

(No Model.)

2 Sheets—Sheet 1.

F. KELLER & C. FREY.

DIE FOR STRIKING UP BRACELET STOCK.

No. 252,676.

Patented Jan. 24, 1882.

Fig. 1.

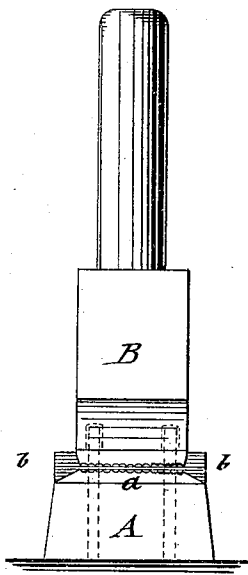


Fig. 2.

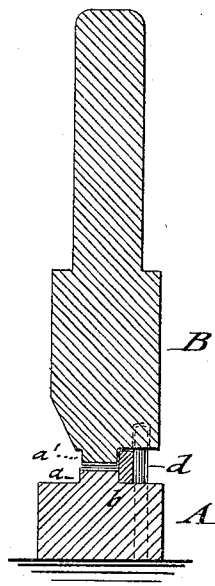


Fig. 4.

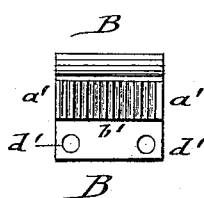


Fig. 3.

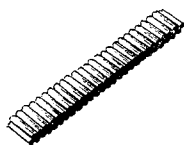
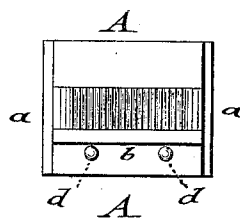


Fig. 5.

WITNESSES:

Otto Risch
Carl Risch

INVENTOR

Frank Keller
Charles Frey
BY Paul Goepel
ATTORNEY

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Fig. 6.

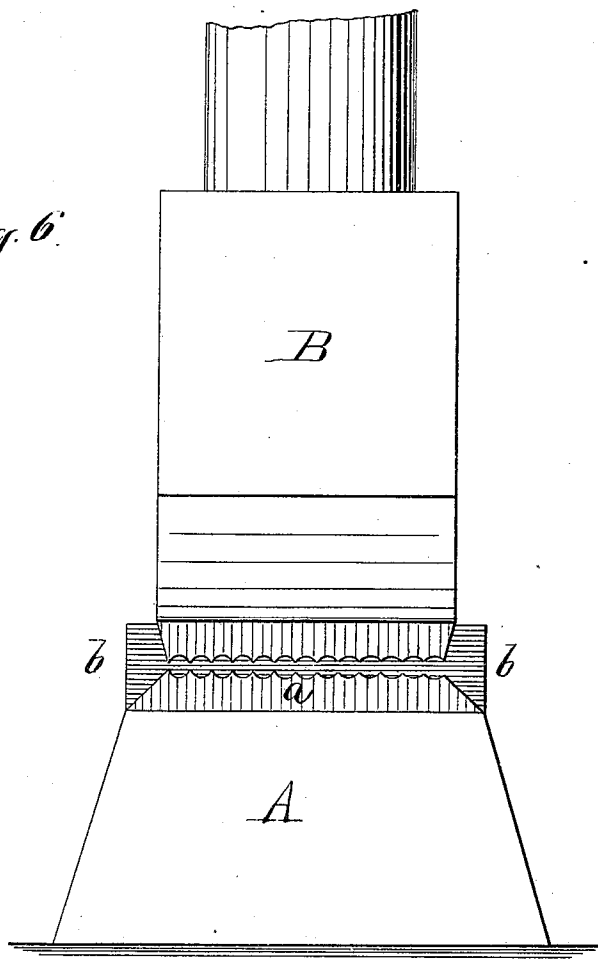
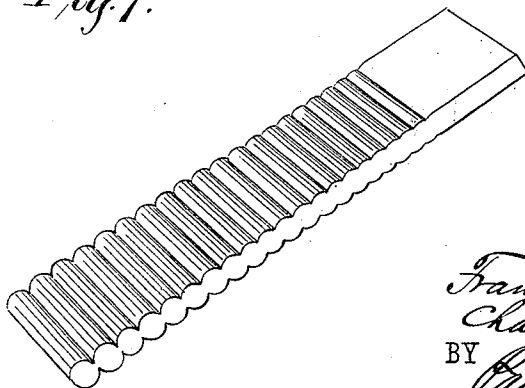


Fig. 7.



WITNESSES:

Carl Kay
J. H. Rosenbaum.

INVENTOR

Frank Keller
Charles Frey
BY *Paul L. G. L.*
ATTORNEY

UNITED STATES PATENT OFFICE.

FRANK KELLER AND CHARLES FREY, OF NEW YORK, N. Y.

DIE FOR STRIKING UP BRACELET-STOCK.

SPECIFICATION forming part of Letters Patent No. 252,676, dated January 24, 1882.

Application filed June 25, 1881. (No model.)

To all whom it may concern:

Be it known that we, FRANK KELLER and CHARLES FREY, of the city, county, and State of New York, have invented certain new and useful Improvements in Dies for Striking Up Corrugated Strips, of which the following is a specification.

This invention relates to an improved die for striking up gold or other metallic strips with corrugations upon both sides, to be used for ornamental purposes in the manufacture of jewelry; and the invention consists of a lower die-section having a corrugated middle portion, a guide-shoulder back of the same, and guide-pins back of the shoulder, in combination with an upper die-section having a corrugated middle portion and a recess back of the same, and socket-holes for the guide-pins back of the recess.

In the accompanying drawings, Figure 1 represents a front view; Fig. 2, a vertical transverse section of our improved die for striking up corrugated strips. Figs. 3 and 4 are respectively a top view and a bottom view of the lower and upper die-sections. Fig. 5 is a perspective view of a corrugated strip struck up by an improved die. Fig. 6 is a front view of the die on an enlarged scale, showing the diminishing concavity of the seats; and Fig. 7 is an enlarged perspective view of a strip after the first blow.

Similar letters of reference indicate corresponding parts.

A in the drawings represents the lower and B the upper section of our improved die for striking up corrugated strips of gold or other metal.

The lower die-section, A, is provided with a raised central portion, *a*, that is corrugated at its upper surface. Immediately back of the corrugated portion *a* is arranged an upwardly-extending guide-shoulder, *b*, of greater height than the portion *a*, and back of the same two upright guide-pins, *d*.

The upper die-section, B, is arranged with a corrugated portion, *a'*, which is an exact counterpart of the lower corrugated portion, *a*. Back of the corrugated portion *a'* is arranged a guide-recess, *b'*, of less depth than the height of the shoulder *b* of the lower section, A, so that the upper die-section, B, in its downward

motion, is stopped by the shoulder and permitted to descend only far enough so that its corrugated portion *a'* is retained at a certain fixed distance from the corrugated portion *a* of the lower die-section, A. The upper die-section, B, has, furthermore, back of the recess *b'*, socket-holes *d'*, which register with the guide-pins *d* of the lower die-section, so as to prevent the lateral displacement of the upper die-section and secure the perfect registering of the corrugated portions one vertically above the other.

The corrugations of the die-sections are not made equal in size with each other, but are so arranged as to increase gradually in concavity from one end of the die-sections to the other while decreasing in width, as shown clearly in Figs. 5 and 7.

The flat strip of gold to be corrugated is introduced at that side of the die-sections at which the corrugations are less concave, but wider, and inserted for the length of one corrugation. A blow is then given by the upper die, whereby one corrugation is formed on the strip. The strip is now advanced for the distance of one corrugation, so that the second stroke forms a second corrugation next to the first one, while the first corrugation receives a more convex form. This is continued all through the die-sections until each completed corrugation has received a separate stroke while placed under each of the successive concavities of the die-sections, so that finally corrugations of uniform width and convexity are produced.

In this manner gold strips with ribs or corrugations of uniform size are obtained quicker and at less expense than when made by hand, to be then applied for ornamental purposes in the manufacture of jewelry.

Having thus described our invention, we claim as new and desire to secure by Letters Patent—

1. The combination of the lower die-section, A, having a central raised and corrugated portion, *a*, a vertical guide-shoulder, *b*, back of the same, and guide-pins *d*, with an upper die-section, B, having a corrugated portion, *a'*, a recess, *b'*, of less depth than the guide-shoulder *b*, back of the corrugated portion *a'*, and socket-holes *d'*, vertically above the guide-pins *d*, all

arranged substantially as and for the purpose set forth.

2. As an improvement in dies for striking up corrugated strips, a lower die-section, A, having a raised corrugated portion, *a*, and an upper die-section, B, having corrugated portion *a'*, the corrugations of the parts *a* *a'* diminishing gradually in width while increasing in height from one end to the other of the dies, in combination with guide and stop devices, by which the motion of the upper die is controlled, substantially as set forth.

In testimony that we claim the foregoing as our invention we have signed our names, in presence of two witnesses, this 22d day of 15 June, 1881.

FRANK KELLER.
CHARLES FREY.

Witnesses:

ADAM KELLER,
JOSEPH KELLER, Jr.