

(No Model.)

P. STUCKER.
WATCH CASE BACK OR CAP.

No. 460,044.

Patented Sept. 22, 1891.

Fig. 1.

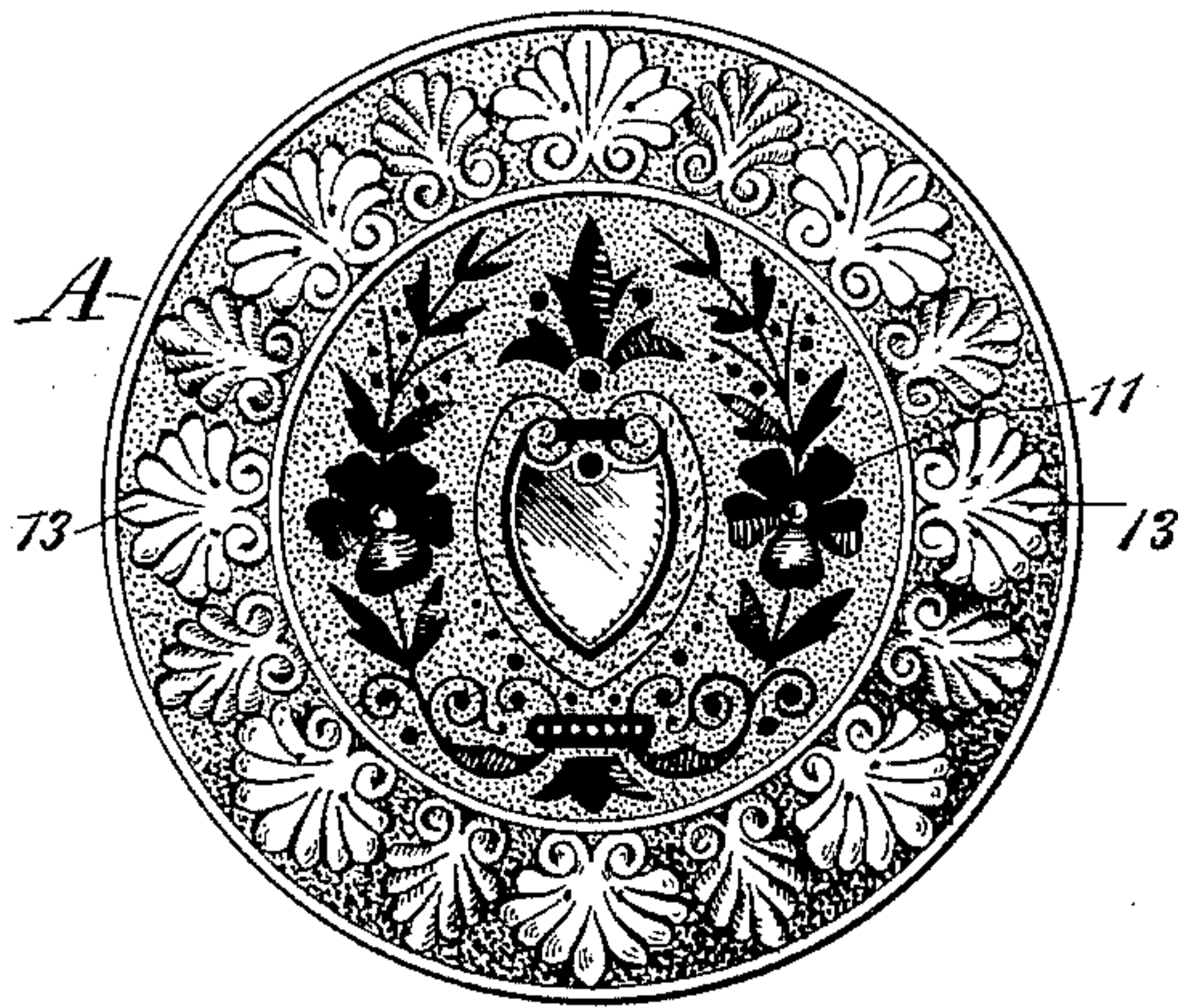
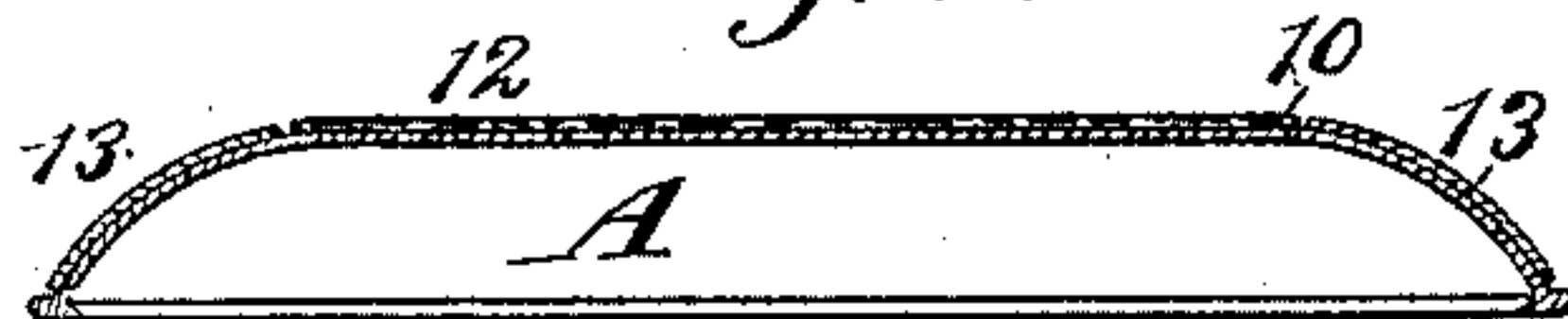


Fig. 2.



Fig. 3.



WITNESSES:

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PAUL STUCKER, OF BROOKLYN, NEW YORK.

WATCH-CASE BACK OR CAP.

SPECIFICATION forming part of Letters Patent No. 460,044, dated September 22, 1891.

Application filed March 21, 1891. Serial No. 385,913. (No model.)

To all whom it may concern:

Be it known that I, PAUL STUCKER, of Brooklyn, in the county of Kings and State of New York, have invented a new and useful Improvement in Watch-Case Backs or Caps, of which the following is a full, clear, and exact description.

My invention relates to an improvement in the manufacture of watch-case backs or caps and like articles of jewelry, and has for its object to provide a means whereby "raised" gold or embossed ornaments may be employed in connection with enameled surfaces or figures.

A further object of the invention is to provide a means whereby the watch-case back or cap may be made of exceedingly thin metal and yet be strong and stiff and highly ornamented with raised and enameled figures.

The invention consists in the novel construction and combination of the several parts, as will be hereinafter fully set forth, and pointed out in the claims.

Reference is to be had to the accompanying drawings, forming a part of this specification, in which similar figures of reference indicate corresponding parts in all the views.

Figure 1 is a plan view of a cap or back constructed in accordance with my invention. Fig. 2 is a diametrical section through the cap or back, illustrating the enameled surfaces as not stoned down; and Fig. 3 is a similar view to Fig. 1, illustrating the cap or back as finished.

Heretofore when watch-case caps or backs or other articles of jewelry have been ornamented with enameled figures, engraved or intaglio ornamentations only have been placed around or adjacent to the enameled surface, and it has also been necessary to use a heavy cap or back when the same is to be enameled. Intaglio ornaments only have been employed in connection with enamel ornamentations, as the enamel when baked puffs up above the surface of the cap or back and must be stoned or ground down flat; and in this operation as heretofore practiced if raised or embossed figures are located near the surface to be stoned the said figures are invariably marred to a great extent, and heavy cases also have been required, as the figures to be enameled have to be engraved quite deeply. I aim to

overcome these difficulties and to provide a means whereby an exceedingly light case may be used and ornamented extensively both with raised and enameled figures, and by so doing add to the strength of the caps or backs. To this end a plate 10 is soldered or otherwise tightly and permanently secured to the face of the cap or back A to be ornamented, the plate being located at the point where the enamel is to be laid. Thus at this point the cap or back is materially increased in thickness, as the cap or back proper is preferably made from very thin material. The plate 10 is engraved with a number of figures 11, if desired; and all or certain of the figures may be filled and preferably are filled with enamel 12, as illustrated. Raised gold or other metal figures 13 may be grouped, as desired, around the plate, and are securely soldered or otherwise firmly attached to the cap or back. The raised figures also tend to materially strengthen the cap or back, and the thickness of the raised gold is preferably the same as the thickness of the attached plate 10.

When the enamel has been introduced into the intaglio figures to be treated, it is necessary that the enamel should be baked in order to harden and fix it in position. During the process of baking the enamel puffs or raises to a great extent above the surface of the plate 10, as illustrated in Fig. 2, and the raised portions of the enamel must be stoned, ground, or otherwise reduced until the outer face of the enamel is flush with the outer face of the plate. By attaching the plate and enameling upon it and making the raised gold of equal thickness to the plate the cap or back may be manipulated in any manner to properly reduce the enamel without in the slightest degree interfering with the raised gold figures. It is evident that if the enamel figures were made, as heretofore, directly in the surface of the cap or back and the raised gold were located around the enamel surfaces the process of grinding down the enamel would be so exceedingly delicate as to require the services of an exceedingly skilled mechanic, and peculiarly-shaped grinding-tools would be required in order that the raised gold should not come in engagement with the grinding implements.

Having thus described my invention, I

claim as new and desire to secure by Letters Patent—

1. As an improved article of manufacture, a watch-case cap or back provided with an
5 attached plate cut *in intaglio* and the cut surfaces filled with enamel, and raised metal figures grouped around and adjacent to the plate, the thickness of the raised metal figures corresponding, essentially, to that of the plate,
10 as and for the purpose specified.

2. The combination, with a watch-case cap or back or a similar article of jewelry, the said cap or back being constructed of thin metal, of a plate attached to the cap or back
15 provided with indentures and enamel filling

the same, and raised metal figures secured to the cap or back around or adjacent to the plate, the said metal figures being of a thickness essentially equal to that of the plate, whereby the cap or back is strengthened and
20 the enamel surfaces may be polished, reduced, or otherwise treated without interfering with the adjacent or surrounding raised metal figures, substantially as and for the purpose specified.

PAUL STUCKER.

Witnesses:

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