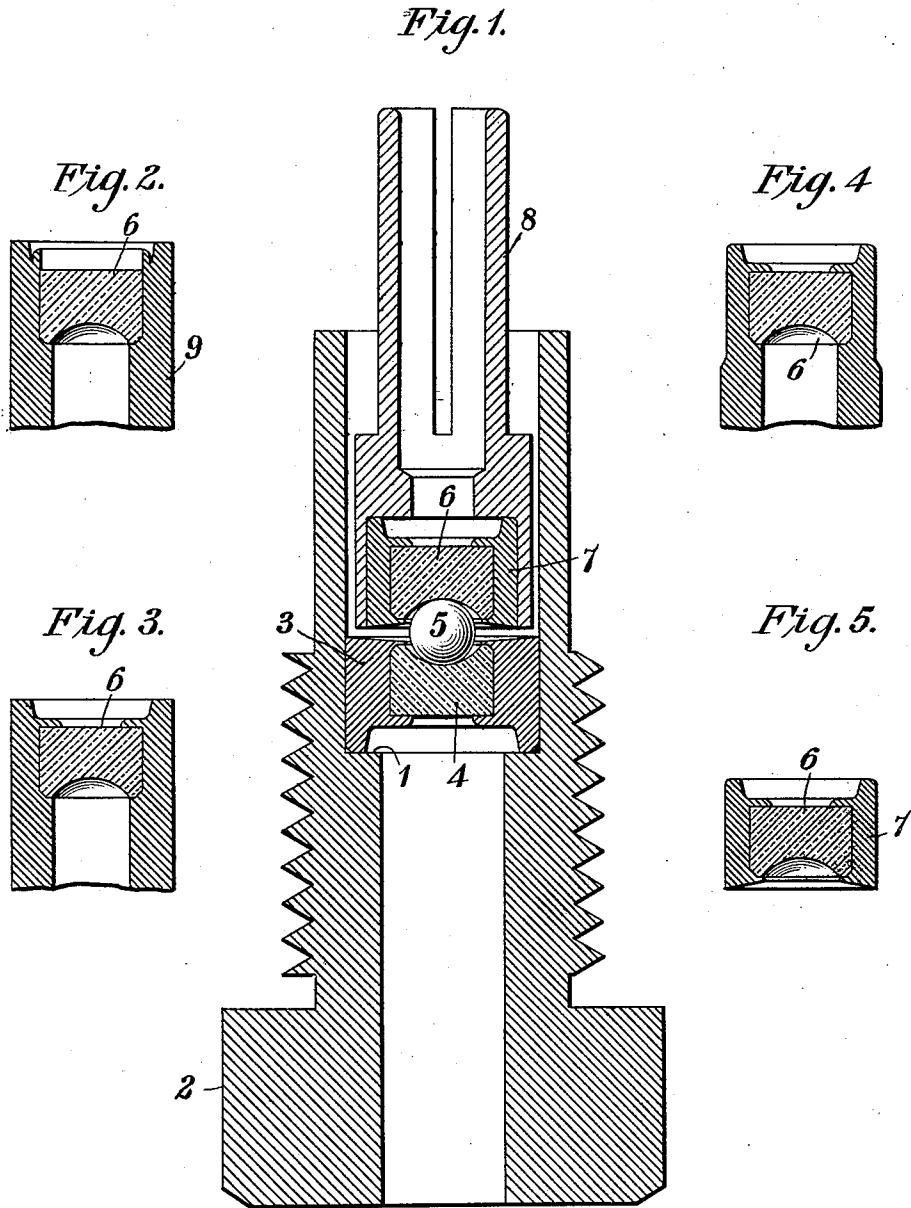


H. MILLER.
METHOD OF MOUNTING BEARING JEWELS.
APPLICATION FILED MAR. 9, 1908.

1,007,372.

Patented Oct. 31, 1911.



WITNESSES:
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METHOD OF MOUNTING BEARING-JEWELS.

1,007,372.

Specification of Letters Patent.

Patented Oct. 31, 1911.

Application filed March 9, 1908. Serial No. 420,080.

To all whom it may concern:

Be it known that I, HENRY MILLER, a citizen of the United States, and a resident of East Orange, in the county of Essex and State of New Jersey, have invented a new and useful Improvement in Methods of Mounting Bearing-Jewels, of which the following is a specification.

My invention relates to mountings for concave bearing jewels and it has for its object to provide a method of readily and economically mounting such jewels without danger of injury thereto.

In the mounting of bearing jewels, it has heretofore been customary to insert the finished jewels into recesses in the mountings with their concave or bearing ends exposed at the tops of the recesses, and to then spin or turn over portions of the mountings upon the top edges of the jewels. However, when such jewels are provided with concave bearing seats the upper ends thereof are rendered fragile, and it is consequently difficult to spin over the edges of the mountings without cracking or otherwise injuring the jewels. In the present instance, the spinning over of the mounting is effected at the back of the jewel, with the result that there is comparatively little danger of injuring the same.

Figure 1 of the accompanying drawing is a vertical sectional view through a bearing having jewels mounted in accordance with my invention, and Figs. 2 to 5, inclusive, are sectional views through a jewel and its mountings and illustrate successive steps in the method of its manufacture.

Seated upon a shoulder 1 within a sleeve 2 that is provided with screw-threads upon its exterior and with a head at its lower end to permit of its being screwed into a suitable supporting member (not shown), is another sleeve or collar 3 constituting a mounting for a jewel 4 having a concave upper bearing surface. A polished steel bearing ball 5 is interposed between the jewel 4 and another similar but inverted jewel 6 that is mounted in a sleeve or collar 7 similar to the sleeve or collar 3, the sleeve 7 being seated against a shoulder within a split

sleeve 8 that is adapted to be applied to the end of a shaft (not shown). The sleeves or mountings 3 and 7 are tightly fitted into the sleeves 2 and 8, respectively, and, in order to effect their removal, it is necessary to insert tools into the smaller ends of the said sleeves and to apply pressure thereto.

In the construction of the jewel mounting, a tube 9 having an internal shoulder is first provided, and the jewel is inserted into the end of the tube having the larger internal diameter with its concave or bearing end resting against the said shoulder, the end of the tube having been previously prepared for spinning over, as indicated in Fig. 2. The inner edge of the tube 9 is next spun over the flat end of the jewel, as shown in Fig. 3, and the exterior of the tube is then turned to the finished external diameter, as shown in Fig. 4. The tube is finally cut off, close to the shoulder upon its interior and in such manner as to form a concavity whereby it is insured that the ball 5 will remain in the concavities in the jewels.

I claim as my invention:

1. The method of mounting a bearing jewel which consists in providing a tube having an internal shoulder, inserting a jewel into said tube with its bearing end against the shoulder, securing the jewel in position, and cutting off the tube close to the said shoulder.

2. The method of mounting a bearing jewel which consists in providing a tube having an internal shoulder, inserting a jewel into said tube with its bearing end against the shoulder, spinning a portion of the tube over the other end of the jewel, and cutting off the tube close to the said shoulder.

In testimony whereof, I have hereunto subscribed my name this twenty-seventh day of February, 1908.

HENRY MILLER.

Witnesses:

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