Feb. 13, 1934. T. E. FOSTER 1,947,254

METHOD OF MAKING A FINGER RING

Filed Dec. 1, 1932

FIG. 1

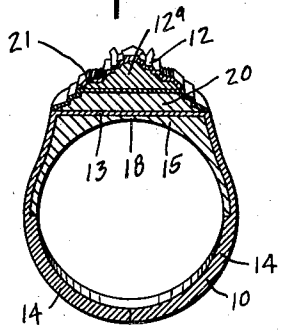


FIG. 2

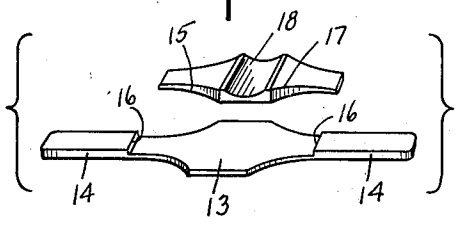


FIG. 3

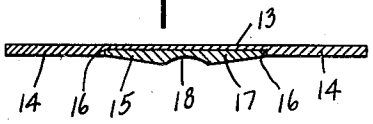


FIG. 5

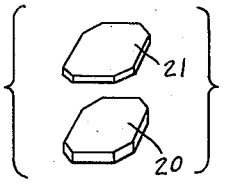


FIG. 4

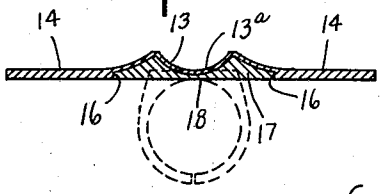


FIG. 7

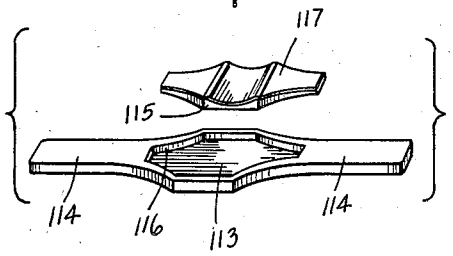


FIG. 6

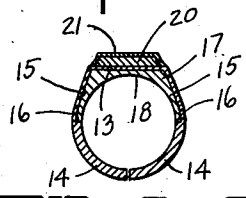


FIG. 8

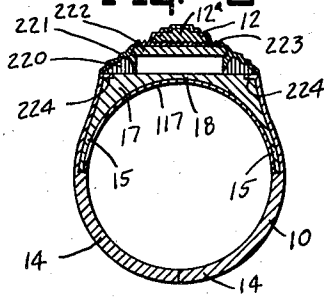
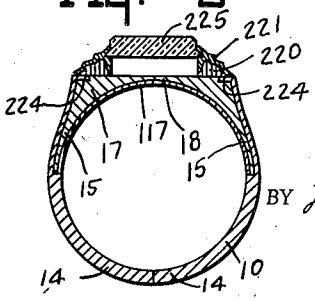


FIG. 9



INVENTOR.
TONY E. FOSTER.
BY Lockwood Lockwood Goldsmith & Galt
ATTORNEYS.

Patented Feb. 13, 1934 1,947,254

UNITED STATES PATENT OFFICE

1,947,254

METHOD OF MAKING A FINGER RING

Tony E. Foster, Indianapolis, Ind., assignor to Herff Jones Company, Indianapolis, Ind., a corporation

Application December 1, 1932
Serial No. 645,199

4 Claims. (Cl. 29—160.6)

This invention relates to the method of making a finger ring, and particularly that type of ring commonly known as an "all metal" or "stone" ring used extensively with fraternal, school or class emblems imposed thereon.

The principal object of the invention is to produce a ring of this general character which is formed of two different metals, principally gold and silver, in such manner as to give the desired weight and wearing qualities while enabling the cost of material to be substantially reduced. It has been common practice to form rings with a base or filler of a cheaper metal, such as silver, on which a gold facing, of sufficient thickness to meet wearing requirements, is secured by soldering or fusing. It is the purpose of this invention, however, to utilize this principle in constructing a ring having a gold finger band with a silver filling, in such manner that the silver surface will not be exposed through wear. Where silver is employed for making a finger band which is overlaid or gold plated, the wear thereof is such as to shortly wear through the gold overlay or plate. Thus, it is highly desirable that the finger band be made of solid gold, while still employing silver fillers for the emblem portion of the ring.

The full nature of the invention will be understood from the accompanying drawing and the following description and claims:

In the drawing, Fig. 1 is a central vertical section through the finished ring shown in perspective. Fig. 2 is a perspective view of the finger band blank with filler piece. Fig. 3 is a central vertical section through the finger band inverted with filler attached ready for stamping and forming. Fig. 4 is a central vertical section through the finger band blank and filler showing it formed in dotted lines after stamping. Fig. 5 is a perspective view of the crown including the crown piece and filler. Fig. 6 is a central vertical section through the formed finger band blank and crown prior to finishing. Fig. 7 is the same as Fig. 2 showing a modified form. Figs. 8 and 9 are the same as Fig. 1 showing modified forms of the crown and ornamented structure.

In the drawing there is illustrated a ring having a finger band 10 and emblem 12. Said ring is formed by blanking out the finger band with a central recessed portion 13 and oppositely extending finger band portions 14. Said portions 14 are substantially twice or three times as thick as the recessed portion 13, which in turn is of a width substantially the desired length of the emblem portion of the finished ring. Said blank is formed of gold or precious metal from which the finger band 10 is formed. A filler 15 of silver or less precious metal is blanked out to conform with the shape of the recessed portion 13 having the ends thereof substantially of the thickness of the shoulders 16, said filler increasing in thickness towards the center thereof, as indicated at 17, but provided with a concave recess 18 to provide a flat base when stamped.

The filler piece 15 is then soldered or fused to the blanked out finger band, as illustrated in Fig. 3, after which it is placed in a die and stamped into shape, as illustrated in Fig. 4. As shown in Fig. 4, it will be noted that the peculiarly shaped filler 17 with the concave portion 18 is reversed by the stamping so that it is formed with a flat surface and the metal of the filler is pushed up to provide a reversed concave portion on the upper side, as indicated at 13*a*. Thereupon, the finger band portions 14 are bent downwardly into a curved position, as shown by dotted lines in Fig. 4, drawing the surface 13 from the concave form 13*a* to a flat form providing the base 13 of the ring, as illustrated in Fig. 6, the angular portions providing the thickened shoulders. The finger band blank is gold so as to provide a solid gold finger band in the finished ring whereby any amount of wear received thereby will not alter the appearance or surface thereof. However, the filler piece is of a less precious metal, such as silver, which will be unexposed in wearing.

To form the thick crown of the ring upon which the emblem is mounted, there is provided a filler piece 20 over which an overlay or finishing crown piece 21 is mounted. The filler piece is of less precious metal, such as silver, and is appreciably thicker than the crown piece 21 which is of gold or the like. These two pieces are soldered or fused together, after which they are formed or stamped, causing the edges of the crown piece 21 to be drawn down over the edges of the filler piece 20, as shown in the upper portion of Fig. 6.

The finger band portion having been drawn into form, as indicated by the dotted lines in Fig. 4, the crown, as above formed, is then soldered, fused or otherwise secured in place thereon, as illustrated in its entirety in Fig. 6. Thereupon the emblem 12, formed in the same manner with a filler 12*a*, is secured upon the crown piece 21 to complete the structure of the ring.

From the foregoing, it will be noted that the lower half of the finger band 10, that portion receiving the greatest wear, is of solid gold, as formed in the finished ring from the finger band

blank, the fillers 15, 20 and 12*a* being entirely contained within a covering of precious metal or exposed only within the interior of the ring adjacent the crown.

Fig. 7 is a modified form illustrating the finger band blank 114 provided with a walled recess 113 surrounded by the wall 116 into which the filler piece 115 is imbedded and secured in the same manner as above described. In this modified form there will be no exposure of the edges of the filler piece, as is the case in the above-described structure. However, said edges, when polished, are barely distinguishable. Furthermore, the filler piece 115 is covered with a surfacing piece 117 of precious metal, so that the filler metal will not be exposed on the upper side of the interior of the finger band.

Fig. 8 shows a construction of an all metal ring having a hollow or open space intermediate the crown and emblem, said hollow space being surrounded by a ring-like filler 220 covered by the crown piece 221 formed in the above-described manner, with a seat into which a filler 222 is positioned with the edges of the crown piece 221 peened over to secure it in place and cover the outer edges thereof, the filler 222 being protected by another crown piece 223 of precious metal upon which the emblem with the filler 12*a* is mounted. In this construction the precious metal does not extend entirely over the filler 15, but terminates in short flanges, as indicated at 224.

Fig. 9 illustrates the same invention as applied to a stone ring, the structure being similar to that shown in Fig. 8 with a stone 225 seated in the crown and secured thereto by the edges 221 peened over to secure it in place and cover the outer edges thereof. Where desired, any suitable emblem may be mounted over the stone 225.

The invention claimed is:

1. A method of making a finger ring consisting in forming a flat blank of precious metal with a recess in one side thereof, securing a filler within said recess having a thickened central portion provided with a curved recess therein, stamping said combined blank and filler to reverse the formation thereof whereby the thickened portion with the central recess will be extended to the other side of the filler with the precious metal covering the surface thereof, and thereafter bending the ends of the blank to provide a finger band, causing the recessed portion to be straightened out to provide a substantially flat surface.

2. A method of making a finger ring consisting in forming a flat blank of precious metal with a recess in one side thereof, securing a filler within said recess having a thickened central portion provided with a curved recess therein, stamping said combined blank and filler to reverse the formation thereof whereby the thickened portion with the central recess will be extended to the other side of the filler with the precious metal covering the surface thereof, thereafter bending the ends of the blank to provide a finger band, causing the recessed portion to be straightened out to provide a flat surfaced crown portion, providing a crown piece having a crown filler, and securing the same over said flattened surface.

3. A method of making a finger ring consisting in forming a blank of precious metal with the finger band portions extending away from each other in the same plane, providing a recessed portion intermediate the finger band portions, securing a filler within said recess having a thickened central portion provided with a curved recess on one side thereof, and thereafter bending said finger band portions to provide a circular finger band.

4. A method of making a finger ring consisting in forming a blank of precious metal with the finger band portions extending away from each other in the same plane, providing a recessed portion intermediate the finger band portions, securing a filler within said recess having a thickened central portion provided with a curved recess on one side thereof and a flat surface on the other side extending in the same plane as said finger band portions, and thereafter bending said finger band portions and filler to provide a circular finger band causing the recessed portion of the filler to be straightened out to provide a substantially flat surface.

TONY E. FOSTER.