

(No Model.)

J. BONNER.
MANUFACTURE OF RINGS.

No. 499,091.

Patented June 6, 1893.

Fig. 1.

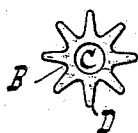


Fig. 2.



Fig. 3.



Fig. 4.



Fig. 5.

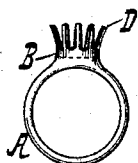
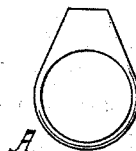


Fig. 6.



WITNESSES:

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UNITED STATES PATENT OFFICE.

JULIUS BONNER, OF NEWARK, NEW JERSEY.

MANUFACTURE OF RINGS.

SPECIFICATION forming part of Letters Patent No. 499,091, dated June 6, 1893.

Application filed December 22, 1892. Serial No. 456,062. (No model.)

To all whom it may concern:

Be it known that I, JULIUS BONNER, a citizen of the United States, residing at Newark, in the county of Essex and State of New Jersey, have invented new and useful Improvements in the Manufacture of Rings, of which the following is a specification.

This invention relates to finger-rings having settings for jewels, and has for its objects to simplify their construction and render the manufacture more economical; to obtain the advantages of a permanently fixed setting without the manipulations, filing, sawing and expense necessary where the ring-shank and setting are made in a single piece, or integral with each other; to avoid constructing the ring-shank in two sections as well as the skill required, in the prior method of manufacture where the setting is a separate piece secured in a fixed position by solder; and to enable rings of the Tiffany type to be rapidly manufactured at reduced expense and by less skilled workmanship. To accomplish all these objects my invention involves the method hereinafter described and claimed, reference being made to the accompanying drawings, in which—

Figure 1 is a detail plan view of the setting prior to bending the clamps into position to receive the jewel. Fig. 2 is a detail sectional view of the setting, showing the clamps bent to receive the jewel. Fig. 3 is a sectional side elevation of the completed ring-shank. Fig. 4 is a top plan view of the ring-shank. Fig. 5 is a side elevation showing the ring-shank and setting united, and Fig. 6 is a side elevation of a ring-blank to illustrate the old method of making a finger-ring where the shank and setting are in one piece.

In the ordinary manufacture of finger-rings with settings, the shank A is cast with an enlarged or thickened portion at its upper side, as in Fig. 6, which is drilled or bored to form the usual hole for the passage of light to the under side of the jewel, and then it is sawed, filed and bent to form the clamps or fingers for holding the jewel. This method of manufacture is slow and expensive and requires skilled workmanship and considerable manipulation and handling.

In carrying out my invention, I form the ring-shank of substantially circular shape in a single piece and provide a plain seat E at the upper side thereof, which seat surrounds the hole in the shank, as in Fig. 3. The setting is a separate piece which can be readily struck or stamped up from a piece of flat metal in the form shown by Fig. 1, the clamps or fingers D, are bent up as in Fig. 2, to the position required to receive the jewel, and the base of the setting is plain, as at F, to accurately fit upon or to the plain seat E of the completed ring-shank A, Figs. 3 and 4. The plain based setting is permanently fixed to the plain seated shank through the medium of solder, making, substantially, a single structure and attaining the advantages of a shank and setting actually made integral, without, however, the objections thereto which reside in the manipulations, handling, sawing, and filing before alluded to.

The construction of the completed ring-shank with its plain seat, and the setting with its plain base, render it possible to join them together through the medium of a joint which is imperceptible and by the means described a very desirable and useful article is produced, while the expense of manufacture is reduced and ring-shanks with permanently fixed settings can be more rapidly produced than heretofore.

Having thus described my invention, what I claim is—

The method herein described of manufacturing finger-rings, which consists in forming a completed ring-shank in a single piece with a hole and a plain seat, and separately forming a setting with bent-up clamps and a plain base, and permanently attaching the parts by soldering the plain base of the setting to the plain seat of the completed ring-shank, substantially as set forth.

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

JULIUS BONNER.

Witnesses:

WM. C. HAUFF,
E. F. KASTENHUBER.