claim is—

1. As an improvement in the manufacture of filled watch-cases, the method of adapting a cover or bezel to be fitted to a case-center, 100

which consists in first forming a recess within such point wherever it requires to be dressed, and fitting into and securing within such recess a correspondingly-shaped piece of solid
5 fine metal, substantially as and for the purpose specified.

2. The method of forming the hinge portion of the cover or bezel of a watch-case, which consists in first forming within the edge of such
10 part a recess that has a length substantially equal to the length of the hinge, next inserting into and securing within such recess a correspondingly-shaped piece of finer solid metal,

next forming within such inserted piece a groove or rabbet for the reception of the hinge- 15 tube, and, lastly, securing said tube in place within such groove or rabbet, substantially as and for the purpose shown.

In testimony that I claim the foregoing I have hereunto set my hand this 27th day of 20 March, A. D. 1886.

WALTER H. FITZ GERALD.

Witnesses:

EDW. O. WEED,
AUGUST BENCKE.