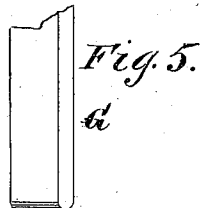
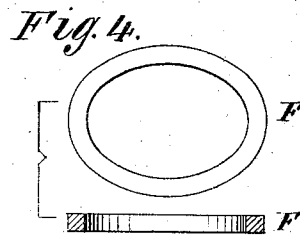
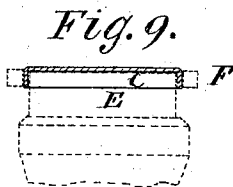
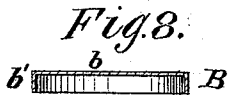
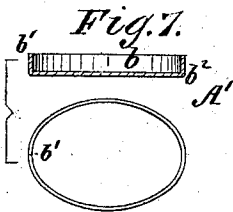
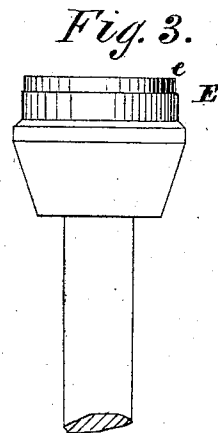
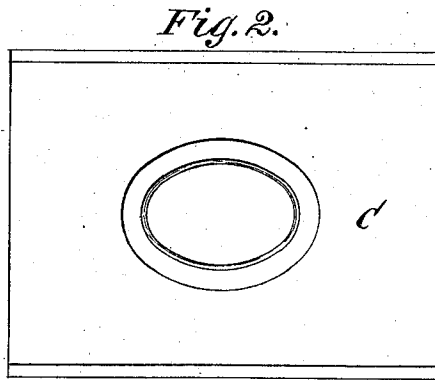
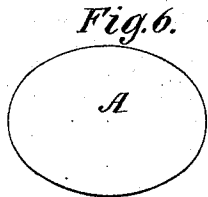
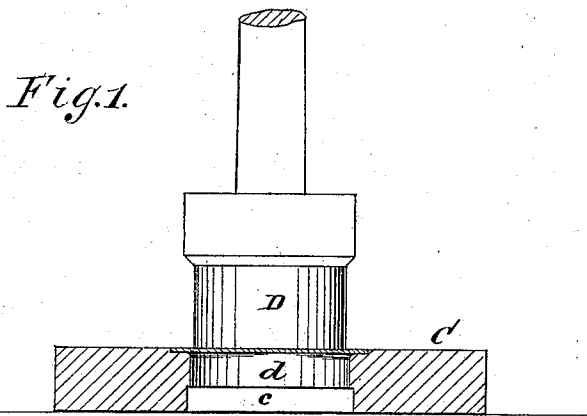


S. COTTLE.

Manufacture of Jewelry.

No. 133,762.

Patented Dec. 10, 1872.



Witnesses:  
*G. Mattys.*  
*John C. Kemon*

Inventor:  
*Shubal Cottle*

PER *[Signature]*  
 Attorneys.

# UNITED STATES PATENT OFFICE.

SHUBAEL COTTLE, OF NEW YORK, N. Y.

## IMPROVEMENT IN THE MANUFACTURE OF JEWELRY.

Specification forming part of Letters Patent No. 133,762, dated December 10, 1872.

### CASE A.

*To all whom it may concern:*

Be it known that I, SHUBAEL COTTLE, of the city, county, and State of New York, have invented means of making certain forms of jewelry bases for buttons, studs, and settings for pins and ear-rings, of which the following is a specification:

The object of this invention is to make, out of a single piece of gold, the bases for buttons, studs, and settings. The form is sometimes round, sometimes oval, but generally adapted to suit the particular fashion of the times, with the barrel always at a sharp angle to the bottom. They are ordinarily made in two pieces, which are soldered together. This soldering can only be hidden from view by a few of the most skilled and accomplished workmen, and is often sought to be concealed by ornamental facings. It becomes, therefore, a matter of importance to make these bases altogether without solder and from a single piece of metal.

Figure 1 is a sectional elevation of male and female dies; Fig. 2, a plan view of die-plate; Fig. 3, side view of lathe-mandrel with die on end; Fig. 4, a plan and section of ring; Fig. 5, a view of burnisher; Fig. 6, a plan view of blank; Fig. 7, a view of blank after the first operation; Fig. 8, a longitudinal section of completed article; Fig. 9, a sectional view of completed article on the mandrel-die and within the ring.

In the drawing, A represents a blank, of suitable form; A', the blank after the first operation; and B, the finished article or product.

C is a die-plate having the female die *c*, and D a plunger having the male die *d* on the end. E is a lathe-mandrel having the annular head *e*, and F a ring which is used in connection with said mandrel. G is a burnishing-tool.

The blank A is placed over and carried down by the male die *d* into the female die *c*. The effect of this operation is to form a blank with bottom *b* and upright barrel *b*<sup>1</sup>, but rounded at the corner *b*<sup>2</sup>. This blank is then inserted over a head, *e*, of the mandrel, while the ring F is placed over the blank. While the blank is held in this position and the mandrel rotated in a lathe, the burnishing-tool is applied to the rounded corners *a*, and pressed thereupon until the bottom *b* and barrel *b*<sup>1</sup> are at a sharp angle to each other. The base for the stud or setting is then finished and ready to be used for its intended purpose.

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

1. The combination of the mandrel, ring, and burnishing-tool, as and for the purpose described.

2. The method of making the base *b b*<sup>1</sup> *b*<sup>2</sup> by first stamping the blank A into the form A' and then burnishing the corner *b*<sup>2</sup> until the bottom *b* and barrel *b*<sup>1</sup> are at a sharp angle to each other, as set forth.

SHUBAEL COTTLE.

Witnesses:

JAMES T. GRAHAM,  
T. B. MOSHER.