May 10, 1927. 1,627,765

G. T. BATES

WATCHCASE AND PROCESS OF MAKING SAME

Filed Oct. 8, 1926

Fig. 1.

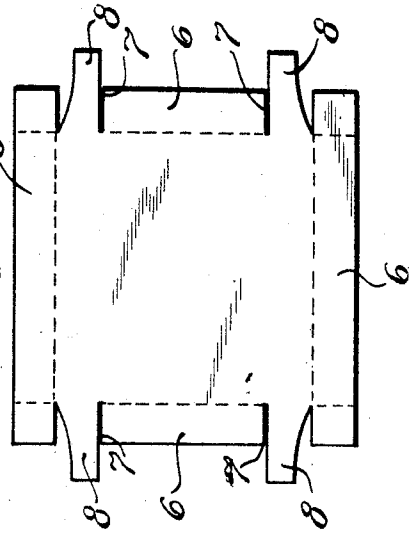


Fig. 3.

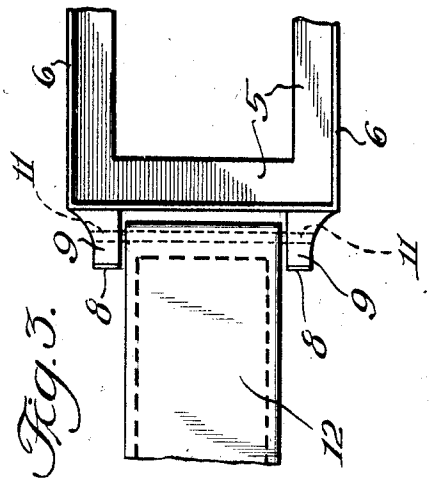


Fig. 2.

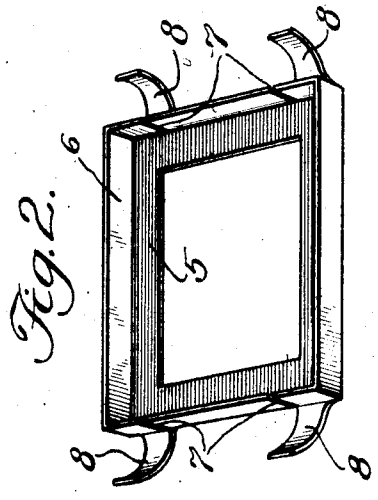
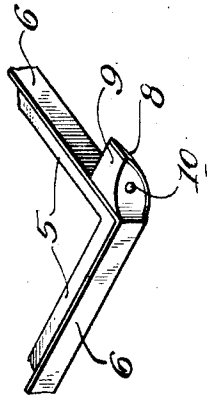


Fig. 4.



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UNITED STATES PATENT OFFICE.

GEORGE T. BATES, OF ELGIN, ILLINOIS, ASSIGNOR TO ILLINOIS WATCH CASE COMPANY, OF ELGIN, ILLINOIS, A CORPORATION OF ILLINOIS.

WATCHCASE AND PROCESS OF MAKING SAME.

Application filed October 8, 1926. Serial No. 140,349.

This invention relates to the manufacture of a watch case of the bracelet type adapted to be secured in place by flexible means extending around the wrist. A pin or bar which is extended between a pair of lugs on each end of the case is commonly used for the attachment thereto of such flexible means—usually a strap or bracelet. Considerable trouble has been experienced in providing lugs for this purpose, due to difficulties in handling and holding the lugs in place prior to and during a soldering operation which must be performed. It is an object of this invention to simplify the manufacture of this type of case by certain improvements directed to the lugs, to the means by which they are held in place, and to the method by which the operation of securing the lugs is carried out.

An illustrative embodiment of my invention is set forth in the accompanying drawing in the manner following:

Figure 1 is a plan view of a blank from which may be formed a bezel or back having the characteristics hereinafter disclosed;

Fig. 2 is a perspective view of a bezel formed from a blank such as is shown in Fig. 1:

Fig. 3 which is a fragmentary view in elevation of the bezel with lugs applied thereto shows one end of a wrist strap having connection with a pin which is extended between one pair of lugs, and

Fig. 4 is a fragmentary detail in perspective showing one of the lugs secured to the case.

I would have it understood that the improvements herein set forth are applicable to a watch case of the bracelet type having lugs carried by the case center or movement ring, by the bezel, or by the case back. For purposes of convenience, the drawing, as well as the description to follow, is concerned with my improved lug construction in relation to a bezel. The same construction might be used with equal advantage where the lugs are fastened to the case center or to the back which is associated therewith.

The bezel 5 which is shown in Fig. 2 may be of any desired contour. It is provided with marginal flanges 6 wherein are formed a pair of slits 7 at each end of the bezel. Between these slits and the proximate corners is a short section of the flange with which is associated a clip 8 joined to the bezel and extending outwardly therefrom in curved formation. The extremity of each clip may lie in approximately the same plane as the flange edges.

A bezel of this general description may be conveniently formed from a blank such as is shown in Fig. 1. The parts appearing in the blank which correspond to the bezel shown in Fig. 2 bear similar reference numerals, the lines of bend being indicated by dotted lines. A sheet metal blank of this character may be produced conveniently by a single die operation, and by a second die operation may be drawn to the form of Fig. 2.

Having progressed to this point, lugs 9 are then placed in the clips 8 which provide seats therefor. As shown best in Fig. 4, each lug may be of such form as to fit within the space between the clip and the marginal flange 6. When so positioned, the lug is secured permanently to the bezel as by a soldering operation. It is of great advantage to provide a seat of the kind set forth so that the lug may be located accurately and held fixedly for the soldering operation. Each lug may also be provided with a transverse hole 10 to receive one end of a pin 11 to which is secured a strap or bracelet 12 in the customary manner.

I would have it noted that the present lug construction and the method of its attachment to the bezel is applicable to cases varying widely in design. The embodiment of the invention herein shown and described is illustrative only. The lugs may also be of any desired form, an irregular shape being suggested in the drawing. Regardless of their shape, the lugs may be handled and located with precision much more easily on account of the seats which are provided for their reception at the time the soldering operation is performed. The clips which form the lug seats may, of course, be variously formed according to the design or shape of the lugs which are desired, it being merely necessary that the seats bear a proper relation to the lugs to ensure retention of the latter.

By proceeding with the manufacture of a case according to the improvements herein outlined, it is possible to eliminate several costly operations, particularly such as are necessary with gold-filled lugs. This is possible because I overcome much of the

difficulty in spreading the gold evenly on both sides and top of the lugs. When secured in place as described, the solder will fill the slits 7 which, as shown, lie immediately adjacent one corner of the lugs. In this manner, the presence of the slits is completely concealed.

I claim:

1. As a new article of manufacture, a sheet metal watch case having integral clips extended outwardly from its ends, each cooperating with the case to provide a seat, and lugs fitted within each seat and secured both to the case and to the associated clip, substantially as described.

2. As a new article of manufacture, a sheet metal watch case against the opposite ends of which are placed lugs independently formed, means for centering each lug in a predetermined position against the case end, said means comprising a clip integral with the case and extended therefrom in a manner to form, with the case, a seat wherein the lug may be fixedly held, and a solder connection between the lug and its seat, substantially as described.

3. A watch case having one component formed with marginal flanges and with integral clips extended outwardly beyond the flanges at opposite ends of the case to cooperate therewith in providing seats, and a lug fitted within each seat and soldered thereto, substantially as described.

4. The process of forming a bracelet watch case which consists in drawing the side edges of a sheet metal blank to provide marginal flanges and also clips outwardly of the flanges at opposite ends of the case, in positioning between each clip and the proximate flange a lug which is shaped to fit within the seat so provided, and finally in soldering the lug so positioned both to the clip and to the case, substantially as described.

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