

(Model.)

3 Sheets—Sheet 1.

W. H. FITZ GERALD.

WATCH CASE CENTER.

No. 353,933.

Patented Dec. 7, 1886.

Fig. 1.

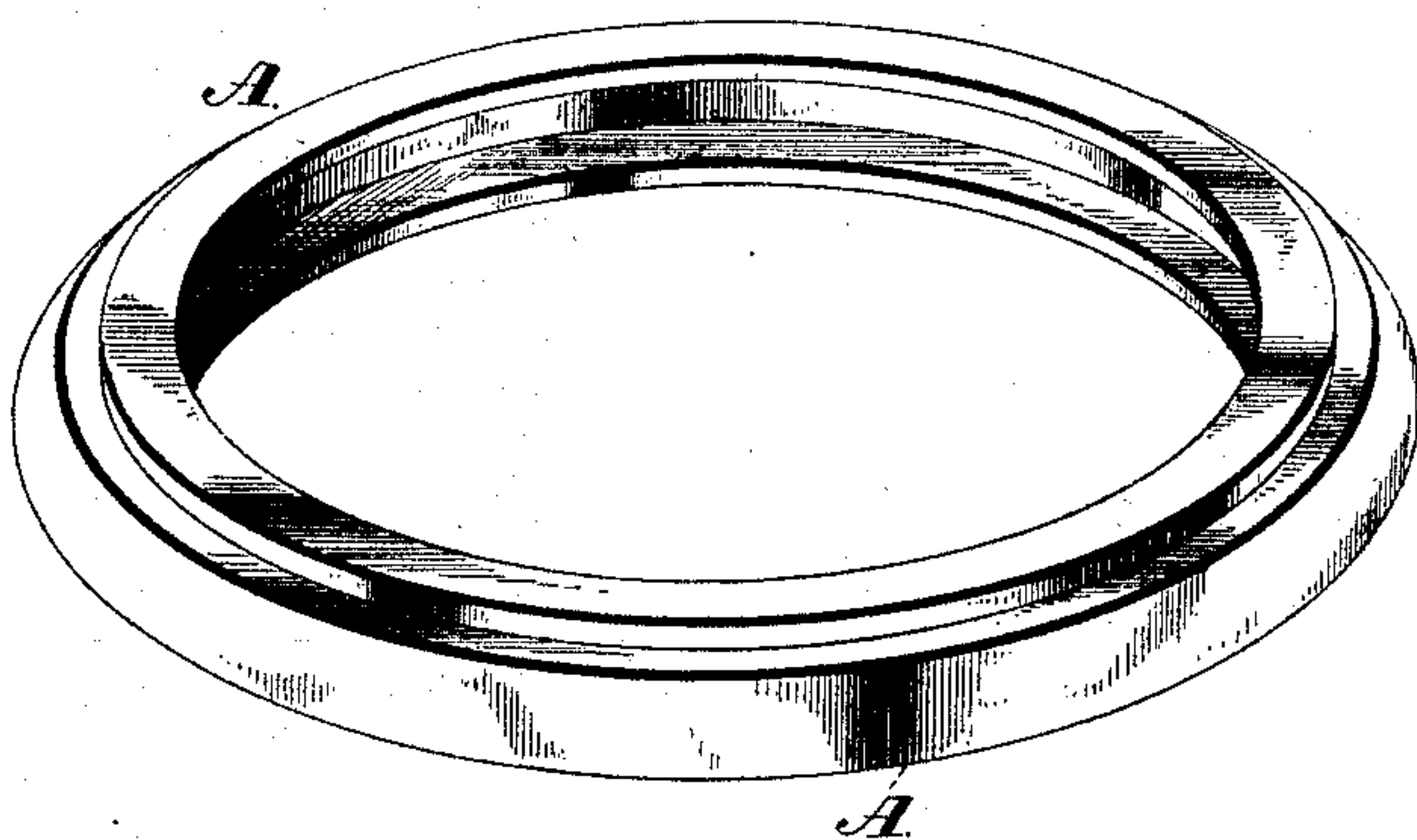


Fig. 2.

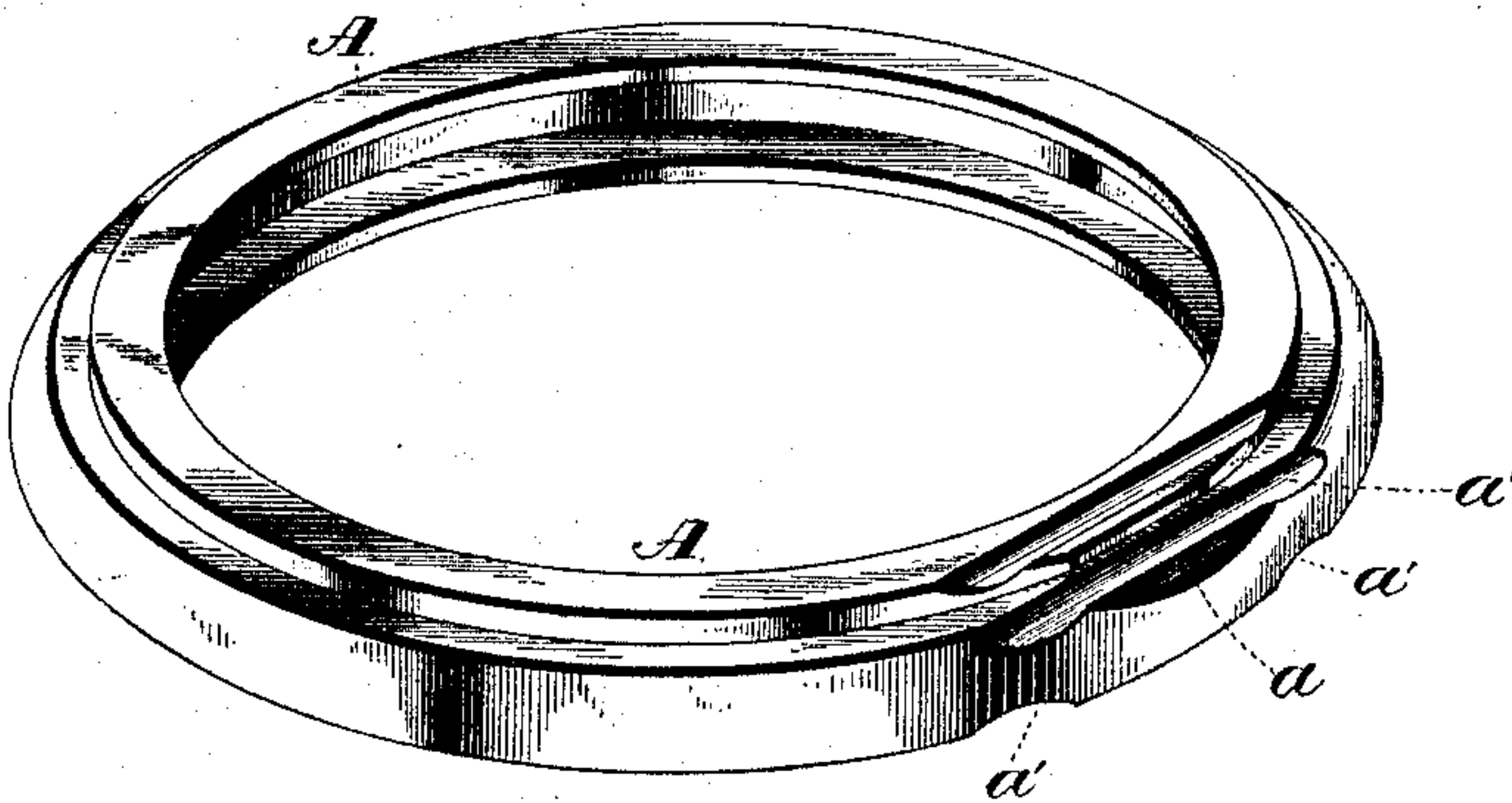
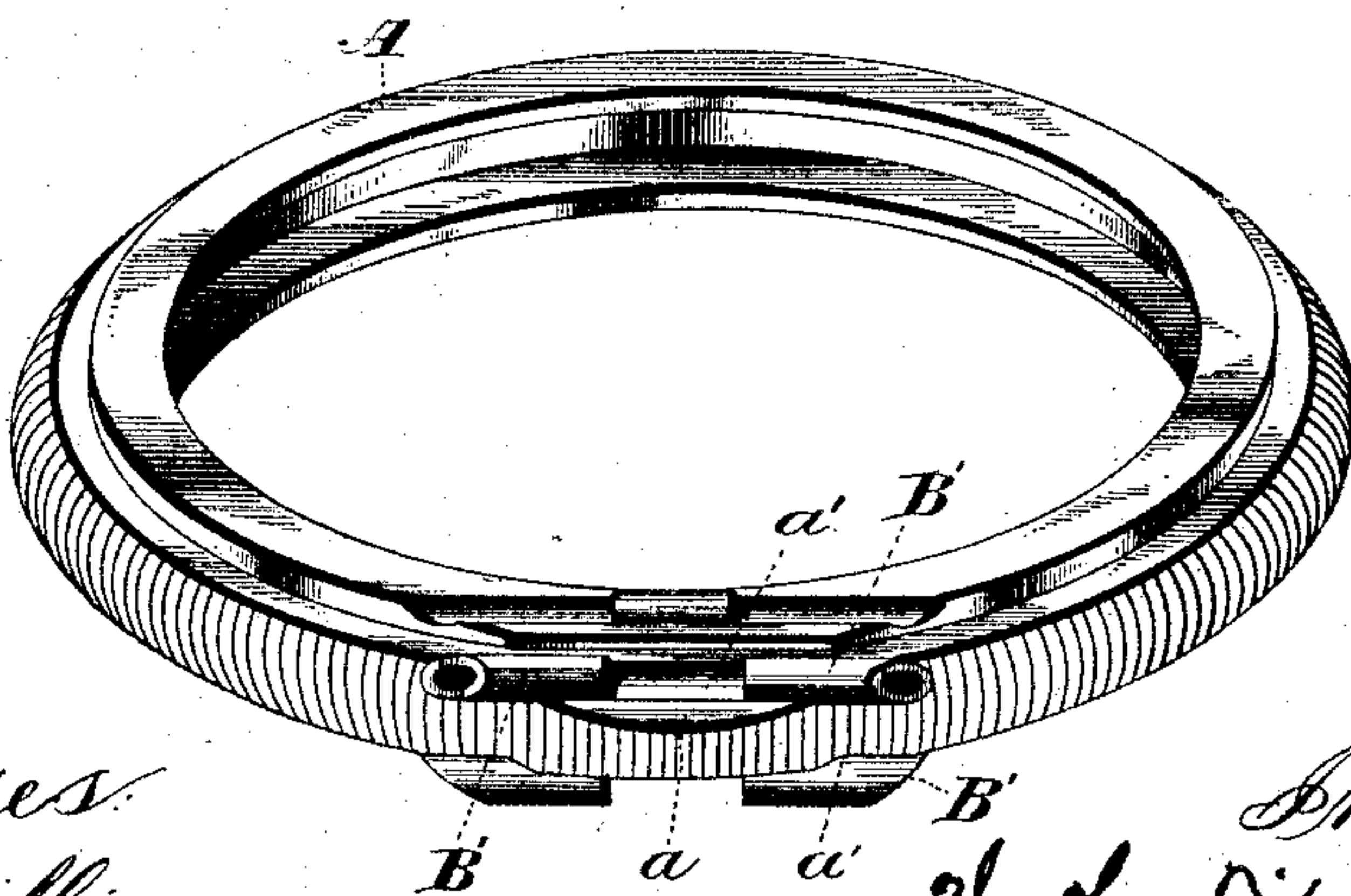


Fig. 3.



Witnesses:
Chas. J. Williamson
Henry C. Hazard

Inventor:
W. H. Fitz Gerald, by
Prindle and Russell, his Attys

(Model.)

3 Sheets—Sheet 2.

W. H. FITZ GERALD.

WATCH CASE CENTER.

No. 353,933.

Patented Dec. 7, 1886.

Fig. 4.

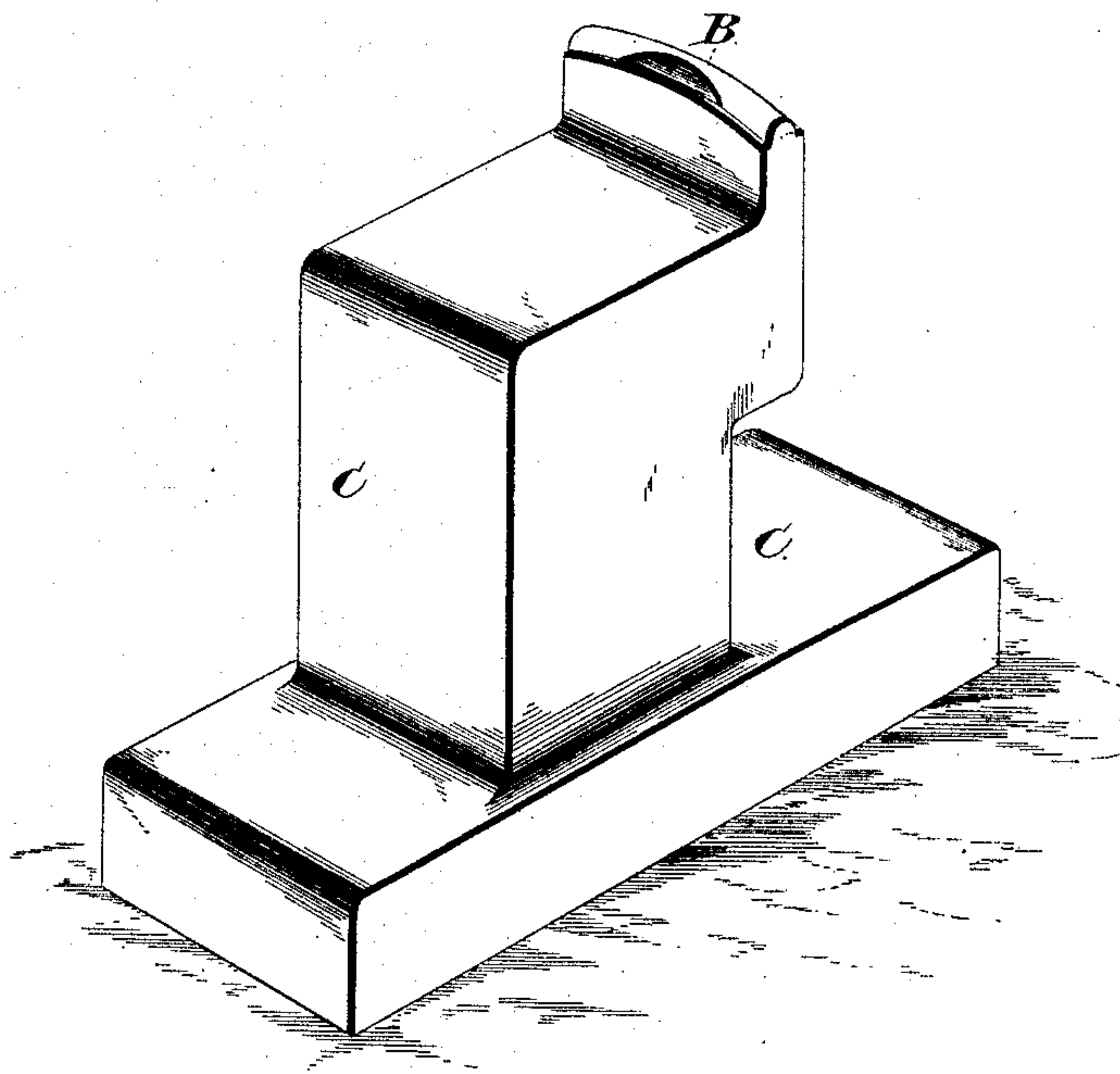
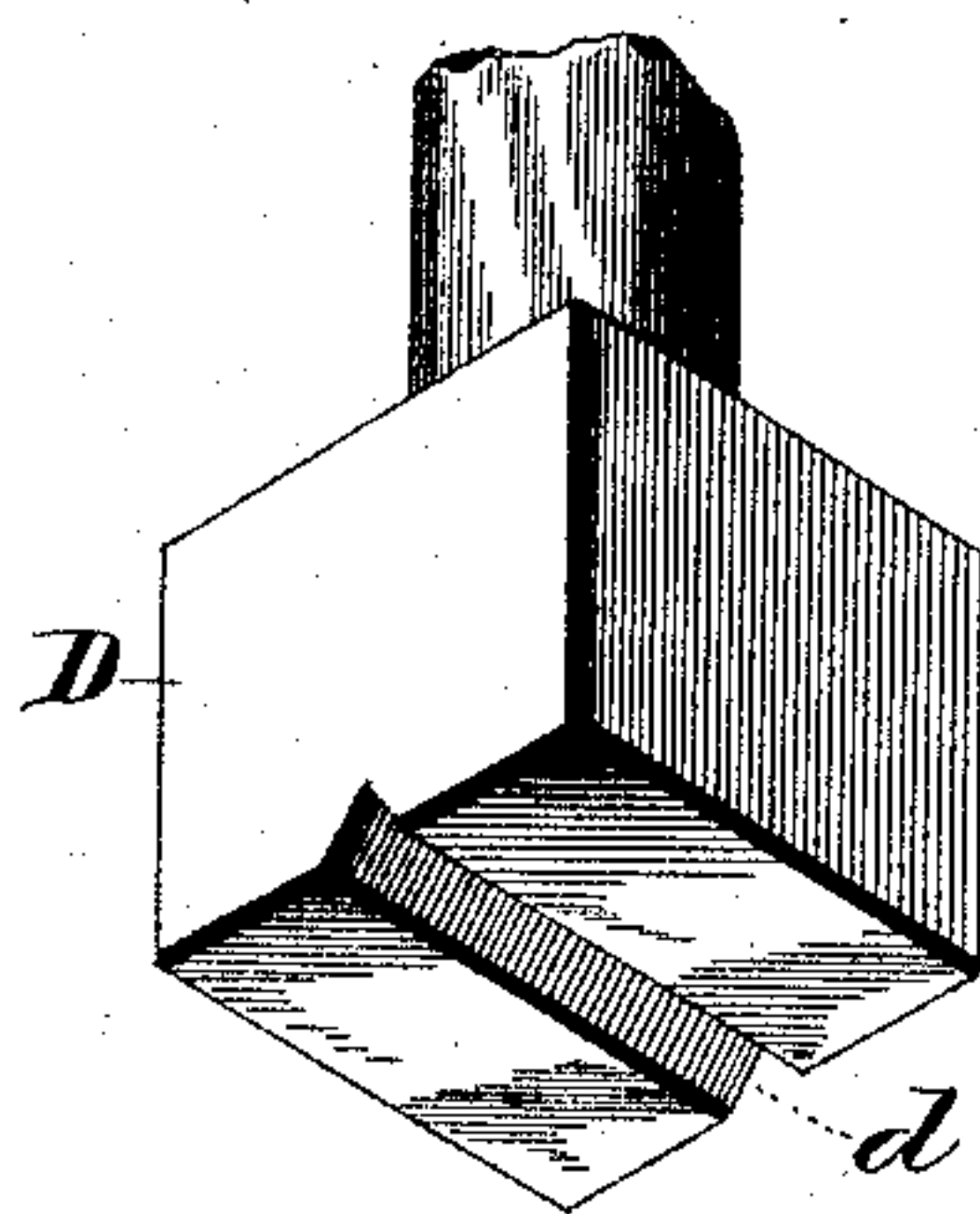


Fig. 5.



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

Inventor:
W. H. Fitz Gerald, by
Grindle & Russell, his Attys.

(Model.)

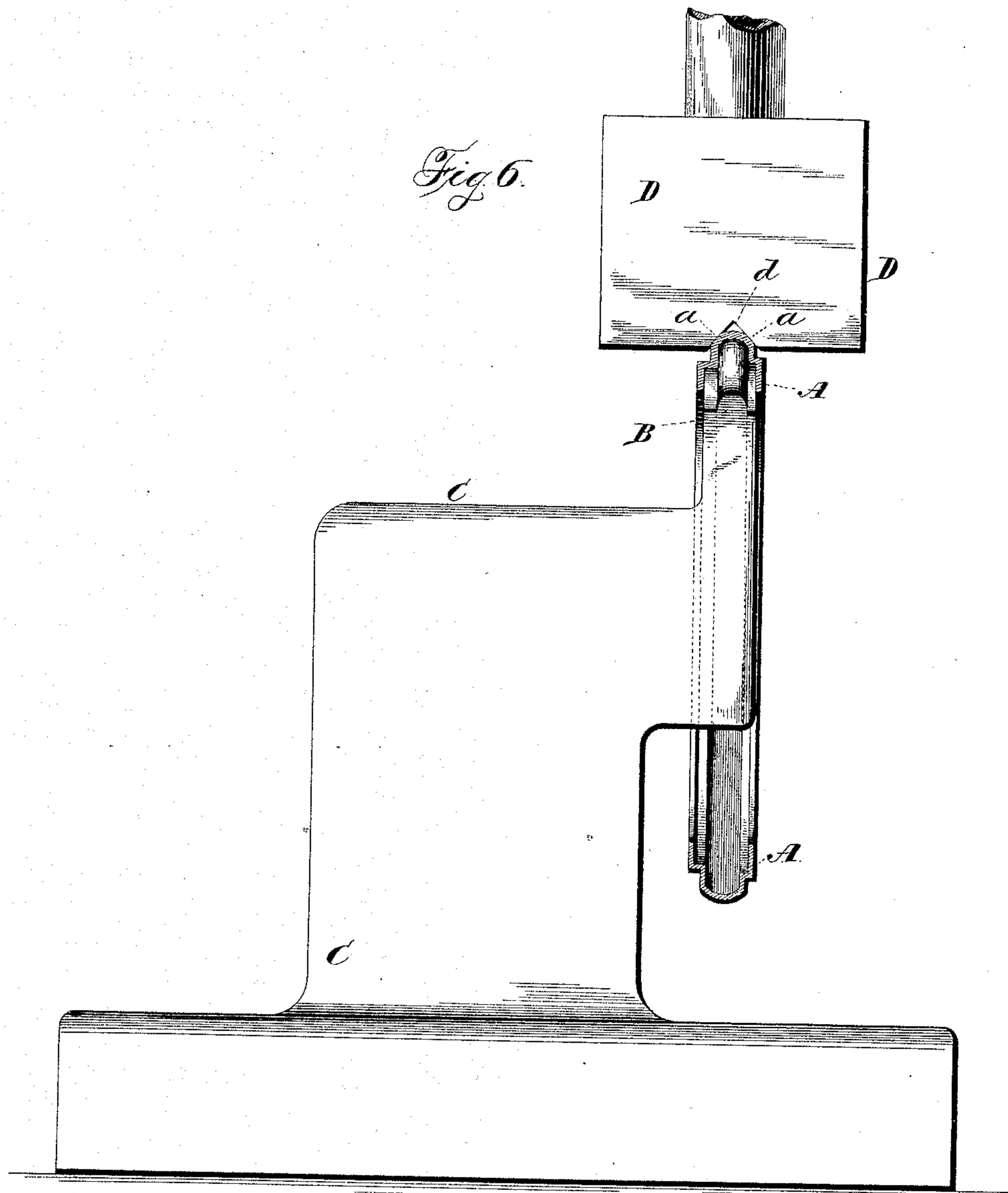
W. H. FITZ GERALD.

3 Sheets—Sheet 3.

WATCH CASE CENTER.

No. 353,933.

Patented Dec. 7, 1886.



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

Inventor:
W. H. Fitz Gerald, by
Crindle and Russell his Attys

UNITED STATES PATENT OFFICE.

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

WATCH-CASE CENTER.

SPECIFICATION forming part of Letters Patent No. 353,933, dated December 7, 1886.

Application filed October 28, 1886. Serial No. 217,490. (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 new and useful Improvements in Watch-Case Centers; 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—

Figure 1 is a perspective view of my case-center before being provided with hinge-rabbets. Fig. 2 is a like view of the same after being provided with the hinge-rabbets and operated upon by the beveling-dies. Fig. 3 is a perspective view of said part after the hinges are in place. Fig. 4 is a like view of the holder or lower die for said case-center. Fig. 5 is a perspective view of the beveling-die, and Fig. 6 is a side elevation of said holder and die and a vertical cross-section of said case-center in position between the same.

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

In the construction of filled watch-cases it has heretofore been customary to cut the hinge-rabbets within the center and to bevel the sides of the contiguous metal after said center was otherwise completed, by which means the fine metal of the surface was removed and the base-metal filling exposed, the result being that in the completed case there was at each hinge a part of the center which was not plated or covered by the fine metal, and which would quickly tarnish. To remedy this defect, the part thus exposed has been afterward plated; but as it is not practicable by such means to exactly match the color of the covering of the other portions of the case the appearance of the part so treated has been but little, if any, better than when the filling has been exposed.

The design of my invention is to cause a filled watch-case to present a uniform appearance over the whole of its outer exposed surface; and to such end said invention consists, principally, as a new article of manufacture, in a filled watch-case center which has adjacent to each hinge-rabbit a beveled face that is covered by a plate which is a part of and continuous with the surface-covering of the body of said case-center, substantially as and for the purpose hereinafter specified.

It consists, further, as a new article of manufacture, in a filled watch-case center which is provided with a beveled face adjacent to each hinge-rabbit, and has its body and beveled faces covered exteriorly by a plate that is continuous, substantially as and for the purpose hereinafter shown.

It consists, further, as a new article of manufacture, in a filled watch-case center which is provided with a beveled face adjacent to each hinge-rabbit, and such beveled face is covered by a plate that is integral with and forms a part of the covering of the body of said case-center, substantially as and for the purpose hereinafter set forth.

It consists, finally, as a new article of manufacture, in a watch-case center which is constructed principally of or from a base metal, and is provided with a beveled face adjacent to each hinge-rabbit, and has its body and beveled faces covered by a plate of relatively fine metal, which forms a continuous surface over the same, substantially as and for the purpose hereinafter shown and described.

In the carrying of my invention into practice I preferably employ certain mechanism for producing beveled faces upon a case-center; but such mechanism forms no part of this invention, and, if desired, may be omitted wholly or in part and other forms of mechanism used for the purpose named.

In the annexed drawings, A represents a case-center blank which is preferably constructed by dies from sheet metal, and in cross-section has a convex exterior and a correspondingly concave interior. The case-center thus shaped is placed upon an anvil or die, B, that substantially conforms in cross-section to the like interior form of said part, and circumferentially within the same has a length of about one-half inch. Said die is suitably supported upon a base, C, so as to enable said case-center to be suspended therefrom, as shown. The case-center A being thus in position upon the anvil-die B, a second die, D, having a V-shaped groove, *d*, within its lower face, is caused to impinge upon the upper portion of the convex periphery of said case-center, so as to form upon such portion two inclined or beveled faces, *a*, one of which is upon each side of said center. The portions of said

lower die that are immediately beneath said faces *a* are correspondingly beveled, so as to cause the metal of said case-center to be solidly compressed between the same and the sides of the groove *d*, and the exact shape desired to be given to said faces *a*.

Immediately below each of the beveled faces *a* there is now cut a rabbet, *a'*, for the reception of the hinge-tubes *B'*, which latter are secured in place in the usual manner after the periphery of the case-center has been knurled or otherwise ornamented. If desired, such ornamentation may be produced before said rabbets are cut. The operation of forming the beveled faces in no manner disturbs or displaces the fine-metal covering which is continuous over the whole surface of said case-center, so that said faces are as fully protected as is any other portion of said surface.

The mechanism and method hereinbefore described are covered by a separate application for patent, Serial No. 202,756, filed May 20, 1886.

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

1. As a new article of manufacture, a filled watch-case center which has adjacent to each hinge-rabbit a beveled face that is covered by a plate which is a part of and continuous with the surface covering of the body of said case-

center, substantially as and for the purpose specified.

2. As a new article of manufacture, a filled watch-case center which is provided with a beveled face adjacent to each hinge-rabbit, and has its body and beveled faces covered exteriorly by a plate that is continuous, substantially as and for the purpose shown.

3. As a new article of manufacture, a filled watch-case center which is provided with a beveled face adjacent to each hinge-rabbit, and such beveled face is covered by a plate that is integral with and forms a part of the covering of the body of said case-center, substantially as and for the purpose set forth.

4. As a new article of manufacture, a watch-case center which is constructed principally of or from a base metal, and is provided with a beveled face adjacent to each hinge-rabbit, and has its body and beveled faces covered by a plate of relatively fine metal which forms a continuous surface over the same, substantially as and for the purpose shown and described.

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

WALTER H. FITZ GERALD.

Witnesses:

WM. B. HURD, Jr.,

CHAS. O. GRIM.