

No. 679,218.

Patented July 23, 1901.

W. A. DAY.  
METAL ARTICLE.

(Application filed Apr. 23, 1900.)

(No Model.)

Fig. 1.

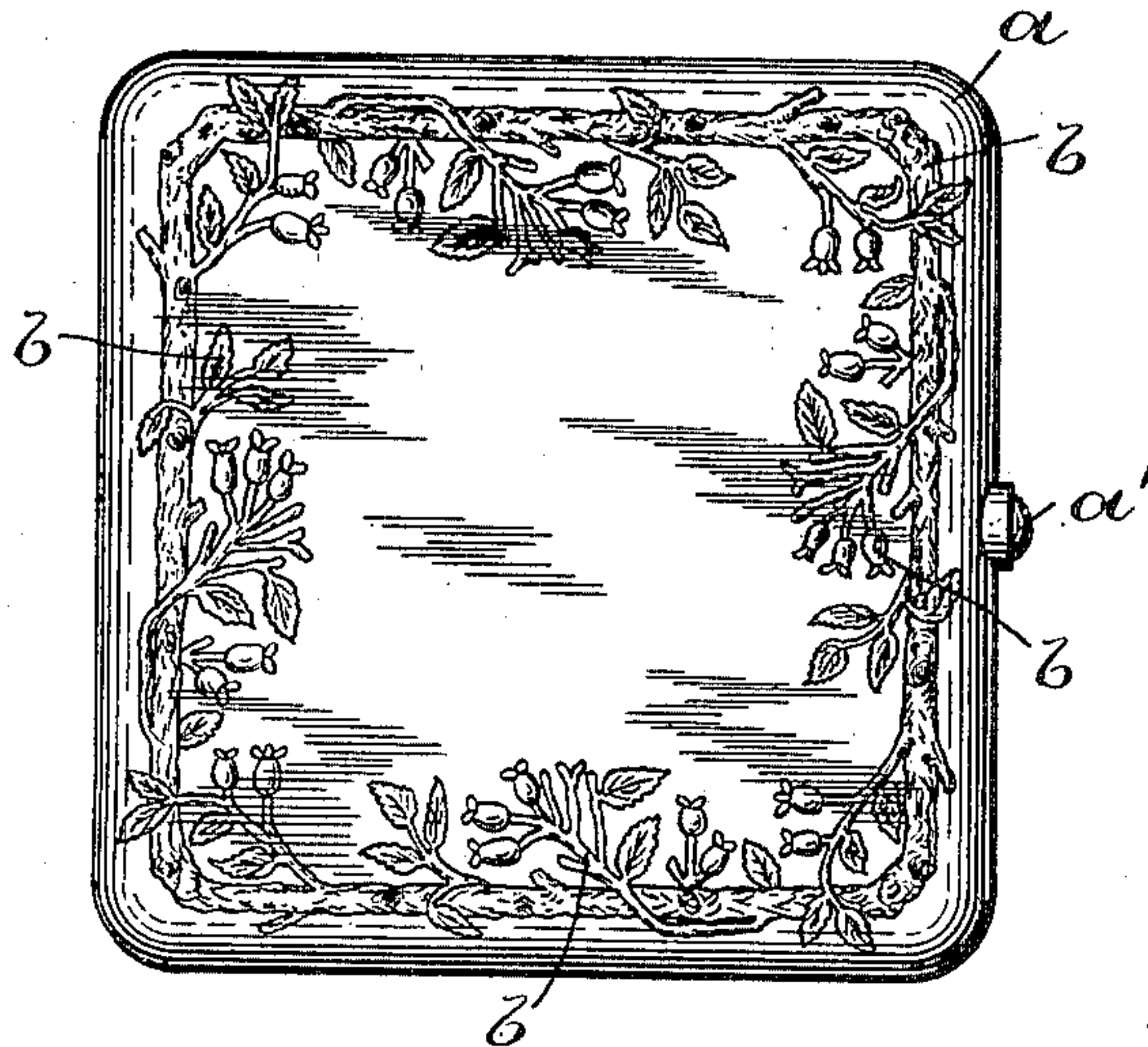


Fig. 2.

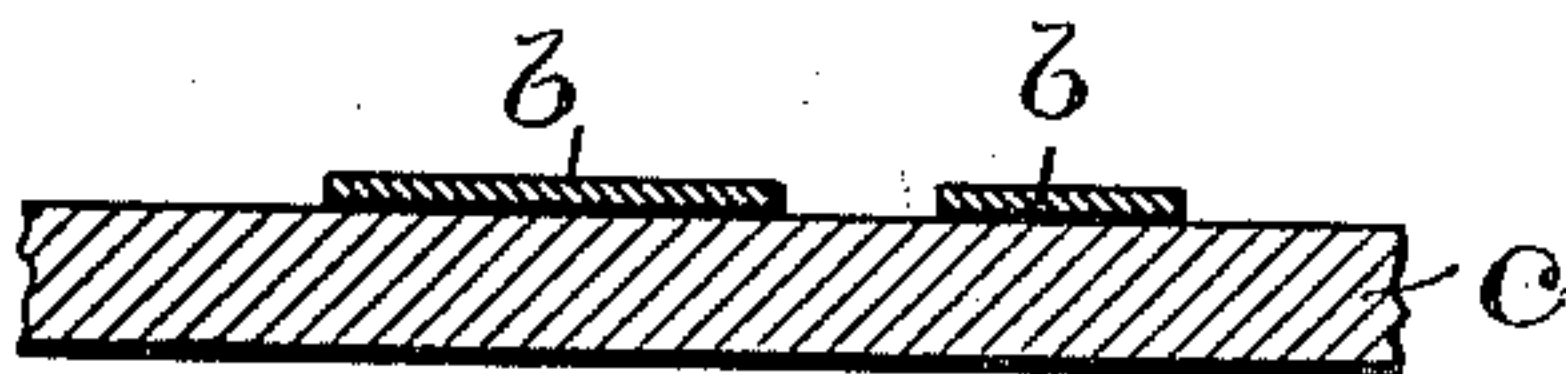


Fig. 3.

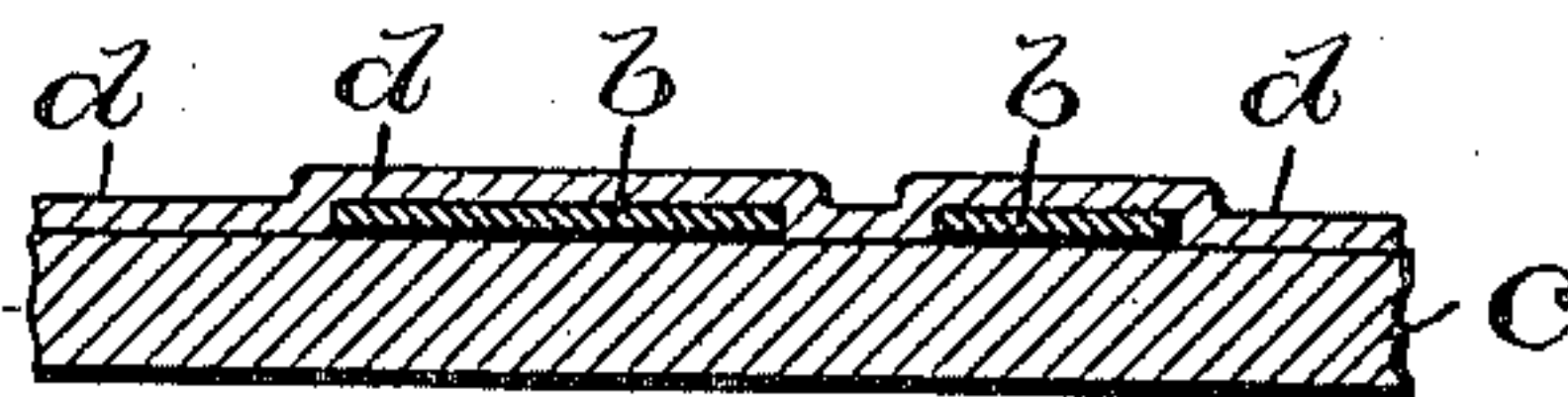


Fig. 4.



WITNESSES:

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# UNITED STATES PATENT OFFICE.

WILLIAM A. DAY, OF PROVIDENCE, RHODE ISLAND, ASSIGNOR TO GORHAM MANUFACTURING COMPANY, OF SAME PLACE.

## METAL ARTICLE.

SPECIFICATION forming part of Letters Patent No. 679,218, dated July 23, 1901.

Application filed April 23, 1900. Serial No. 13,886. (No model.)

*To all whom it may concern:*

Be it known that I, WILLIAM A. DAY, a citizen of the United States, residing at Providence, in the county of Providence and State of Rhode Island, have invented a new and useful Improvement in Metal Articles, of which the following is a specification.

This invention has reference to a metal article ornamented with metal differing in color or texture from the metal of the article.

The object of this invention is to produce an ornamental metal article presenting the appearance of inlaid work at less cost than inlaid work, of greater durability, and more perfect finish.

The invention consists in the peculiar and novel combination of the parts whereby the ornaments are secured to and embedded in the metal of the article, as will be more fully set forth hereinafter.

The invention is especially designed for articles made of silver, gold, and alloys of precious metal, but is applicable to articles made of inferior metals.

In illustrating the invention I have selected a cigarette-case made of silver and ornamented with a border of gold and alloys of gold.

Figure 1 is a side view of a cigarette-case ornamented with what resembles inlaid work. Fig. 2 is a section, on an enlarged scale, of a part of the sheet-metal side of the cigarette-case, having blanks forming part of the ornamentation secured to its outer surface. Fig. 3 is a sectional view of the side shown in Fig. 2, showing the outer surface of the plate and the ornamental blanks covered with metal deposited by electrolysis. Fig. 4 is a sectional view of the part of the sheet metal, showing the ornamental blank embedded in the metal, while exposing the surfaces.

In the drawings, *a* indicates the surface of the cover of a cigarette-case, formed of sheet metal, usually silver; *a'*, the latch by which the cover is secured, and *b b* parts consisting of ornamental stems, branches, leaves, and flowers, or they may be representations of animals, letters, or any other desired ornament or configuration.

In the present instance the ornamental stems, branches, leaves, &c., are cut from sheets of precious metal and alloys of precious metal differing in color from the cover *a*. The parts *b b* are secured to the sheet *c*, which

forms the body of the cover, preferably by solder, and arranged to form the desired ornamentation. The cover is now cleaned and prepared in the usual manner for the electrolytic bath, where the metal *d d* is deposited on the surface of the sheet *c* and on the parts *b b*. When the desired thickness of metal *d* has been deposited, the plate is removed from the bath, and the metal *d* on the surfaces of the parts *b b* is removed, so as to expose the surfaces of the embedded ornamental parts *b b*. These may now be more or less engraved, as is shown in Fig. 1.

As the ornamental parts are firmly secured to the sheet *c* and the metal deposited by electrolysis forms an integral part of the sheet *c*, as well as of the ornamental parts *b b*, articles ornamented in the manner described are more durable and the joints are more perfect than inlaid work produced with the highest skill. The cost of producing ornamented metal articles as herein described, presenting to the ordinary observer the appearance of the costly inlaid work, is very much reduced, while to the artistic or expert observer the work is readily distinguishable by its high artistic merits and the absence of the more or less wide marginal lines between the inlaid parts and the adjacent surfaces.

For articles of precious metal the absence of the solder-joints in the surface adds materially to the beauty of the ornamentation of the article, which joints are unavoidable in inlaid work and when affected by oxidation mar the effect of the inlaid article.

Having thus described my invention, I claim as new and desire to secure by Letters Patent—

As a new article of manufacture, an article of precious metal having ornamental figures of precious sheet metal soldered to the normal surface, and the normal surface raised by the electrode position of precious metal differing in color or quality from the sheet-metal ornamentations, as described.

In testimony whereof I have signed my name to this specification in the presence of two subscribing witnesses.

WM. A. DAY.

Witnesses:

B. M. SIMMS,  
A. E. HAGERTY.