F. W. NITTEL.

METHOD OF MAKING WATCH CHAIN SWIVELS.

APPLICATION FILED MAY 5, 1921.

1,425,128. Patented Aug. 8, 1922.

Fig. 1.

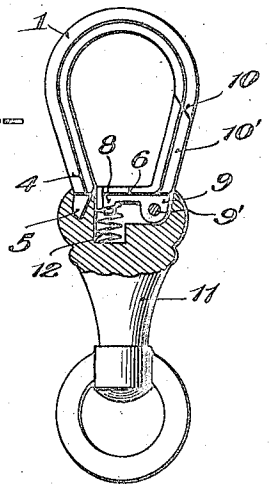


Fig. 2.

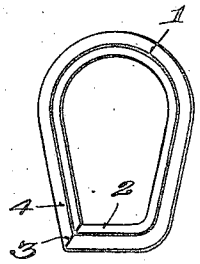


Fig. 3.

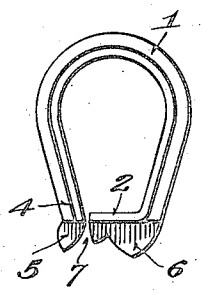


Fig. 4.

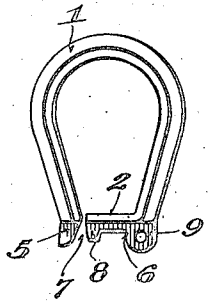


Fig. 5.

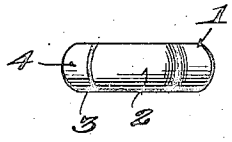


Fig. 6.

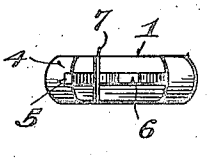
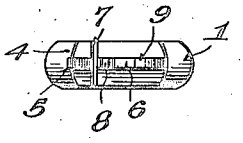


Fig. 7.



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METHOD OF MAKING WATCH-CHAIN SWIVELS.

1,425,128. Specification of Letters Patent. Patented Aug. 8, 1922.

Application filed May 5, 1921. Serial No. 467,117.

To all whom it may concern:

Be it known that I, FREDERICK W. NITTEL, a citizen of the United States, residing at Attleboro, in the county of Bristol and State of Massachusetts, have invented new and useful Improvements in Methods of Making Watch-Chain Swivels, of which the following is a specification.

This invention relates to certain new and useful improvements in method of making watch chain swivels, and the primary object thereof is to provide an improved method of making the bow parts of the swivels.

The invention briefly proposes to form the entire bow part including its movable tongue in an integral structure, shaping the latter to form an anchorage for the rigid part of the bow and a pivotal ear and a spring engaging part, and in then severing the bow to form the spring tongue, or to separate the tongue from the rigid part of the bow, preceding which the parts are secured in their operative relation to the swivel proper.

Further and other objects will be later set forth and manifested in the course of the following description.

In the drawings:

Figure 1 is a side elevation partly broken away and in sections showing a completed swivel;

Figure 2 is a plan view of the blank showing the bow in the first stage of the operation;

Figure 3 is a view similar to Figure 2 showing the bow in the second stage of the operation;

Figure 4 is a similar view of the bow in its final stage of the operation; and

Figures 5, 6, and 7 are bottom plan views of Figures 2, 3, and 4 respectively.

In proceeding in accordance with the present invention a bow 1 is employed having one of its ends 2 forming the bottom of the bow and having a mitered joint 3 with the adjacent end of the bow, as depicted in Figure 2 of the drawing. The bottom or lower end part of the bow is now subjected to a swaging operation which provides the end 4 thereof with a reduced depending ear or web 5 and the bottom of the end 2 with an elongated depending reduced web 6, the parts 5 and 6 each being disposed at the center of the thickness of the material of which the bow is formed, the bow in this operation having its mitered joint 3 separated as indicated at 7. The parts are then subjected to a further swaging operation which shapes same into the finished form shown in Figure 4 of the drawing, in which form a spring receiving teat 8 is shaped out of the web 6 and the latter finished to have a perforated ear 9. The parts are then secured to the head 11 of a swivel, the anchoring ear 5 being secured to the head 11 by soldering or welding or otherwise, and a pin 9′ being passed through the perforation of ear 9, previous to which the spring 12 is engaged over the teat 8. The bow is then cut or severed on the line 10, which provides the movable tongue 10′.

From the foregoing it will be seen that accurate alinement of the rigid part of the bow with relation to its tongue is thus assured, and all possibility of these parts being secured in place out of alinement is obviated.

The invention therefore involves the securment of the entire bow in place together with the pivotal pin and spring of its to be movable tongue, followed by severing of the bow to form such tongue.

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

1. The method of making watch chain swivels which consists in first forming a bow with a bottom end extending thereacross, then in swaging the said bottom end to form a pair of spaced depending attenuated webs, then in shaping said webs to form an anchoring ear, a spring engaging teat and a pivot ear the latter perforated, then in attaching the bow to the swivel head with the teat engaged with the spring, the pivot ear with the pivot pin of the swivel and the anchoring ear rigidly at-

tached to the head, and finally in severing the bow to form a tongue movable about the pivot pin and tensioned by said spring.

2. The method of making watch chain swivels which consisits in first forming a bow, then in forming attaching means, and pivot means on the bow, then in attaching said bow to a swivel with the attaching means thereof rigidly secured to the swivel and with a pivot means connecting to the pivot means of the bow, and finally in severing the bow to form a movable tongue which pivots about said pivot means of the swivel.

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

FREDERICK W. NITTEL.

Witnesses:
MARION A. KINGSLEY,
J. A. MILLER.