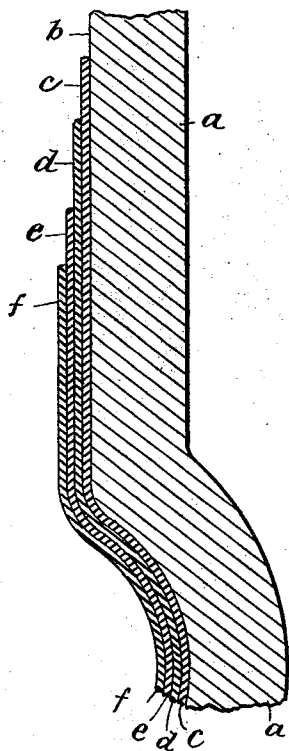


(No Model.)

F. KROEBER.
METHOD OF COATING CLOCK CASES.

No. 506,050.

Patented Oct. 3, 1893.



WITNESSES:

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FLORENCE KROEBER, OF NEW YORK, N. Y.

METHOD OF COATING CLOCK-CASES.

SPECIFICATION forming part of Letters Patent No. 506,050, dated October 3, 1893.

Application filed February 15, 1893. Serial No. 462,414. (No specimens.)

To all whom it may concern:

Be it known that I, FLORENCE KROEBER, a resident of the city, county, and State of New York, have invented an Improvement in Clock-Cases, of which the following is a specification.

My invention relates more especially to clock cases.

The main object of the invention is to provide an improved method of coating such cases, and of giving them the desired color.

The invention consists in the method and in the product or article hereinafter described and set forth in the claims.

In the drawing the figure shows a section of a piece of the clock case with several layers of coating material thereon according to this invention, and shown largely magnified in thickness.

By my invention I am able to coat clock cases with a film of coloring material,—hereinafter called enamel-like material, since it is applied and then subjected to heat, giving it a glazed or enamel-like appearance,—in such manner as to give a fine imitation of porcelain, and one in which the film is not liable to fracture and peel off.

The clock case has a body *a*, preferably of iron, and the outer surface *b* is carefully polished by any suitable means. On said surface is placed a coating *c* of said enamel-like material, which is then subjected to moderate heat, whereby it is fixed on the surface. The heat to which the article is subjected to fix the enamel-like material is just high enough to render the coat viscid, but not high enough to render it hard and unworkable. I have found that a temperature of 120° Fahrenheit, or thereabouts, is sufficient to produce this result. This coating is then rubbed down while in a viscid condition with pumice stone and hot water, or other similar polishing substances, by which all roughnesses are removed and a very thin even coating is left on the polished iron. Over coating *c* is placed a similar coating *d*, which is then also subjected to the same degree of heat and polished or rubbed down considerably while yet viscid in the manner above indicated. The layers *c d* are preferably not colored, and the number of these layers may be varied. Over layer *d* is placed a layer *e*, which should con-

tain a suitable coloring material to form a foundation for subsequently applied layers, and which is also subjected to heat, and then, preferably polished. Over this layer is placed one layer or more of enamel-like material *f*, having the desired color, such as cream white, red, pink, green or blue. These layers are each subjected to heat, but are preferably not polished. The several coatings, or some of them, and especially the last one, should have in them or in it a varnish capable of standing the heat to which the coating is subjected, and which will give a fine gloss or porcelain appearance to the surface. The number of the colored coatings applied may also be varied.

Sometimes the polishing of the surface to be coated may be omitted, but this will generally require more layers and more polishing of the coating material.

In practice I use an enamel-like material for the first layers composed of a mixture of oxide of zinc, oxide of lead and flattening, or any suitable varnish, and for the last layers I have used flattening or any suitable varnish with coloring material to produce either color mentioned, and have subjected each layer to a temperature of about 120° Fahrenheit. This not only dries the layers quickly, but gives a better glaze to the surface.

As above indicated the coating applied as described is very permanent, and has the exact appearance of porcelain.

Having now described my invention, I claim—

1. The method of coating clock cases which consists in applying several coats of enamel-like material, heating the article after each coat has been applied to a degree of temperature sufficient to render the coat viscid, and rubbing down each coat separately while in the viscid condition, whereby all roughnesses are removed and a thin even coating is left on the clock case, substantially as and in the manner specified.

2. The method of coating clock cases which consists in applying to the article one or more coats of enamel-like material, heating the same after each coat has been applied to a degree of temperature sufficient to render the coat viscid, and separately finishing each coat by rubbing down while viscid, then applying

one or more coats of enamel-like material with coloring matter added and heating after each coat to the same degree of temperature as before, then applying one or more coats of
5 the last named material mixed with varnish, and heating the article after each of said coats has been applied, substantially as and in the manner specified.

3. The method of coating clock cases which
10 consists in applying to the article one or more coats of enamel-like material consisting of oxide of zinc and oxide of lead mixed with

varnish, heating the same after each coat has been applied to a degree sufficient to render the coat viscid, and separately finishing each
15 coat by rubbing down, then applying one or more coats of varnish with coloring material embodied therein and heating after each of these coats has been applied, substantially as and in the manner specified.

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Witnesses:

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G. FOLKE.