

(No Model.)

E. C. FITCH.  
WATCHCASE PENDANT.

No. 539,255.

Patented May 14, 1895.

Fig. 1.

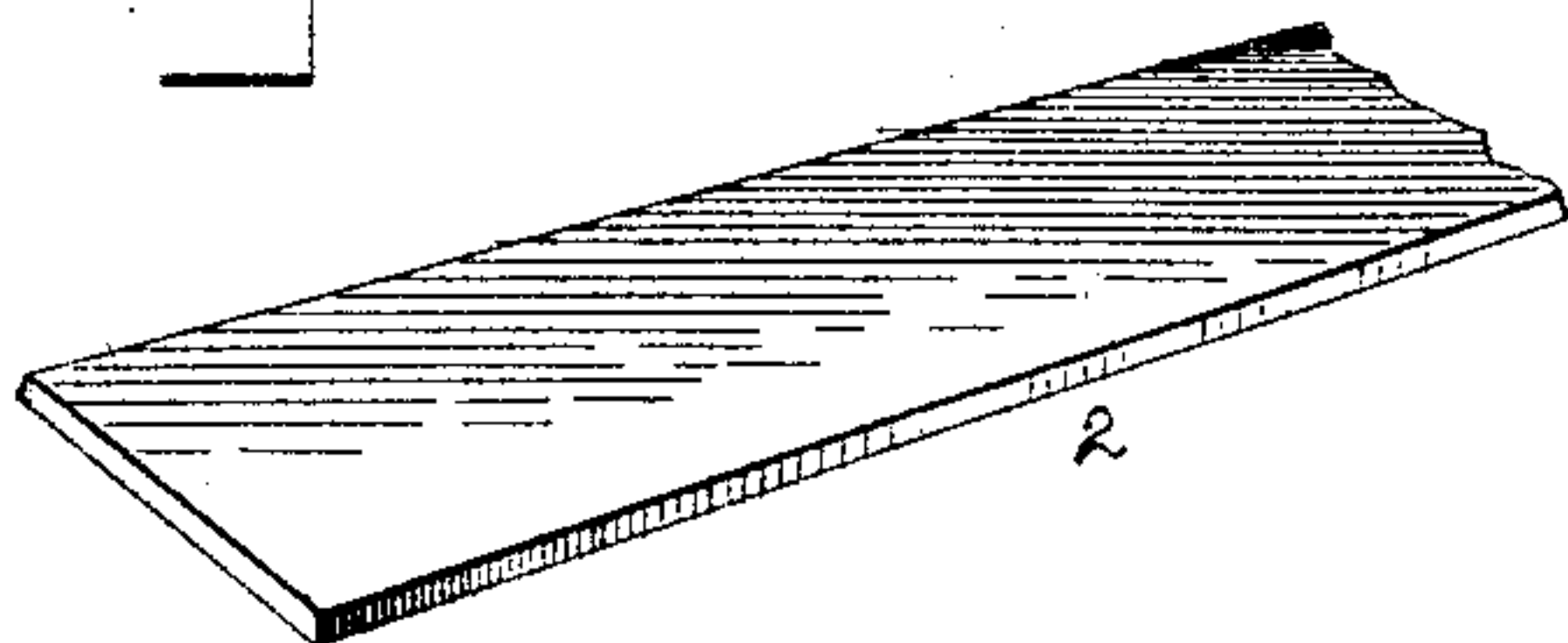


Fig. 2.

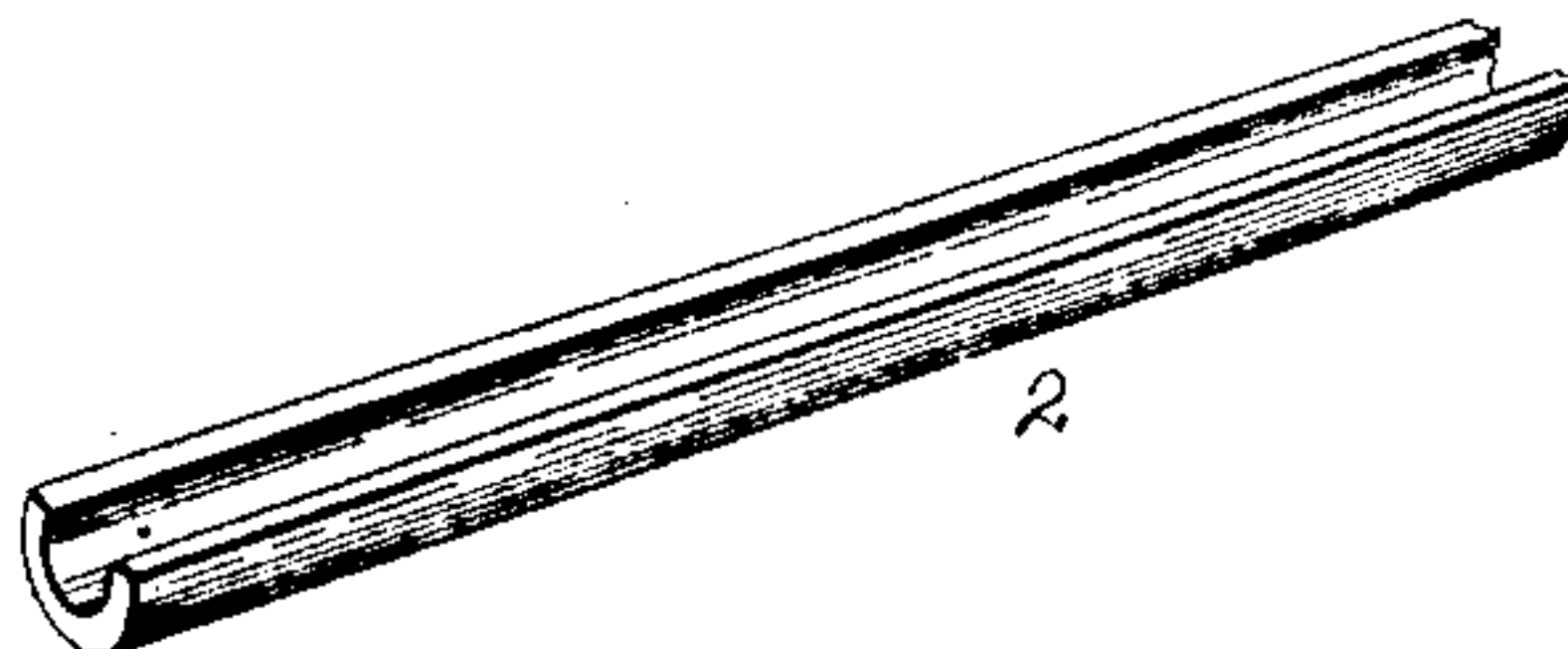


Fig. 3.

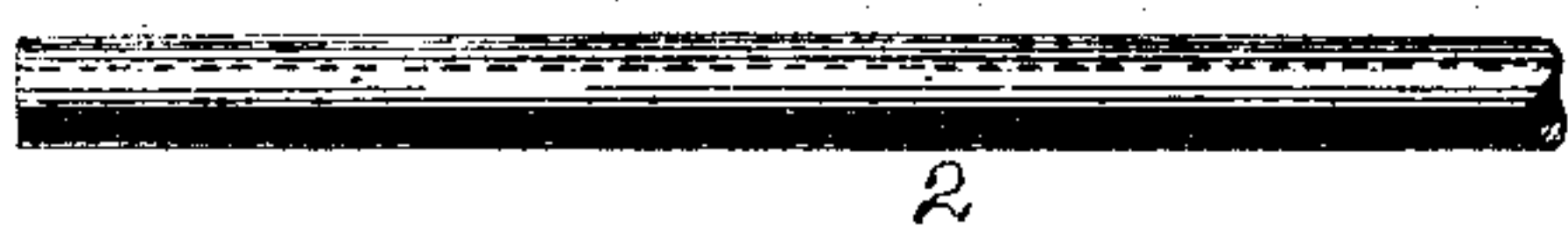


Fig. 4.



Fig. 5.



Fig. 6.

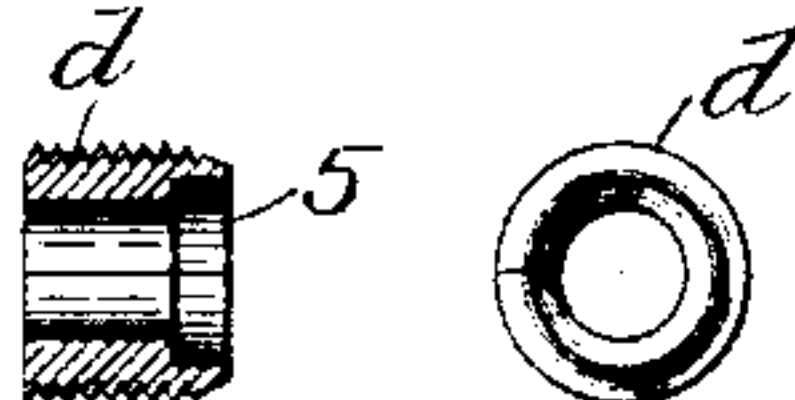


Fig. 7.

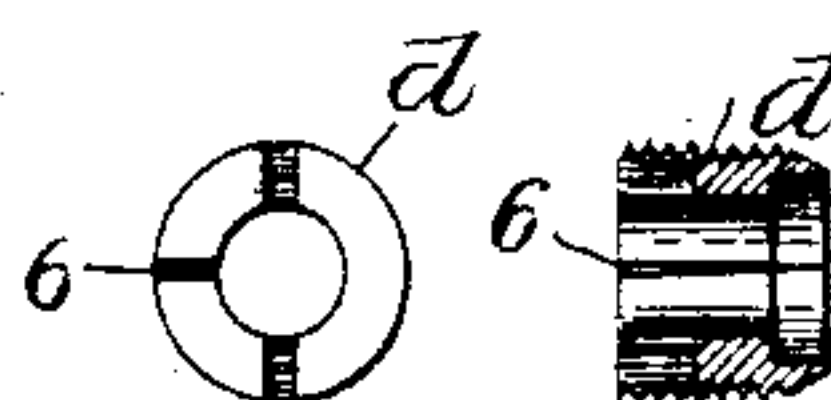


Fig. 10.

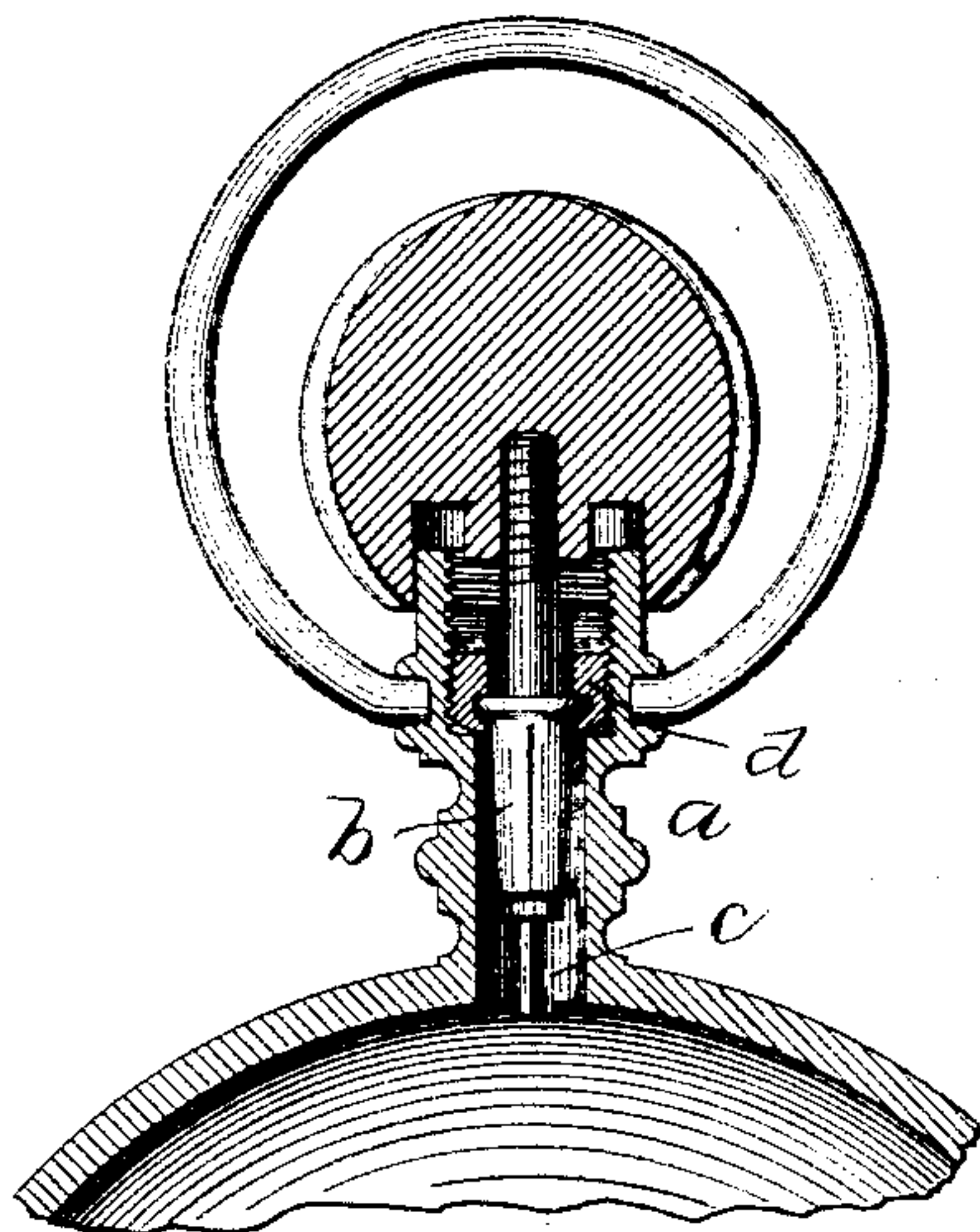
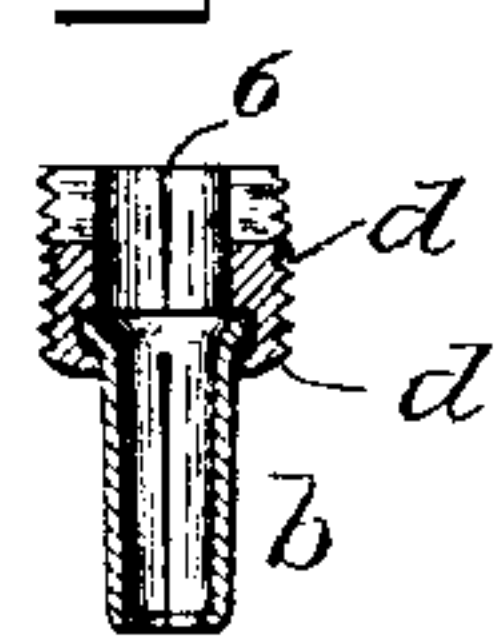


Fig. 8.



Fig. 9.



Witnesses.

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E. C. Fitch  
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# UNITED STATES PATENT OFFICE.

EZRA C. FITCH, OF NEWTON, MASSACHUSETTS.

## WATCHCASE-PENDANT.

SPECIFICATION forming part of Letters Patent No. 539,255, dated May 14, 1895.

Application filed September 19, 1892. Serial No. 446,296. (No model.)

*To all whom it may concern:*

Be it known that I, EZRA C. FITCH, of Newton, in the county of Middlesex and State of Massachusetts, have invented certain new and useful Improvements in Holders for Spring-Sleeves for Watchcase-Pendants, of which the following is a specification.

This invention relates to holders for the spring sleeves which are within the pendants of certain watch-cases, for the purpose of engaging the longitudinally-movable winding bar, and holding it in position for either winding the watch or setting the hands.

The construction of the springsleeve which I prefer to use, described and claimed in my application filed August 19, 1892, Serial No. 443,469, is no part of my present invention, and will not be further described.

Heretofore the holder for the spring sleeve has been made by boring out a solid blank of metal in such a manner as to form a tube. This way of constructing the holder is comparatively slow and expensive.

It is the object of my invention to produce these holders more rapidly and economically than heretofore, and to this end my invention consists of the improvements which I will now describe and claim.

Of the accompanying drawings, forming a part of this specification, Figures 1 to 7, inclusive, show different stages in the operation of making a holder in accordance with my invention. Fig. 8 shows an elevation of the spring-sleeve which is secured to the holder. Fig. 9 shows a central vertical section of the holder and spring-sleeve. Fig. 10 is a central vertical section of the pendant, showing the winding-bar, holder, and split sleeve in position.

In the drawings, in which like letters and numerals of reference indicate like parts in all the figures, *a* represents a watch-case pendant.

*b* represents a spring sleeve of any preferred construction adapted to engage the winding-bar *c* in either its winding or hand-setting position, and *d* is a holder, externally threaded for engaging a corresponding thread within the pendant, and secured to the spring sleeve by upsetting the lower edge of the

holder over a flange at the top of the sleeve, as shown at *d'*, Fig. 9.

There is nothing new in the general form of the holder *d*, or in its connection with the sleeve and pendant, a holder of the same general form having been heretofore made from a solid cylindrical blank by boring it out to give it a tubular form, and cutting the thread upon the exterior.

In carrying out my invention, I construct the holder in the following manner: I take a flat blank 2 of sheet metal, and form it by stages, as indicated in Figs. 2 and 3, into a tube having abutting edges extending along the side. I then cut a thread upon the exterior of the tube and sub-divide it into short lengths 3, each being the proper size for the holder *d*. The piece is then chamfered, as shown at 4, Fig. 5, and turned out at 5, see Fig. 6, to receive the flange on sleeve *b*. The holder is finally joined to the spring sleeve by upsetting its lower edge at *d*. The abutting side edges are spread apart slightly at the top, as shown at 6, Figs. 7 and 9, so that the inherent resiliency of the holder may retain it against displacement by jar within the pendant.

It will be seen that, by the above method, I am enabled to produce holders for the purpose described, more rapidly and economically than heretofore.

I claim—

1. A holder for the spring sleeves of watch-case pendants, the same consisting of a sheet-metal tube-section divided longitudinally at one side with edges abutting throughout a portion of its length, and spread apart throughout the remaining portion of its length, said tube-section having exterior screw-threads.

2. The improved method of making holders for the spring sleeves of watch case pendants, the same consisting in bending a blank of sheet metal into the form of a tube with the edges of the sheet abutting without uniting, exteriorly screw-threading the tube thus formed, and severing the tube into lengths suitable to constitute the holders.

3. The improved method of making holders for the spring sleeves of watch case pendants, the same consisting in bending a blank of sheet metal into the form of a tube with the

edges of the sheet abutting without uniting,  
exteriorly screw-threading the tube thus  
formed, severing the tube into lengths suit-  
able for holders, and slightly separating the  
5 abutting edges for the purpose described.

In testimony whereof I have signed my  
name to this specification, in the presence of

two subscribing witnesses, this 9th day of  
September, A. D. 1892.

EZRA C. FITCH.

Witnesses:

D. W. ELDREDGE,  
E. A. MARSH.