

(No Model.)

H. LEFORT.

ART OF FORMING PENDANTS FOR WATCHES.

No. 372,158.

Patented Oct. 25, 1887.

Fig. 1.

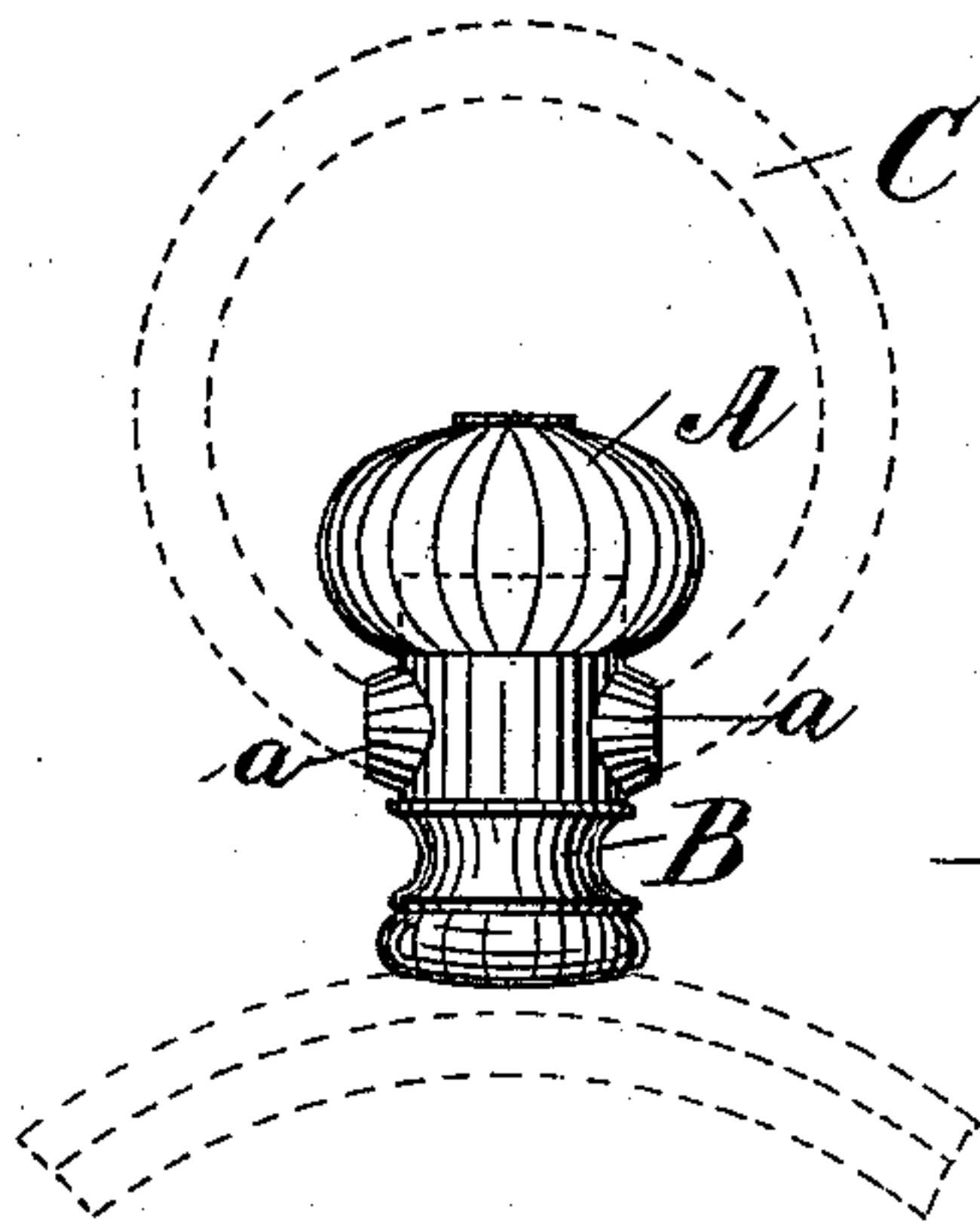


Fig. 3.

Fig. 7.

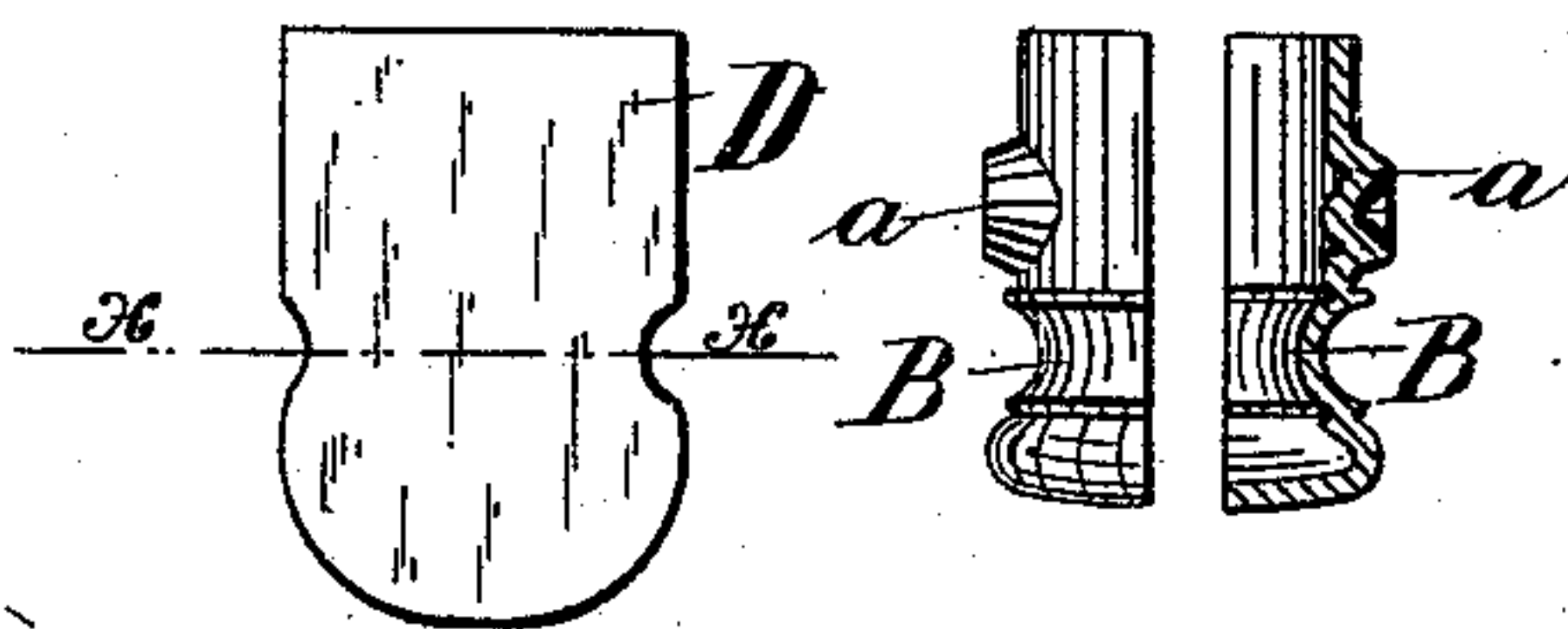


Fig. 4.

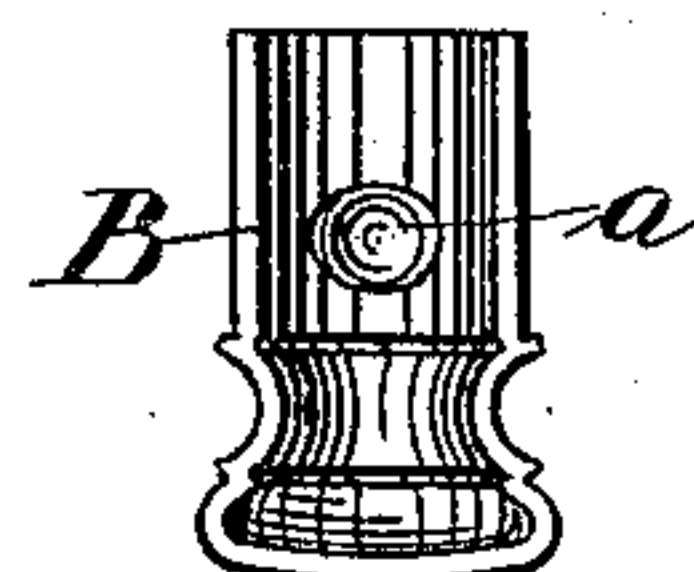
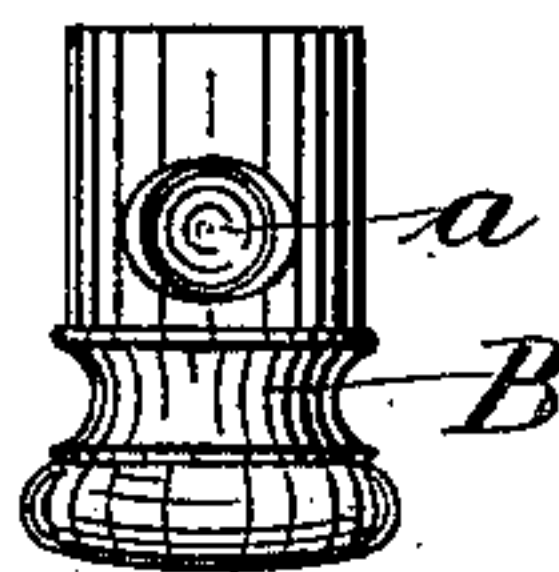
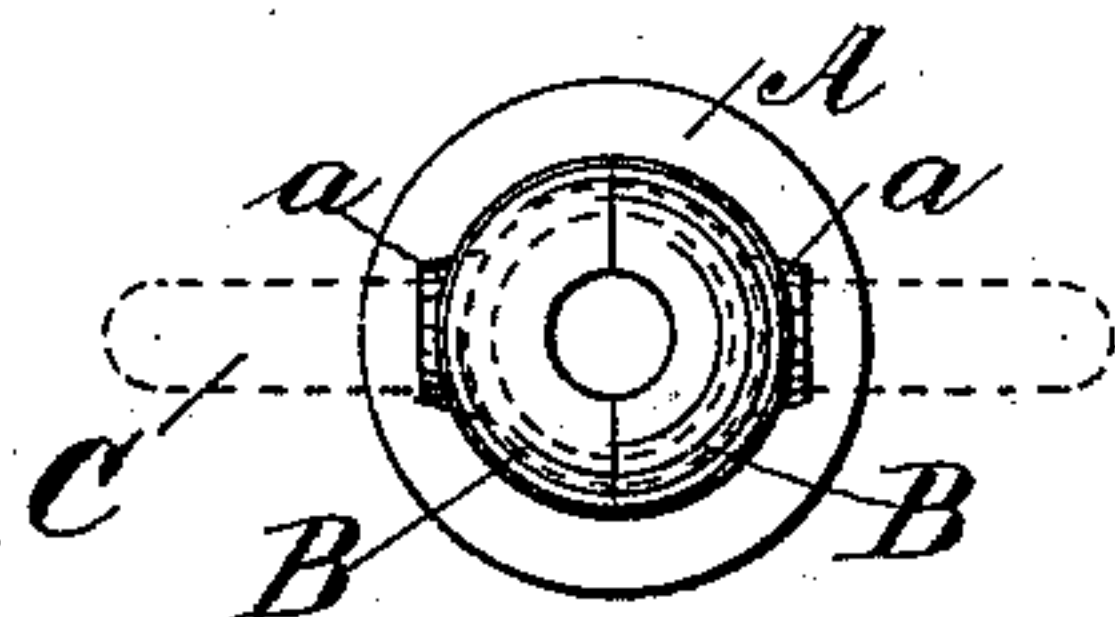
Fig. 8.



Fig. 2.

Fig. 5.

Fig. 6.



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ART OF FORMING PENDANTS FOR WATCHES.

SPECIFICATION forming part of Letters Patent No. 372,158, dated October 25, 1887.

Application filed April 4, 1887. Serial No. 233,578. (No model.)

To all whom it may concern:

Be it known that I, HENRY LEFORT, a citizen of the United States, and a resident of the city of Newark, in the county of Essex and State of New Jersey, have invented certain new and useful Improvements in Pendants for Stem-Winding Watches, of which the following is such a full, clear, concise, and exact description as will enable others skilled in the art to which my invention appertains to make and use the same, reference being had to the accompanying drawings, forming part of this specification.

In the formation of pendants for stem-winding watches it is necessary that they be made tubular or hollow, so as to receive the push-pin, and also that they be provided with openings to receive the ring of the watch. The openings which receive the ring are made upon opposite sides of the pendant; and, in order to properly finish such portions of the pendant, ears or lugs are usually soldered upon the outside of the pendant, and through which such openings also extend. In making such a pendant it has heretofore been customary to take a single tubular piece of metal and finish the same inside and out by grinding or boring until the desired form and polish have been given to it, and to then solder the ears or lugs, before referred to, thereon, when the holes for receiving the watch-ring are bored through the same. The several operations required, when such method is followed, are necessarily expensive, because of the amount of labor required and the filings of the extra material required in such a case.

The object of my invention is to cheapen the cost of manufacturing pendants by forming and finishing the same with as little material and labor as possible; and to this end the invention consists in making a pendant of two parts, which are stamped from blanks and brought into shapes adapted to be united together by soldering, while at the same time the ears for the watch-ring are stamped out of the same piece of metal, as hereinafter more fully described and claimed.

In the drawings, Figure 1 is a front elevation of a pendant when the crown is placed thereon and its other connections are made; and this figure shows the ring of the watch by dot-

ted lines, and, by similar lines, a portion of the watch-case. Fig. 2 is a plan view of the same pendant and ring of the watch when looking from below. Fig. 3 shows a blank formed of metal of suitable shape, to be stamped or drawn up so as to form one-half of the pendant, and Fig. 4 is a cross-section of the same, taken on the line *xx* of Fig. 3. Fig. 5 is a side elevation of one-half of the pendant after being drawn up or stamped from the blank shown by Figs. 3 and 4, when looking at the outside or back thereof, while Fig. 6 is a similar view of the reverse or inside of such half. Fig. 7 shows the two portions ready to be joined together, the right-hand part, however, being shown in section, as indicated by the line *yy* of Fig. 8, which latter figure is an end view of the two halves ready to be united together.

In the drawings, A represents the crown and B the pendant, while C indicates the watch-ring.

In order to form the pendant, a blank piece of metal, D, of the required shape—as, for example, that shown in Fig. 3—is taken, and by means of suitable dies the same is drawn or brought up into the form of a half of the pendant, as shown by Figs. 5 and 6. The same die may be made to stamp the ears *aa* upon such halves, or these ears may be formed by another stroke or operation with a separate die. When the metal is thus shaped, the finishing is very easily accomplished owing to the accessibility of the inside portion. After the finishing, which in such case is slight, the two corresponding halves of the pendant are placed in their relative position to each other, the edges thereof being brought together or soldered, and the pendant is then practically complete. If the holes for receiving the ring are not already finished, this may be done after uniting the two halves together; but, as the ears are already formed and are integral with the other portion, the work required in completing the pendant, so as to receive the ring, is very much less than when the ears have to be soldered thereon. In fact, the whole work of manufacturing pendants in this manner is very much less, and at the same time more expeditious, than when made in the old way.

Having thus described my invention, what

I claim as new, and desire to secure by Letters Patent, is—

The improvement in the art of forming pendants for stem-winding watches, which consists in stamping blanks of metal into shapes for halves of the pendants and in stamping the ears for receiving a ring from the same blanks,

then uniting the parts, and finishing the same, substantially as and for the purpose set forth.

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