

(No Model.)

A. H. POTTER.

MANUFACTURE OF WATCH PLATES AND CASES.

No. 360,818.

Patented Apr. 5, 1887.

Fig. 1.

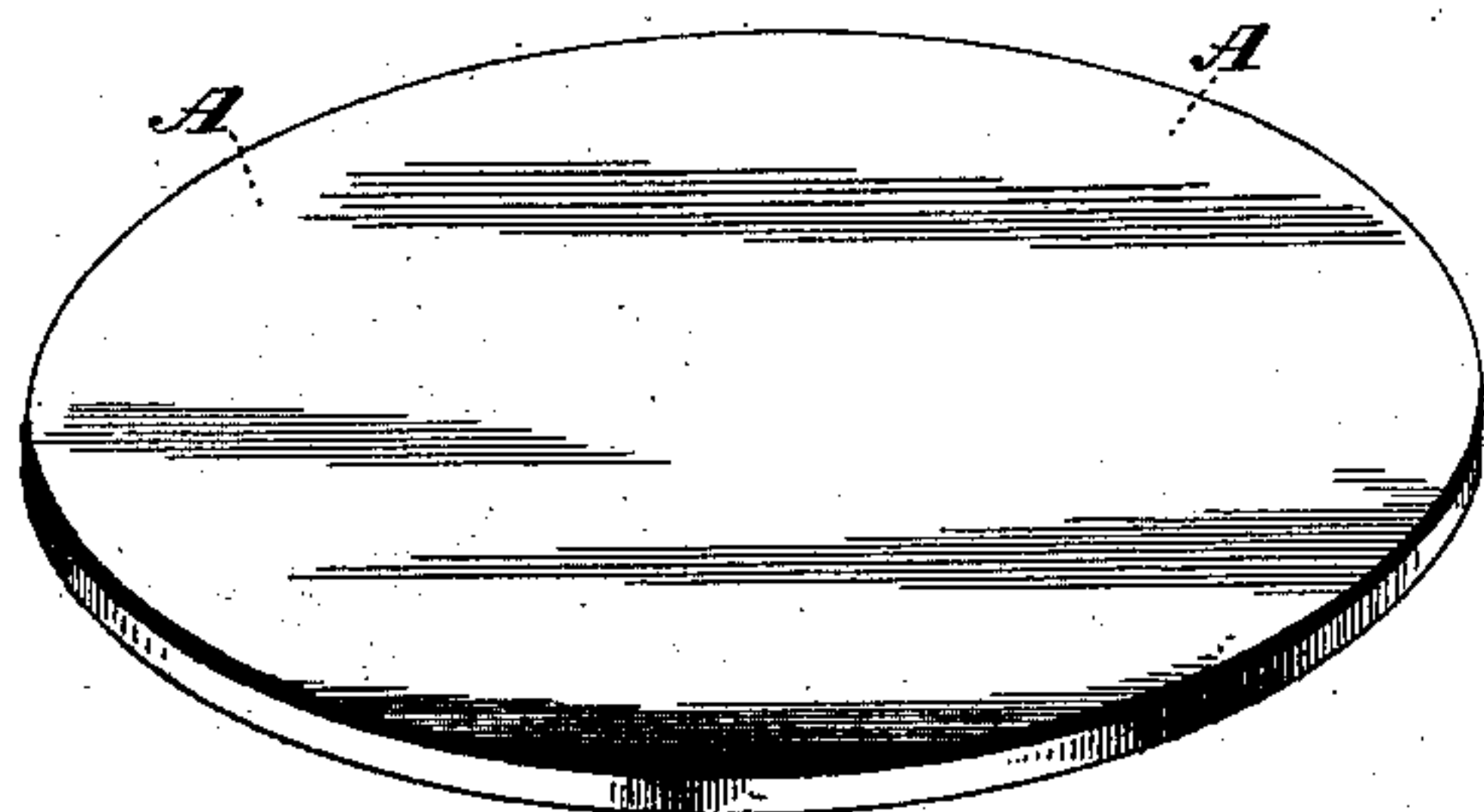


Fig. 2.

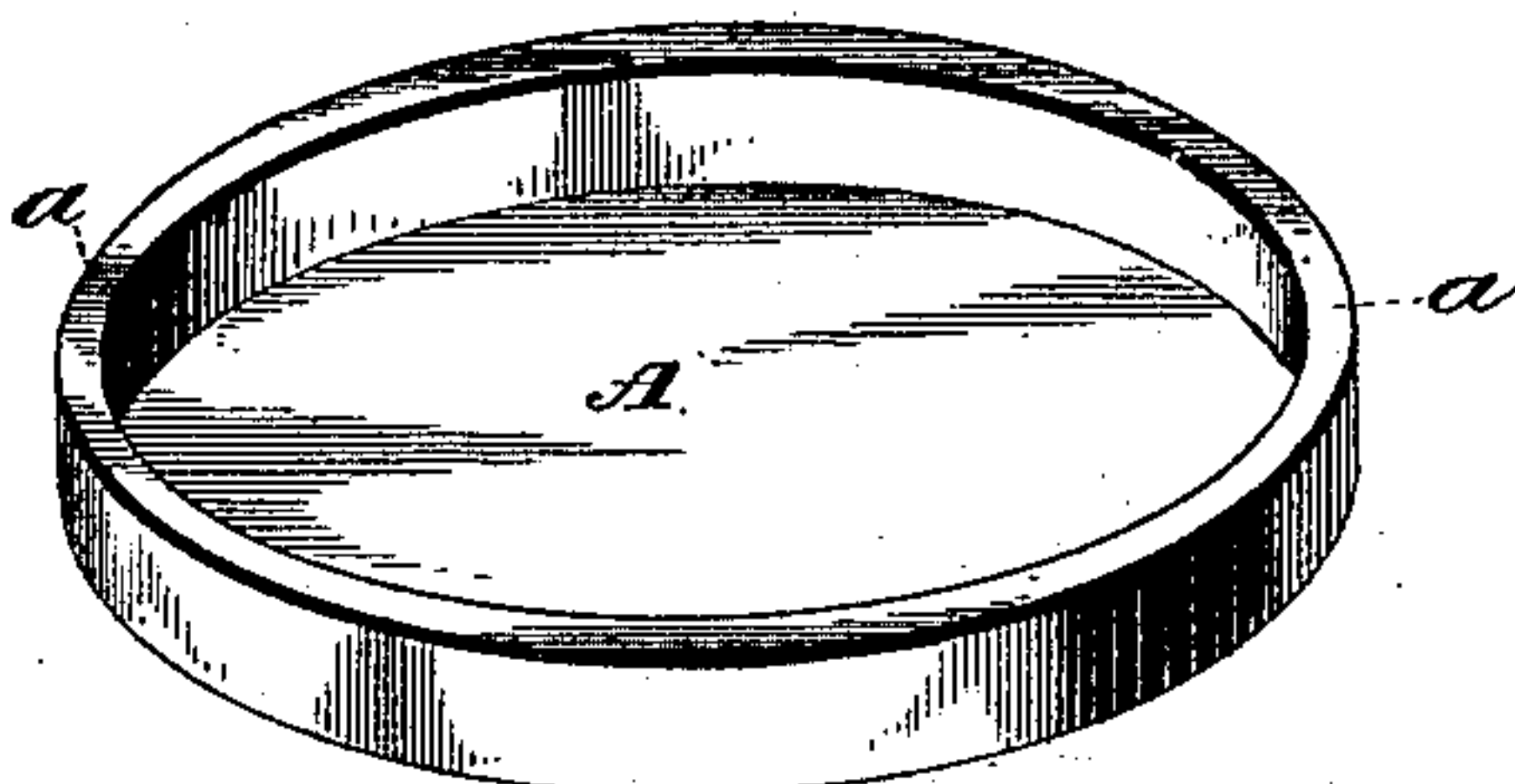


Fig. 3.

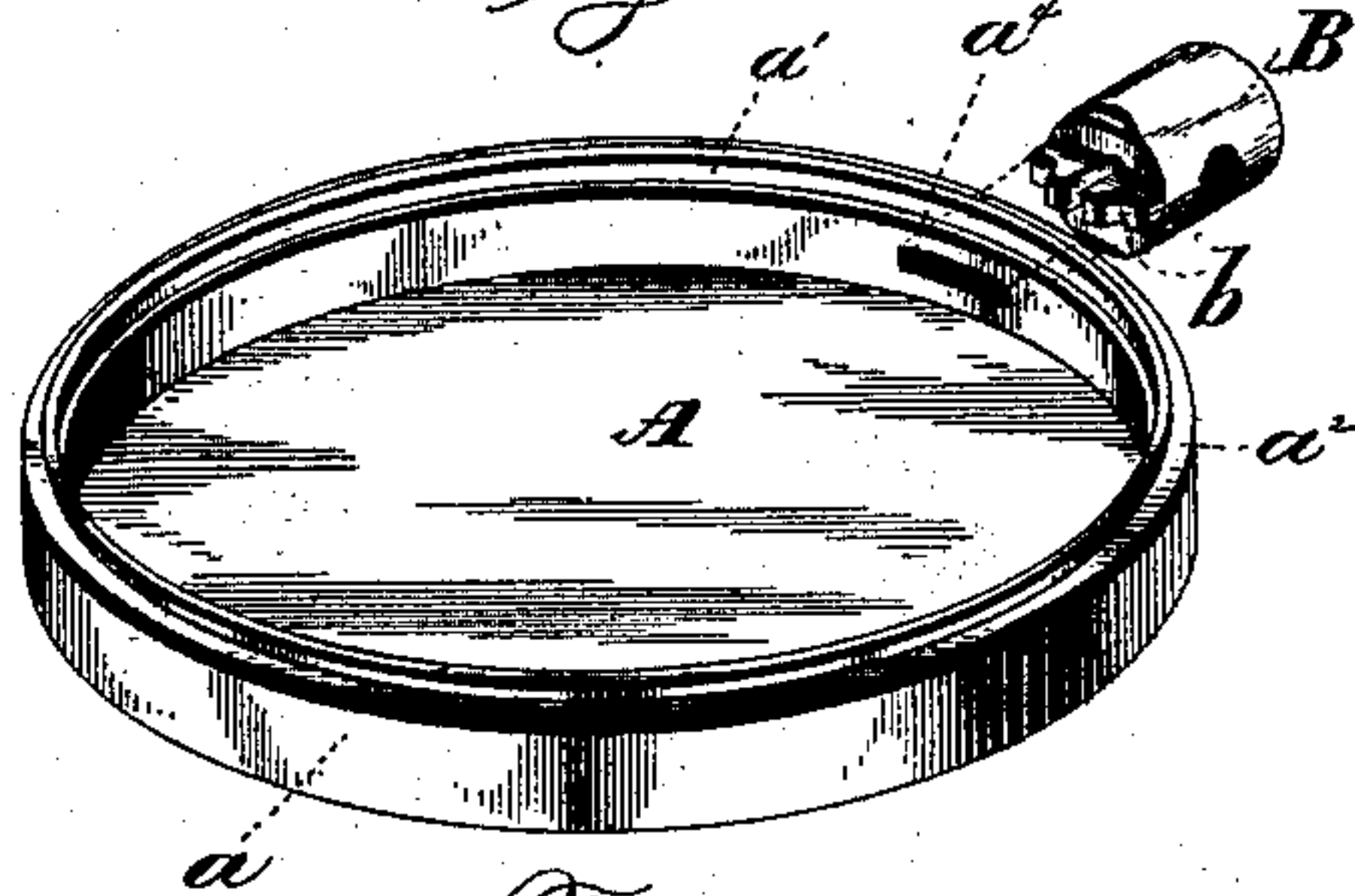


Fig. 4.

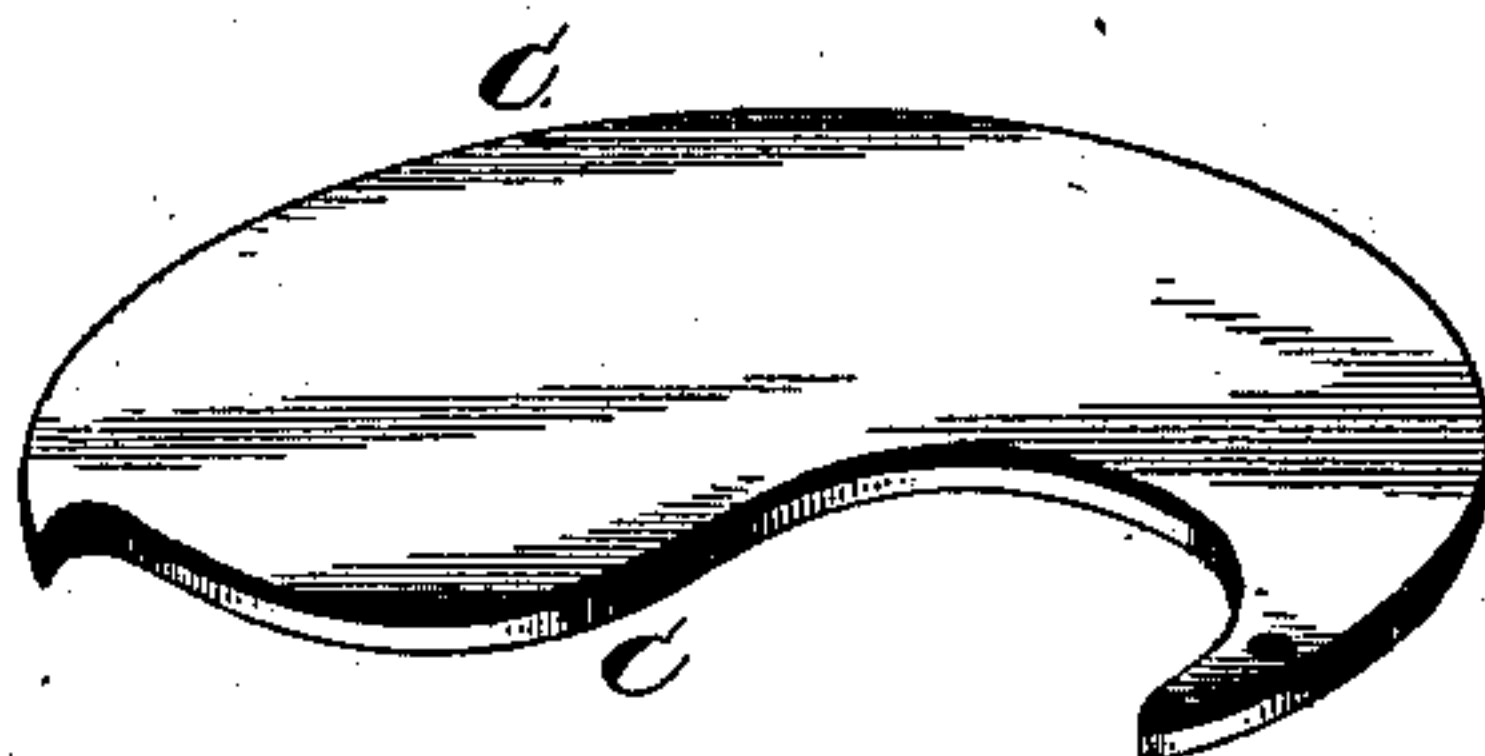


Fig. 5.

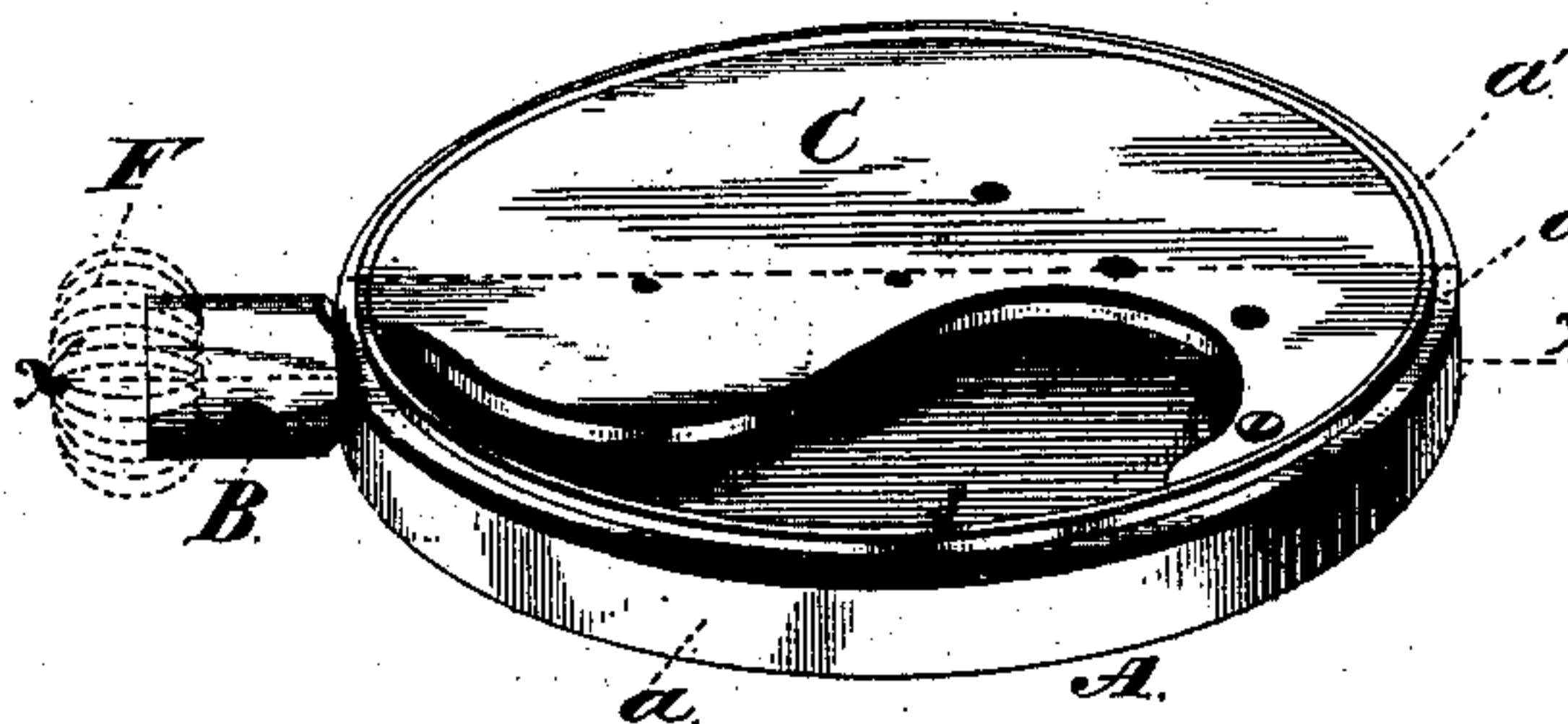


Fig. 6.

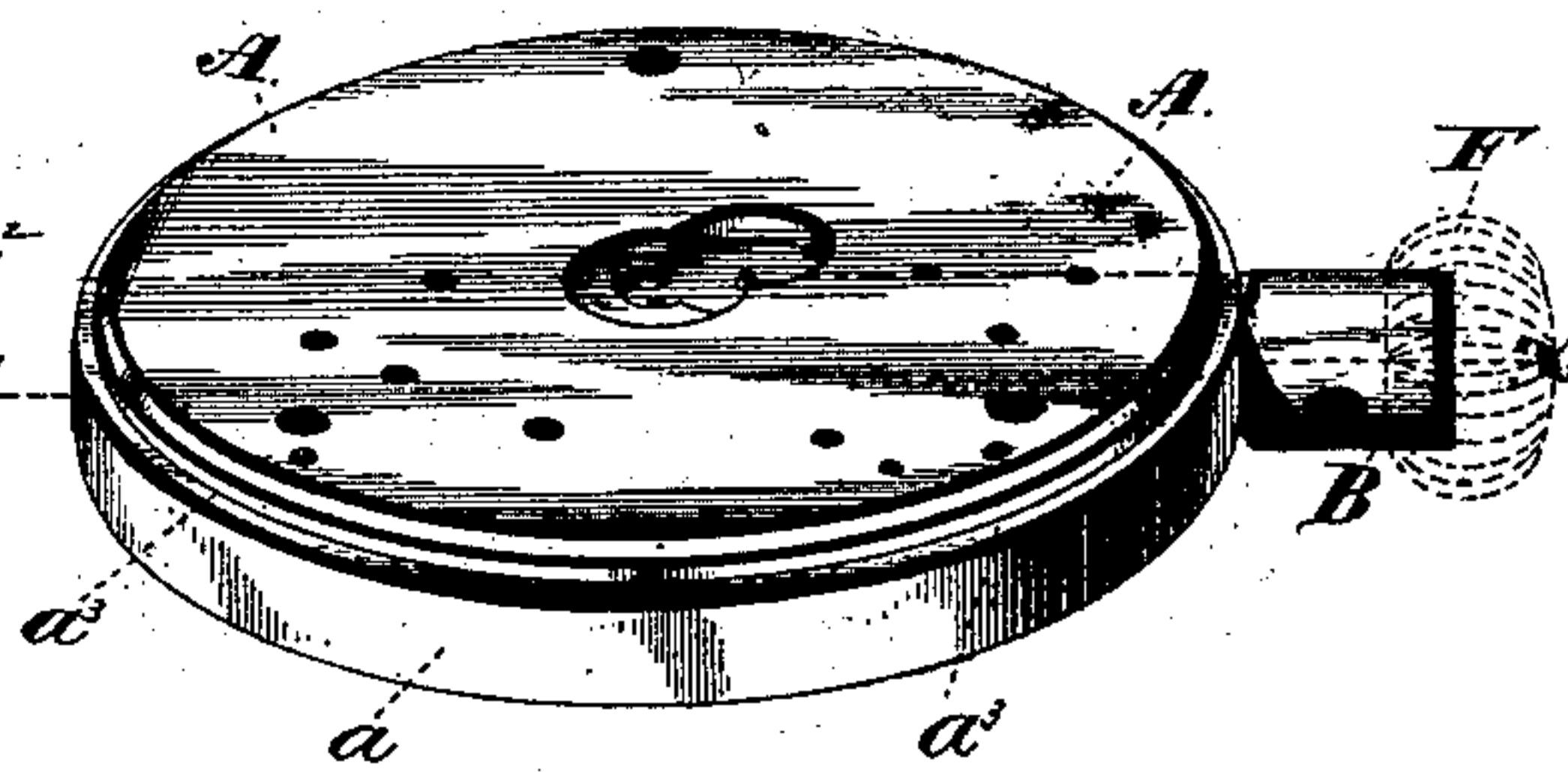


Fig. 7.

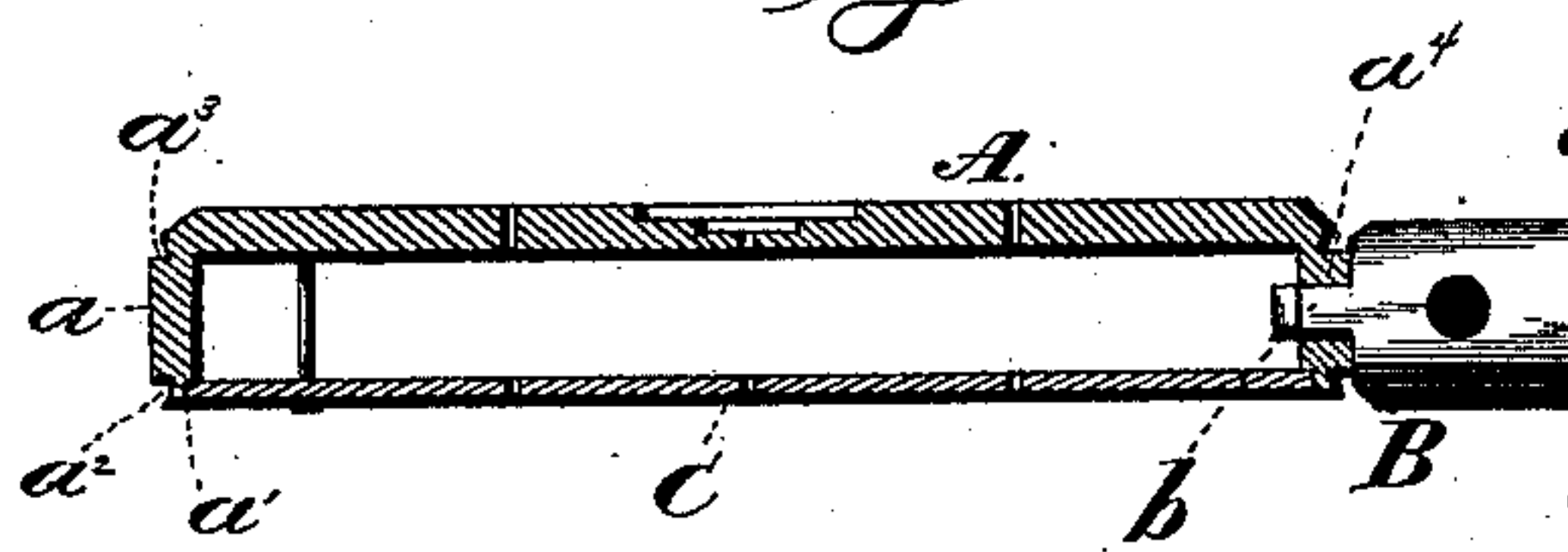
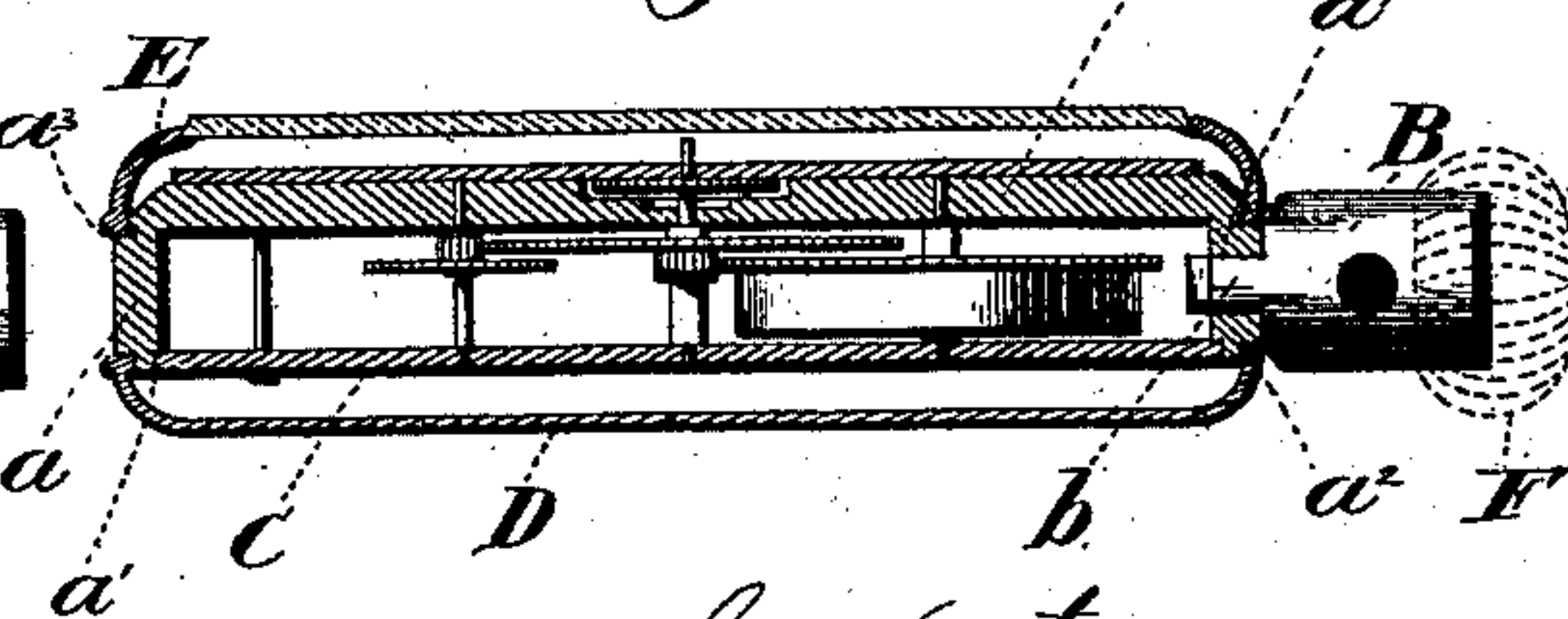


Fig. 8.



Witnesses:

Chas. Williamson  
Henry C. Hazard.

Inventor:

Albert H. Potter, by  
Crindle and Russell, his Attys.



# UNITED STATES PATENT OFFICE.

ALBERT H. POTTER, OF GENEVA, SWITZERLAND, ASSIGNOR TO THE NEW HAVEN WATCH COMPANY, OF NEW JERSEY.

## MANUFACTURE OF WATCH PLATES AND CASES.

SPECIFICATION forming part of Letters Patent No. 360,818, dated April 5, 1887.

Application filed August 26, 1886. Serial No. 211,879. (No model.)

*To all whom it may concern:*

Be it known that I, ALBERT H. POTTER, of Geneva, in the Republic of Switzerland, have invented certain new and useful Improvements in the Manufacture of Watch Plates and 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 blank as cut from a sheet of metal. Fig. 2 is a like view of the same after having been subjected to the action of the cupping-dies. Fig. 3 is a perspective view of the pendant and the combined movement-plate and case-center after having been prepared for the reception of the back plate, back cover, and pendant. Fig. 4 is a like view of said back plate. Figs. 5 and 6 are respectively perspective views from the front and back of said movement-plate and case-center, pendant and back plate when completed and united for use. Fig. 7 is a section of the same upon line *x x* of Figs. 5 and 6, and Fig. 8 is a like view of a completed watch containing the said improvements.

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

30 The design of my invention is, mainly, to enable watches to be constructed more cheaply than has heretofore been practicable; and to this end my said invention consists, principally, in the method employed for constructing the movement-frame and case-center, substantially as and for the purpose hereinafter specified.

35 It consists, further, in the method employed for combining the case-center and pendant, substantially as and for the purpose hereinafter shown.

40 It consists, finally, in the method employed for constructing the watch-case and movement-frame, substantially as and for the purpose hereinafter set forth.

45 In the carrying of my invention into practice a disk, A, is cut from a sheet of metal, and by means of dies has a flange, *a*, turned upward around its edge, as shown in Fig. 2. The part A now has its entire inner and outer surfaces dressed off in a lathe, and within the inner and outer corners of the flange *a* are cut right-an-

gled rabbets *a'* and *a''*, respectively, while within the corner of its opposite side is cut a third rabbet, *a'''*. The plate A constitutes the front movement-plate of a watch and its flange *a* the center of the case therefor, and at a suitable point within the latter is provided a radial rectangular opening or mortise, *a''''*, for the reception of the inner end of a pendant, B. Said pendant has at its inner end a tenon, *b*, that corresponds to and is adapted to closely fill said opening *a''''*, and when inserted therein is secured in place by the heading down of its inner projecting end.

55 Within the inner rabbet, *a'*, is fitted a back movement-plate, C, which is cut from a plain sheet of metal and has the usual form, as seen in Fig. 4. Said plate is held in place by a steady pin and screw, or any of the means ordinarily employed, and between the same and the plate A are journaled the parts of the time-train. The rabbet *a''* receives a case-back, D, and the rabbet *a'''* a glass-bezel, E, while within the pendant is journaled a stem-arbor with a crown, F, all of usual construction, which completes the watch.

60 It will be seen that by my method a large saving is effected in the number of parts over watches of usual construction; that the movement-frame is much stronger than would be practicable if made wholly separate from the case, and that within my case there is considerably more space for the train than could be had in a case of the same exterior dimensions of ordinary make.

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

1. The method of constructing a case-center and movement-plate, which consists, first, in cutting a disk from sheet metal, next in forming around the edge of said disk an upward-turned flange, and, finally, in adapting the inner edge of said flange to the reception of a back movement-plate and its outer edge and the edge of the disk for engagement by a case-back and glass-bezel, substantially as and for the purpose specified.

2. The method of combining a watch case-center and pendant, which consists in forming within the case-center a radial rectangular opening, and upon the pendant a correspond-

ing rectangular tenon, and then inserting the latter within said mortise and heading down its inner projecting end, substantially as and for the purpose shown.

- 5 3. The method employed for constructing a combined movement-frame and watch-case, which consists, first, in providing a disk of sheet metal with an upturned peripheral flange that constitutes a case-center, next in fitting  
10 into and securing within the periphery of said case-center a radial pendant, next in inclosing the space within said case-center with a sepa-

rable movement-plate, and, finally, fitting upon opposite sides of the plates thus combined a case-back and a glass-bezel, substantially as 15 and for the purpose set forth.

In testimony that I claim the foregoing I have hereunto set my hand this 31st day of July, A. D. 1886.

ALBERT H. POTTER.

Witnesses:

GEO. S. PRINDLE,  
HENRY C. HAZARD.