

(No Model.)

J. C. DUEBER.

MANUFACTURE OF WATCH CASES.

No. 260,747.

Patented July 11, 1882.

Fig. 1

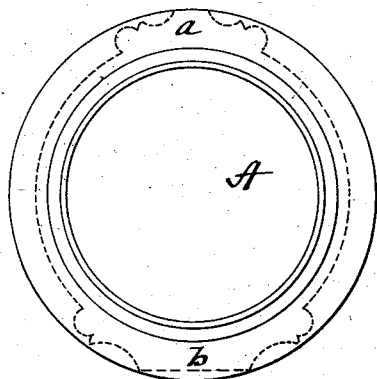


Fig. 2

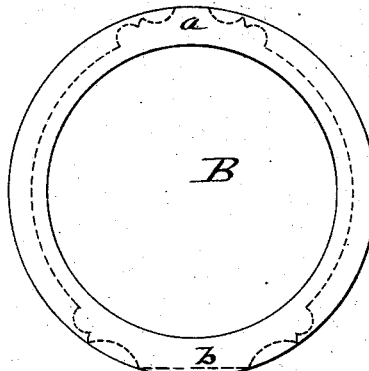


Fig. 3

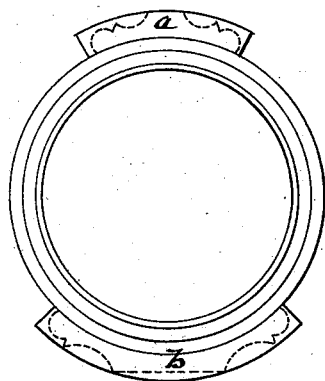
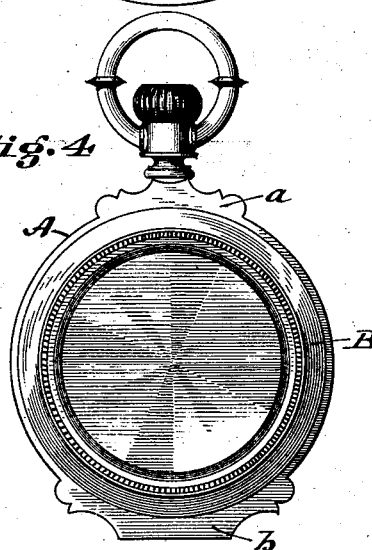


Fig. 4



Attest

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MANUFACTURE OF WATCH-CASES.

SPECIFICATION forming part of Letters Patent No. 260,747, dated July 11, 1882.

Application filed November 25, 1881. (No model.)

To all whom it may concern:

Be it known that I, JOHN C. DUEBER, a citizen of the United States, residing at Newport, Kentucky, have invented new and useful Improvements in the Manufacture of Watch-Cases, of which the following is a specification.

My invention relates to the manufacture of watch-cases, its object being to improve the construction and economize the cost of that style of watch-cases commonly known as "Louis XIV," in which the joint-bearings are arranged upon the outside of the case instead of the inside, as in the ordinary style of watch-cases. In the ordinary construction of such cases the "centers" and "snaps" are first formed, and then segmental blocks for joint-bearings are soldered upon their peripheries in corresponding positions, which are afterward dressed to the required form. This construction, besides being expensive, leaves the soldered joint exposed to view, and is otherwise undesirable.

My improvements consist in the construction of the center and hinge parts in one piece, and similarly the snap-ring and hinge parts in one piece, thus constituting seamless Louis XIV centers and snap-rings.

The process by which this manufacture is carried out is as follows: The center is punched by suitable tools for the purpose from a solid plate of metal of the required thickness, forming a ring or annulus having an exterior diameter sufficient to include the hinge parts. The snap-rings are similarly formed. These parts are then properly dressed in the lathe, and after soldering the backs to the snap-rings the centers and backs are fitted together, thus constituting the case. The case is then subjected to the action of milling-tools and the extra metal cut away upon its outer edge between the hinge-blocks, and the blocks dressed to the desired ornamented shape in the same operation.

My invention is illustrated in the accompa-

nying drawings, in which Figure 1 represents a watch-case center as punched, including the joint-bearings or hinge parts, indicated by dotted lines; Fig. 2, a snap-ring as punched, including the hinge parts, shown by dotted lines; Fig. 3, a center as ordinarily constructed for a Louis XIV style of watch-case, having the hinge-blocks soldered thereon; and Fig. 4, a finished watch-case of the Louis XIV style.

The center A and snap-rings B, being punched to the largest diameter of the hinge parts *a b* and dressed in the lathe and fitted together as a case, are completed by milling away the surplus metal from the periphery of the center and snaps, the other operations to complete watch being as usual. It will be apparent that by suitably-formed dies the rings and snaps with hinge parts thereon could be punched complete, thus avoiding the milling operation; but such process, although within the spirit of my invention, is not desirable, because of the expense of constructing and maintaining the dies thus formed. On this account I deem it more feasible and economical to proceed as first described, since the process is conducted by ordinary tools, easily made, preserved, or replaced.

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

The method of manufacturing the centers and also the snap-rings of Louis XIV watch-cases, which consists in forming said centers, and similarly said snap-rings, to the largest diameter of the hinge parts, and then milling away the surplus metal between the projections, substantially as set forth.

In testimony whereof I have hereunto set my hand in the presence of two subscribing witnesses.

JOHN C. DUEBER.

Witnesses:

L. M. HOSEA,
GEO. B. MUSCHLER.