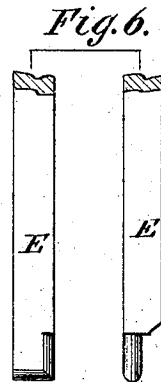
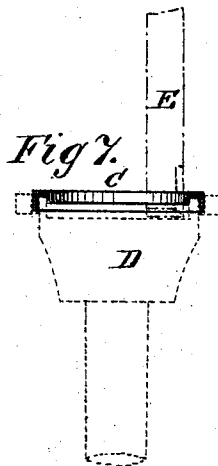
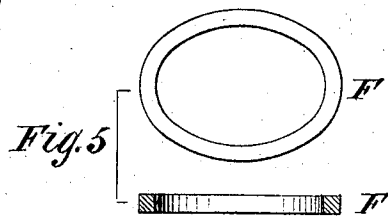
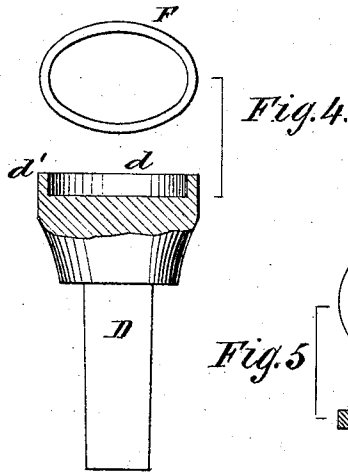
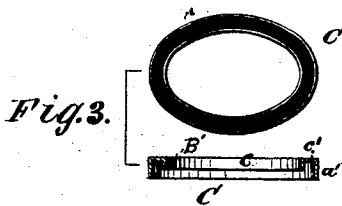
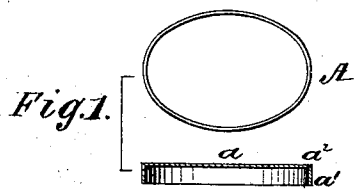


S. COTTLE.

Manufacture of Jewelry Bases.

No. 135,087.

Patented Jan. 21, 1873.



Witnesses:
G. M. Watkins
C. A. Pettit

Inventor:
Shubael Cottle
per
Attorneys.

UNITED STATES PATENT OFFICE.

SHUBAEL COTTLE, OF NEW YORK, N. Y.

IMPROVEMENT IN THE MANUFACTURE OF JEWELRY-BASES.

Specification forming part of Letters Patent No. 135,087, dated January 21, 1873.

CASE C.

To all whom it may concern:

Be it known that I, SHUBAEL COTTLE, of New York, in the county of New York, and State of New York, have invented Means for Making certain Forms of Jewelry-Bases for Studs, Buttons, or Settings, of which the following is a specification:

The invention consists in a new mode of forming an inner barrel on a jewelry-blank, as hereinafter fully described and subsequently claimed.

Figure 1 represents, in plan and section, the first blank employed; Fig. 2, the second blank; Fig. 3, the completed article; Fig. 4, the mandrel and ring; Fig. 5, a detail plan and sectional view of ring; Fig. 6, a view of burnisher; Fig. 7, the mandrel with article finished thereon.

A represents a blank, having bottom a and barrel a^1 at a sharp angle, a^2 , to each other. B is a second blank, formed from the first and differing from it only in having the hole b cut out of it so as to leave the edge B' . C is the article or product ready to receive the studs, buttons, or settings, having the internal barrel c concentric with the one a^1 , and an inter-

mediate groove or channel, c' . D is a mandrel having the cavity d corresponding in form to hole b and the mandrel edge d' of a thickness corresponding to the width of blank groove c' .

The blank B is turned bottom upward over the edge d' of mandrel, and ring F placed over blank B, and the blank edge B' turned over inwardly with a burnisher, E, until at right angles to bottom. This produces the base C, which is now ready for receiving the stud or setting.

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

1. The mandrel D, having edge d' and cavity d , constructed as described, and combined with a burnisher and ring, as and for the purpose set forth.

2. The method of forming on the blank A an inner barrel, C, concentric with outer barrel, substantially as described.

SHUBAEL COTTLE.

Witnesses:

JAMES T. GRAHAM,
T. B. MOSHER.