Nov. 17, 1970 R. MARTHALER 3,540,109

PROCESS FOR MANUFACTURING METALLIC BANDS FOR BRACELETS

Filed Nov. 2, 1967

FIG. 1

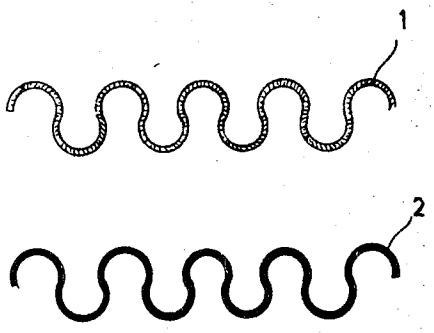


FIG. 2

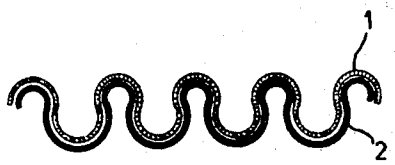
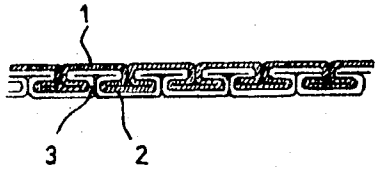


FIG. 3



United States Patent Office 3,540,109 Patented Nov. 17, 1970

3,540,109

PROCESS FOR MANUFACTURING METALLIC BANDS FOR BRACELETS

Rene Marthaler, Chaux-de-Fonds, Switzerland, assignor to Moblot Manufacturing Rene Marthaler, Chaux-de-Fonds, Switzerland, a Swiss company

Filed Nov. 2, 1967, Ser. No. 680,112
Claims priority, application Switzerland, June 30, 1967, 9,343/67
Int. Cl. B23p *11/00*
U.S. Cl. 29—160.6 1 Claim

ABSTRACT OF THE DISCLOSURE

Process for manufacturing metallic bands for bracelets from at least two metallic strips, the laterally-viewed longitudinal cross-section of the strips being repeated accentuated loop shapes. The strips are laminated by crushing together so that the loops of the two strips interpenetrate one another and hold the strips together.

The object of the invention is a process for making composite metallic bands for bracelets from at least two metallic strips. These strips are placed together and have repeated accentuated, loop-shaped cross-sections laterally viewed in the longitudinal direction. They are laminated by crushing together so that the loops of the two strips interpenetrate one another and hold the strips together.

The process according to the invention departs from known techniques and makes possible the manufacture of thin bracelets which exhibit the properties of its different components.

By combining for example a gold and a steel band, there can be made a bracelet which has the appearance of gold but the strength and the elasticity of steel.

The accompanying drawing represents by way of example one embodiment of the invention.

FIG. 1 shows a lateral longitudinal view of two metallic strips before their assembly.

FIG. 2 shows a similar view of the two strips of FIG. 1 assembled but not laminated.

FIG. 3 shows a similar view of the two metallic strips after laminating to form a band.

In FIG. 1 are shown two metallic strips **1** and **2**, strip **1** being for example of brass or of gold, while strip **2** is of steel. The strips are first made wavy in such a way as to have an accentuated repeated-loop-shaped cross-section with the loops slightly closed. This shape is obtained by means of known processes.

The two strips are then applied one on the other in such a way that the loops interpenetrate (FIG. 2). Owing to the strength and the elasticity of steel strip **2**, the loops of the composite strips of FIG. 2 retain their slightly closed shape. The more the loops are closed, the better the composite strips will lend themselves to the subsequent step of laminating.

After laminating, the band has the shape shown in FIG. 3. The loops are completely crushed and assume the shapes of a T, the two strips being then intimately linked by the interpenetration of the T-shaped sections. The continuity of the two strips is not however interrupted and there is obtained a band for a bracelet the two surfaces of which have the same appearance which differ only by the colour of the metals used. This appearance is that of a succession of parallel links connected therebetween by invisible elements.

The bracelet band thus made can be very thin and has the characteristics of the metals or alloys which form it. If the band is composed of a gold and a steel strip, it will thus have the appearance of a gold bracelet band with the strength and the elasticity of a steel bracelet band.

If a steel and a brass strip are associated, there will be obtained a two-sided bracelet band which can be used with gold-plated watch cases as well as with steel watch cases.

It is of course possible to laminate together more than two trips, for example two strips of steel or two different metals combined with a brass, gold or cheaper aluminium strip.

By a judicious choice of the metals used, it is possible to combine advantageously the different characteristics of metals used, such as strength, elasticity, flexibility, corrosion resistance, aesthetic appearance, while making a bracelet band which is very thin.

What is claimed is:

1. Process for manufacturing a metallic band for a bracelet comprising providing at least two metallic strips, one of said strips being of relatively resilient metal, the laterally-viewed longitudinal cross-sections of each of the strips being repeated accentuated slightly closed loop-shapes, applying said strips together in mutually superposed relation so that each loop shape of one strip enters a corresponding loop shape of another of said strips, said superposed loop shapes being mutually retained together by the elasticity of said on strip, and laminating said strips by crushing them together so that the loops of the strips interpenetrate one another and are permanently deformed and flattened into interlocked T-shaped sections.

References Cited

UNITED STATES PATENTS

298,358	5/1884	Edge	29—160.6
324,014	8/1885	Edge	63—2
451,550	5/1891	Bayer.	
2,054,408	9/1936	Casey.	
2,246,221	6/1941	Prestinari et al.	63—11 X

F. BARRY SHAY, Primary Examiner

U.S. Cl. X.R.

29—509, 521; 63—11