(No Model.)

A. LAMBERT.

MODE OF MANUFACTURING BRACELETS.

No. 264,541. Patented Sept. 19, 1882.

Fig: 1.



Fig: 2.

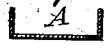


Fig: 3.

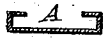


Fig: 4.

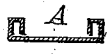


Fig: 5.

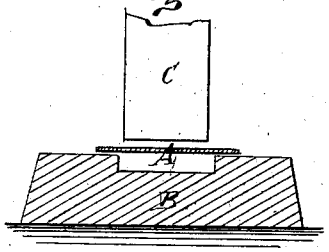


Fig: 6.

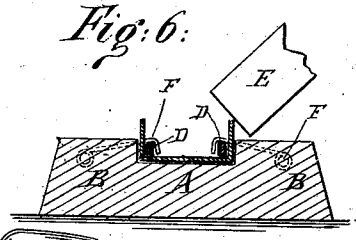


Fig: 7.

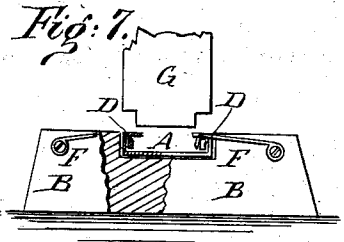
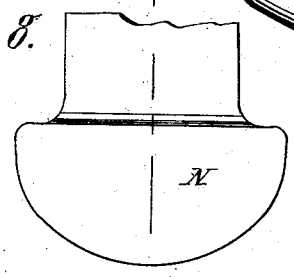


Fig: 8.



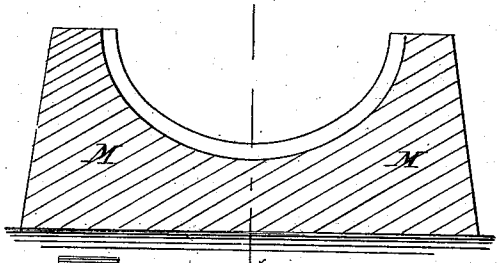


Fig: 9.

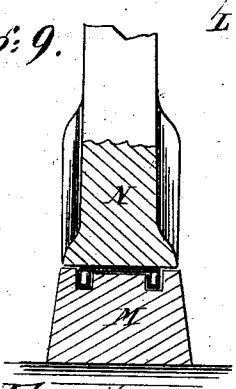


Fig: 10.

Fig: 11.

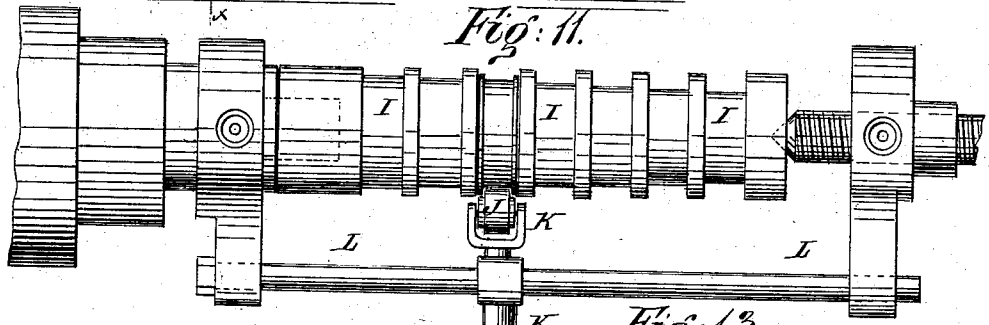


Fig: 12.

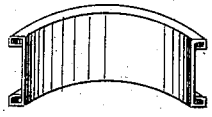
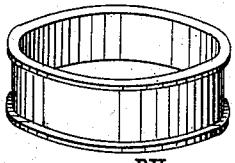


Fig: 13.



WITNESSES:

Chas. Nida.

C. Sedgwick

INVENTOR:

A. Lambert

BY Munn & Co.

ATTORNEYS.

N. PETERS. Photo-Lithographer, Washington, D. C.

UNITED STATES PATENT OFFICE.

ALONZO LAMBERT, OF CORONA, ASSIGNOR TO S. W. HALE & CO., OF NEW YORK, N. Y.

MODE OF MANUFACTURING BRACELETS.

SPECIFICATION forming part of Letters Patent No. 264,541, dated September 19, 1882.

Application filed March 23, 1882. (No model.)

To all whom it may concern:

Be it known that I, ALONZO LAMBERT, of Corona, in the county of Queens and State of New York, have invented certain new and useful Improvements in the Mode of Manufacturing Bracelets, of which the following is a full, clear, and exact description.

Reference is to be had to the accompanying drawings, forming part of this specification, in which similar letters of reference indicate corresponding parts in all the figures.

Figure 1 is a section of the stock for a bracelet before being operated upon. Fig. 2 is a section of the same after the first operation. Fig. 3 is a section of the same after the second operation. Fig. 4 is a section of the same after the third operation. Fig. 5 is an end elevation, partly in section, of the dies for performing the first operation. Fig. 6 is an end elevation, partly in section, of the die and tool for performing the second operation. Fig. 7 is an end elevation, partly in section, of the dies for performing the third operation. Fig. 8 is a side elevation, partly in section, of the dies for giving shape to half-bracelets. Fig. 9 is a sectional end elevation of the same, taken through the line *x x*, Fig. 8. Fig. 10 is a sectional end elevation of the mandrel for giving shape to the bracelet when made in one piece, the bending-tool being shown in side elevation. Fig. 11 is a plan view of the same. Fig. 12 is a perspective view of a half-bracelet. Fig. 13 is a perspective view of a bracelet made in one piece.

The object of this invention is to facilitate and cheapen the manufacture of bracelets made with raised rims.

The invention consists in the mode of manufacturing bracelets having raised rims by bending the edges of the stock upward at right angles by pressing the stock into a grooved die, then bending the turned-up edges inward at right-angles over rectangular wires placed in the angles of the stock while still in the die, then bending the inwardly-projecting edges downward at right angles along the inner sides of the wires, and then bringing the bracelet into shape upon an oval mandrel with a bending-tool; also, in the combination, with a lathe, of a graduated mandrel, a bending-tool, and its fulcrum-rod, whereby a bracelet can be readily brought into the required shape; and, also, in a bending-roller having rabbets at its ends, in combination with an oval annular grooved mandrel, and a shiftable hand-lever, whereby a bracelet made with projecting rims can be readily brought into shape, as will be hereinafter fully described.

A represents a plate of gold or other metal of suitable length, width, and thickness to form a bracelet. The stock A is laid upon a female die having a rectangular channel formed in its face of a width equal to the desired width of the bracelet. The stock A is forced into the die B by a male die, C, bending its edges upward at right angles, and bringing it to the form shown in Fig. 2. Rectangular wires D, of suitable size, are then placed in the angles of the stock A, and the edges of the said stock are then hammered or burnished down upon the said wires with a suitable tool, E, bringing the stock A to the form shown in Fig. 3, each edge being bent twice at right angles, the said wires being held in place by hooks F, as shown in Fig. 6. The inwardly-projecting edges of the stock A are then bent downward at right angles along the inner sides of the wires D by a die, G, of suitable size, as indicated in Fig. 7, each edge of the stock being thus bent three times at right angles, as shown in Fig. 4. The stock A is then removed from the die B, and one of its ends is inserted in a groove or slot, H, in the bottom of an annular groove in an oval mandrel, I, and the stock is worked down into the said groove by a bending roller or tool, J, bringing the stock to the oval form required in a bracelet. The mandrel I is placed in and revolved by an ordinary lathe. The bending-roller J is pivoted to the forked end of a lever-handle, K, which has an eye formed in it to receive and slide upon a rod, L, connected with and supported by the lathe-heads, and which serves as a slide and fulcrum for the bending-tool. For convenience in making bracelets of different sizes, the mandrel I is graduated in size and in the width and depth of its grooves, so that bracelets of different sizes can be brought into shape upon the same mandrel. The bending-roller J is rabbeted at its ends, so as to operate upon the body of the

stock and upon its rims. When the stock has been brought to the desired shape it is removed from the mandrel I, its elasticity being sufficient to allow it to be sprung from the said mandrel without having its shape changed. The wires D are then withdrawn from the stock A, and the said stock is provided with a hinge and catch, and is ornamented and finished in the ordinary manner.

When the bracelet is to be made in two parts or halves the stock is placed in a female die, M, having a half-oval face, and having grooves along the sides of its face to receive the rims of the said stock, and the stock is brought into a half-oval shape by a male die, N, having a corresponding half-oval face, as shown in Figs. 8 and 9. The two parts of the bracelet are then provided with a hinge and a catch, and are ornamented in the ordinary manner.

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

1. The mode of manufacturing bracelets having raised rims, substantially as herein shown and described, which consists in bending the edges of the stock upward at right angles by pressing the stock into a grooved die, then bending the turned-up edges inward at right angles over rectangular wires placed in the angles of the stock while still in the die, then bending the inwardly-projecting edges downward along the inner sides of the wires, and then bringing the bracelet into shape upon an oval mandrel with a bending-tool, as set forth.

2. The combination, with a lathe, of the mandrel I, having graduated annular grooves provided with slots in their bottoms, the bending-tool J, hand-lever K, and the fulcrum-rod L, substantially as herein shown and described, whereby the bracelet can be readily brought into the required shape, as set forth.

3. The combination, with the oval mandrel I, having annular grooves, of the pivoted shiftable hand-lever K and the rabbeted roller J, as shown and described.

ALONZO LAMBERT.

Witnesses:
WILLIS H. HAWES,
CHAS. H. BALDWIN.