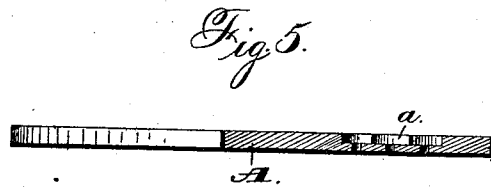
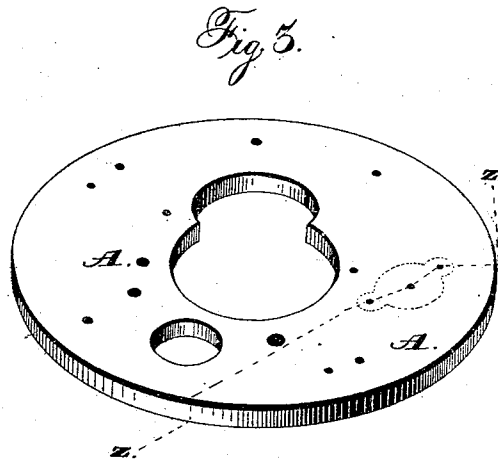
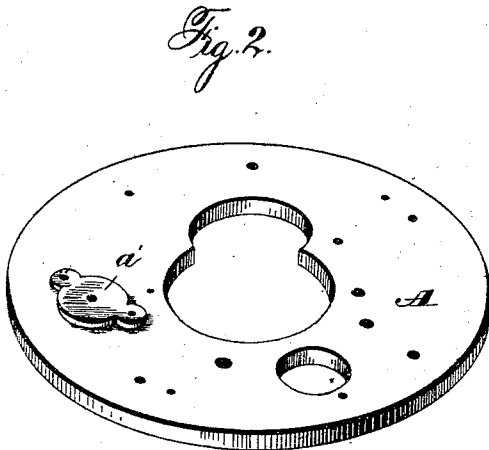
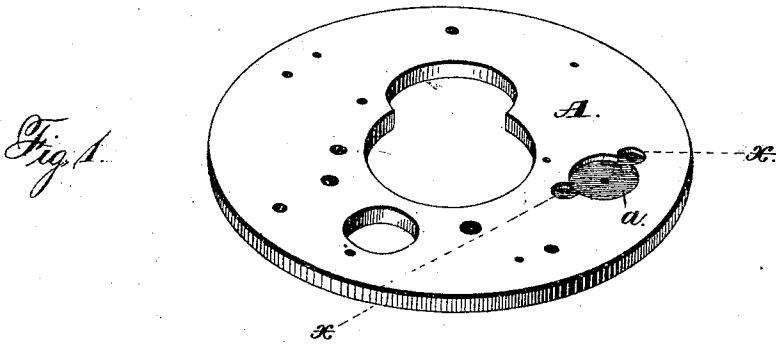


(No Model.)

G. E. HART.  
WATCH PLATE.

No. 321,896.

Patented July 7, 1885.



Witnesses:  
Jas. E. Hutchinson.  
Henry L. Hazards

Inventor:  
Geo. E. Hart, by  
Prindle & Russell, his Attys

# UNITED STATES PATENT OFFICE.

GEORGE E. HART, OF WATERBURY, CONNECTICUT, ASSIGNOR TO THE  
WATERBURY WATCH COMPANY, OF SAME PLACE.

## WATCH-PLATE.

SPECIFICATION forming part of Letters Patent No. 321,896, dated July 7, 1885.

Application filed June 2, 1884. (No model.)

*To all whom it may concern:*

Be it known that I, GEO. E. HART, of Waterbury, in the county of New Haven, and in the State of Connecticut, have invented certain new and useful Improvements in the Manufacture of Watch-Plates; and I do hereby declare that the following is a full, clear, and exact description thereof, reference being had to the accompanying drawings, in which —

Figure 1 is a perspective view from the outer side of a watch-plate after leaving the dies. Fig. 2 is a like view of the same from the inner side. Fig. 3 is a perspective view of the inner face of the said plate after having been dressed off; and Figs. 4 and 5 are respectively sections upon lines *xx* and *zz* of Figs. 1 and 3.

Letters of like name and kind refer to like parts in each of the figures.

The design of my invention is to lessen the expense involved in the construction of watch-plates, to which end said invention consists, as an improvement in the construction of watch-plates, in the method of forming recesses by first stamping or pressing the required depression into one face of a plate, and then removing the corresponding protuberant metal from the opposite side of the same, substantially as and for the purpose hereinafter specified.

In the construction of watch-plates certain portions of the operative parts require the formation of recesses within the surface of the plate, which recesses have heretofore been formed by means of milling-tools, lathe-tools, &c., and when of irregular shape each portion of a recess has required a separate operation.

In constructing watch plates by my method

a blank plate, A, is placed between suitable dies and the desired recess, *a*, pressed into one face to the required depth. The metal displaced by the die forms a corresponding protuberance, *a'*, upon the opposite face of said plate, which protuberance is afterward dressed off so as to restore said face to its former plane form.

In forming a recess by this method no greater expense other than in the construction of the dies, is involved in the production of the most irregular form of recess over the most simple form of the same, and several recesses may be thus formed at one operation as readily as one recess.

In addition to the advantages named my method enables recesses to be formed which could not otherwise be produced except by hand-work, and each recess thus formed within one plate is an exact duplicate of the like recess within every other plate that is operated upon by the same dies.

Having thus fully set forth the nature and merits of my invention, what I claim as new is—

As an improvement in the construction of watch-plates, the method of forming recesses by first stamping or pressing the required depression into one face of a plate, and then removing the corresponding protuberant metal from the opposite side of the same, substantially as and for the purpose specified.

In testimony that I claim the foregoing I have hereunto set my hand this 15th day of March, 1884.

GEORGE E. HART.

Witnesses.

GEO. S. PRINDLE,  
E. L. BRONSON.