

(No Model.)

G. H. KNIGHT.  
JEWELER'S STOCK.

No. 346,661.

Patented Aug. 3, 1886.

Fig. 1.

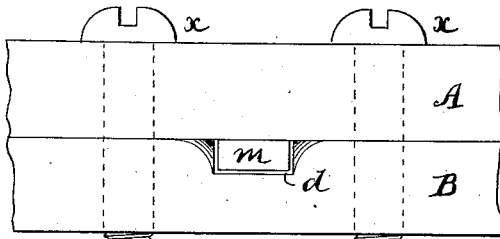


Fig. 2.

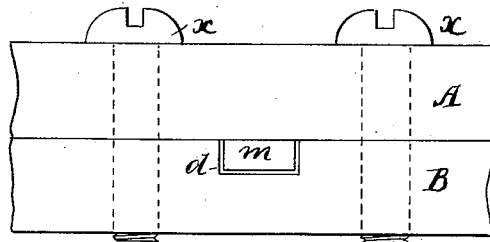


Fig. 3.

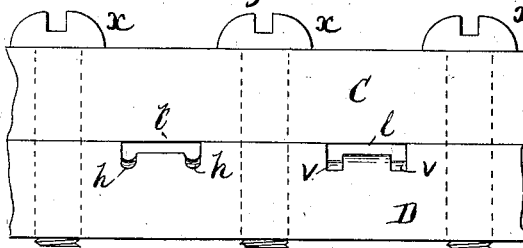


Fig. 4.

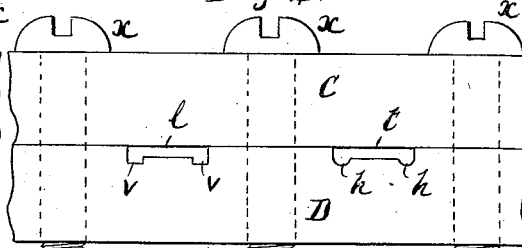


Fig. 5.

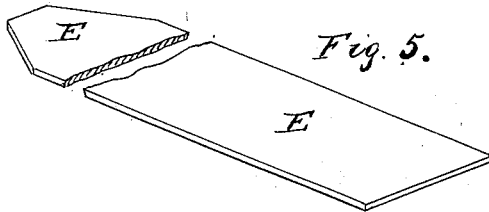


Fig. 6.

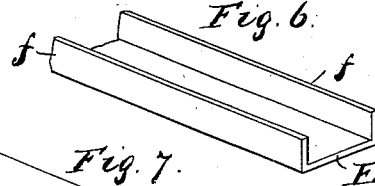


Fig. 7.

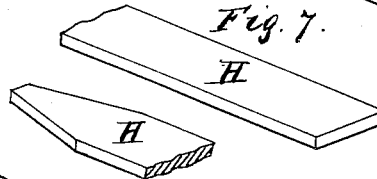


Fig. 8.

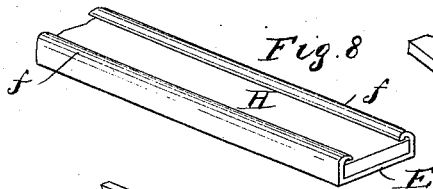


Fig. 9.

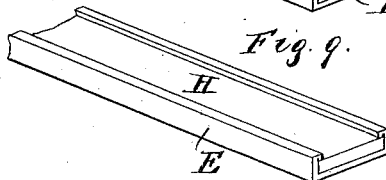


Fig. 10.

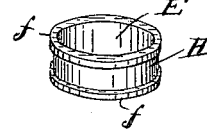
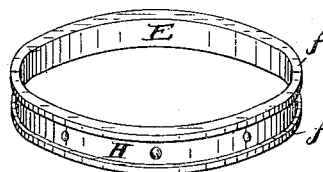


Fig. 11.



Witnesses.

W. Blanka.  
L. J. White

Inventor.

George H. Knight.  
Per C. A. Shaw.  
Attorney.

# UNITED STATES PATENT OFFICE.

GEORGE H. KNIGHT, OF PROVIDENCE, RHODE ISLAND.

## JEWELER'S STOCK.

SPECIFICATION forming part of Letters Patent No. 346,661, dated August 3, 1886.

Application filed April 27, 1885. Serial No. 163,500. (No model.)

*To all whom it may concern:*

Be it known that I, GEORGE H. KNIGHT, of Providence, in the county of Providence, State of Rhode Island, have invented a certain new and useful Improvement in Jeweler's Stock, of which the following is a description sufficiently full, clear, and exact to enable any person skilled in the art or science to which said invention appertains to make and use the same, reference being had to the accompanying drawings, forming part of this specification, in which—

Figures 1 and 3 are front elevations of the dies used in drawing or manufacturing my improved stock; Figs. 2 and 4, respectively, rear elevations of the same, represented as reversed; Fig. 5, a perspective view of the blank from which the covering of the stock is formed; Fig. 6, a like view showing the blank after its edges have been turned by the first die; Fig. 7, a perspective view showing a portion of the body before it is inserted in the covering; Fig. 8, a like view showing the body inserted in the covering, the edges of the covering being represented as having been turned by the second die; Fig. 9, a perspective view showing a piece of the completed stock, the edges of the covering being represented as having been turned by the third or last die; and Figs. 10 and 11, respectively, perspective views of a ring and bracelet made of my improved stock. In Figs. 5, 6, 7, 8, and 9 the parts are represented as enlarged.

Like letters of reference indicate corresponding parts in the different figures of the drawings.

Heretofore in the manufacture of bracelets from plated stock it has been the practice to bend up a thin piece of plated stock at its opposite edges, thus forming a hollow beaded edge, and then to combine therewith another piece of plated stock, the base-metal edges of which were concealed by the hollow beaded edge of the former piece, as shown in the Re-issued Patent No. 4,192, dated December 6, 1870; but such combination of separate pieces of plated stock have necessarily been made in single bracelet lengths, and not in a continuous strip of stock adapted to be cut up into bracelet lengths, or in lengths suitable to

form rings or other articles of jewelry, for the reason that a combined strip so formed having a hollow beaded edge is not adapted for the striking up or bending required to produce such bracelets or rings, so that in practice the plated strips are separately struck up or bent prior to combination with each other. I have, however, discovered that by closing the turned edge completely together upon itself over the base-metal edge of the inclosed body-strip, such combined strips when cut into suitable lengths to form bracelets, rings, &c., can be readily bent to the desired circular or curved form without distorting the turned edge of the strip. I am therefore enabled to manufacture long strips of such stock for sale to manufacturing jewelers, to be cut up and bent into desired forms, and thus produce a new article of trade.

In the drawings, Figs. 1 and 2 represent front and rear views of the first die for drawing the stock to form the turned edge, A being the upper, and B the lower section, of the same, which are attached to each other by means of screws *x*. The upper section is provided with a transversely-arranged rectangular projection, *m*, on its lower side, the lower section being provided with a corresponding socket, *d*, for receiving the same, the socket, being slightly larger than the projection, thus leaving a U-shaped opening between the projection and the bottom and sides of the socket, through which the covering of the stock passes as it is drawn.

The die shown in Fig. 3 is composed of two sections, C D, which are united by screws *x* in substantially the same manner as shown in Fig. 1; but the lower section, D, is provided with two transverse openings, *tl*, extending across its upper side, the opening *l* having a square right-angled groove, *v*, extending longitudinally its entire length at either side, and the opening *t*, a corresponding rounded groove, *h*, at either side, said grooves being deeper or extending, respectively, below the bottoms of the openings *tl*. The openings *tl* *d* are respectively flared or enlarged at the front of the die to form mouths for receiving the stock, as shown in Figs. 1 and 3. The covering E is composed of a strip of sheet metal,

plated on its under or exposed side, and the body H of a thin bar of metal, correspondingly plated on its upper or exposed side, and in making the stock the covering-strip E is drawn through the first die, or die shown in Fig. 1, thereby turning up a flange at either edge, as shown at *ff* in Fig. 6. The bar H, of which the body is composed, is then placed on the covering-strip E, between the upturned flanges *ff*, after which both of these parts are drawn through the second die, or die having the rounded grooves *h*, as shown in Fig. 3, thereby curving the edges *f* inwardly onto the body H, as shown in Fig. 8. The stock is next drawn through the third die, or die having the angular grooves *v*, by which the curved flanges *f* are folded closely in rectangular form and firmly set down onto the body H, the unplated thin edges, or edges proper of the covering, resting on the top of the body H, and being concealed, as shown in Fig. 9. It will be readily seen that the stock so formed will have a practically solid edge, the turned edge being closed against its own base-metal side without intervening vacant space, as shown in Fig. 9. The combined strip of stock will therefore admit of being bent or formed in dies like an integrally-formed piece of stock, so that bracelets, rings, and other articles of

jewelry can be readily struck up and formed therefrom.

I do not claim the combination of the body-plate with the covering-plate when the covering-plate forms a hollow beaded edge, as shown in the Reissued Patent No. 4,192, dated December 6, 1870; neither do I claim the combination of the covering-plate with turned edges inclosing a wire, as shown in Patent No. 264,541, dated September 19, 1882.

I do not confine myself to drawing the stock through dies as described, as the same may be rolled, if preferred.

Having thus explained my invention, what I claim is—

The improved jeweler's stock herein described, consisting of the covering *f*, plated on its under or exposed side, and the body H, plated on its upper or exposed side, said parts being united by the flanges *f*, turned onto the body in such a manner as to conceal the edges of the body and the edges proper of the covering, and to form a practically solid angular edge along the covering above the body, substantially as described.

GEORGE H. KNIGHT.

Witnesses:

JOHN F. COSGROVE,  
THOMAS S. LEE.