

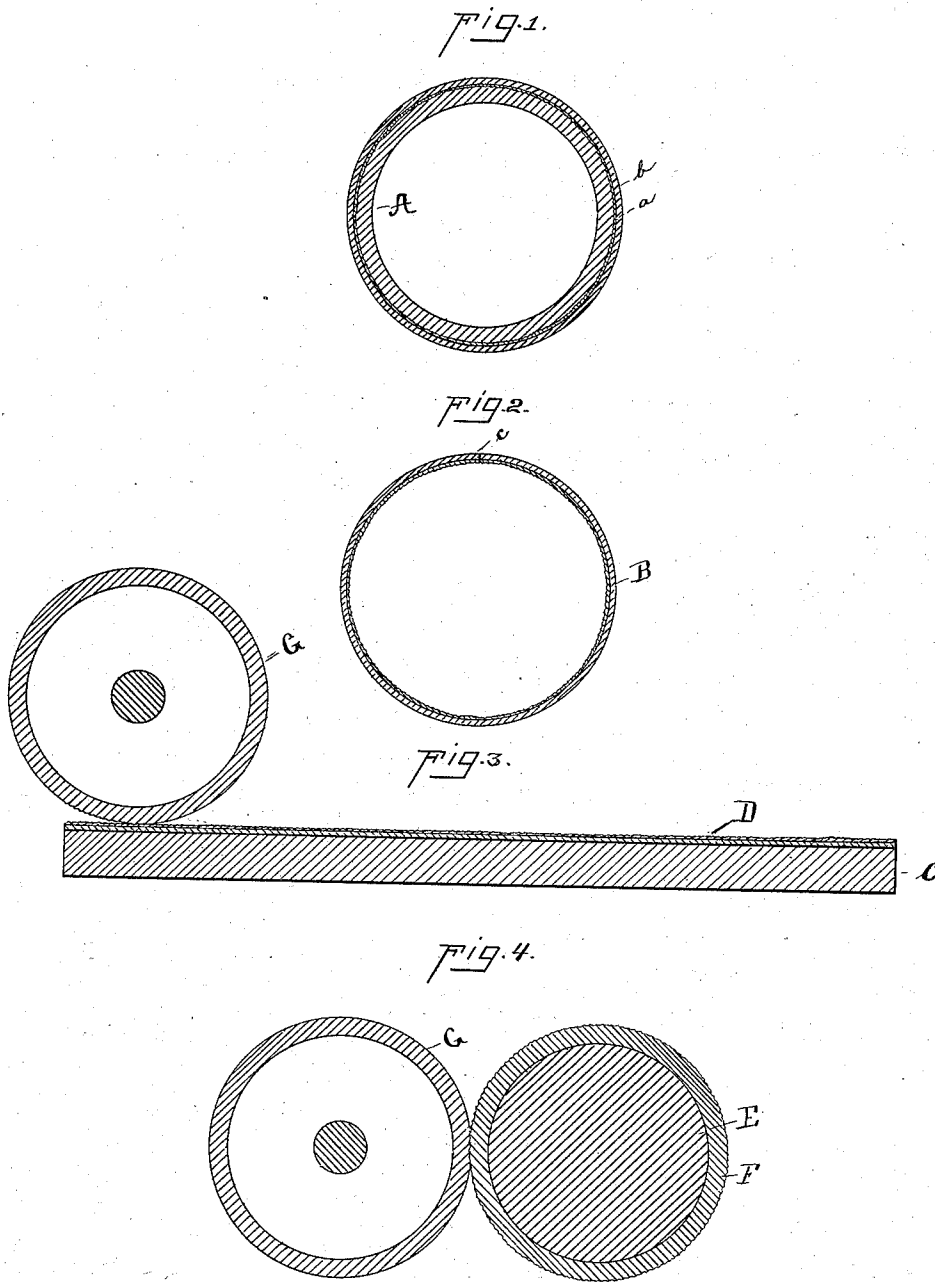
(No Model.)

T. A. EDISON.

PROCESS OF DUPLICATING PHONOGRAMS.

No. 382,419.

Patented May 8, 1888.



Witnesses  
E. B. Rowland  
William Rizer

Inventor.  
Thomas A. Edison.  
By his Attorneys *John S. Tracy*

# UNITED STATES PATENT OFFICE.

THOMAS A. EDISON, OF LLEWELLYN PARK, NEW JERSEY.

## PROCESS OF DUPLICATING PHONOGRAMS.

SPECIFICATION forming part of Letters Patent No. 382,419, dated May 8, 1888.

Application filed March 8, 1888. Serial No. 266,596. (No model.)

*To all whom it may concern:*

Be it known that I, THOMAS A. EDISON, a citizen of the United States, residing at Llewellyn Park, in the county of Essex and State of New Jersey, have invented a certain new and useful Improvement in Processes for Duplicating Phonograms, (Case No. 765,) of which the following is a specification.

The object of my invention is to produce a simple and efficient process for duplicating phonographic records. In applications already filed by me I describe a process for duplicating phonograms, wherein a metallic matrix is formed by depositing metals over the surface of cylindrical wax phonograms and then dissolving out the wax, leaving a hollow matrix or mold with the record in relief upon its inner surface. By my present invention I propose to apply the process of knurling to the duplication of phonograms as distinguished from molding. In my English Patent No. 1,644 of 1878 I proposed to construct a knurl by depositing metal over the record; but it is obvious that if this deposit were made of any thickness at all the record would be largely obliterated.

By my present invention I deposit metals over the record of the recording-surface of a cylindrical wax phonogram, and after melting out the original wax I divide the remaining cylinder by splitting it longitudinally with a thin saw on one side. I then open the cylinder out flat or further bend it into the form of a cylinder, with the record upon its exterior. To give the necessary strength I provide a suitable backing. The result is a flat or cylindrical knurling-surface having the record in relief, so that by rolling a wax phonogram-blank upon it the original record will be reproduced.

For making the first deposit upon the original wax phonogram I prefer to employ silver, which is deposited upon the wax phonogram by the vacuum process or by electroplating. A thin coating is produced in this way, which is backed up by a coating of lead or tin, which is also quite thin. For example, it may be one-sixteenth of an inch in thickness. The silver gives an inoxidizable surface, which is cheaper than gold or platinum. After the wax is dissolved out and this cylinder split on one side it will be found to have sufficient flexi-

bility by reason of the materials employed and the thinness of the cylinder to permit of its being bent without injury to the record into the form of a flat sheet or a reversed cylinder. If bent around a cylinder it will be secured to the same by cement, and if bent into a flat sheet it will likewise be secured to a suitable bed-plate, the cylinder or bed-plate giving the necessary strength to the record. The duplicate phonogram-blanks upon which I impress the original record by means of the knurl are preferably of a wax composition, which is too hard to be practically indented directly in the phonograph, although softer compositions may be employed, or materials other than wax.

In the accompanying drawings, forming a part hereof, Figure 1 is a sectional view showing the original phonogram with the deposit thereon; Fig. 2, a similar view with the original phonogram melted out or removed from the encircling metal deposit. Fig. 3 is a sectional view illustrating the flat knurling-surface, and Fig. 4 a similar view illustrating the cylindrical knurling-surface.

A is the original wax phonogram, upon the surface of which is the phonographic record, upon which is formed a thin deposit of silver, *a*, and over this a thicker deposit of lead or tin, *b*, the entire metallic deposit being, for illustration, one-sixteenth of an inch thick. After this deposit is made the wax cylinder A is melted out of the metal coating, leaving the metallic cylinder B (shown in Fig. 2) with the record in relief upon its inner surface. This cylinder B is split longitudinally on one side at the point *c*, and it is then bent out flat and mounted upon a suitable base plate, C, to which it is secured by cement, forming a flat knurling-surface, D; or the cylinder B may be bent reversely over a solid cylinder, E, and secured thereto by cement, forming a cylindrical knurl, F. (Shown in Fig. 4.) The wax duplicate phonogram-blank G is impressed with the original record by rolling it against the flat or the cylindrical knurling surface, as will be readily understood.

I do not claim herein the method of duplicating phonograms by depositing metals upon a cylindrical wax phonogram and then melting or dissolving out the original wax phonogram, leaving a matrix with the record in relief upon its inner surface; neither do I claim

herein the use of a vacuum deposit for producing a coating upon the wax phonogram; neither do I claim herein a duplicate phonogram constructed of a hard material not capable of being satisfactorily indented by a phonograph, since these features are covered in my applications Nos. 743, 744, and 751, already filed by me. Such applications have respectively the Serial Nos. 259,895, 259,896, and 262,428.

What I claim as my invention is—

1. The process of duplicating phonograms, consisting in forming a knurl having the original record in relief by depositing metal upon the original record, removing the original phonogram and opening the metallic coating, and then impressing duplicate phonogram-blanks with the original record by means of such knurl, substantially as set forth.

2. The process of duplicating phonograms, consisting in depositing a flexible metallic coating upon an original cylindrical phonogram, removing the original phonogram from the inclosing-coating, splitting the inclosing-coating longitudinally, bending the same to form a knurl, and then impressing the duplicate phonogram-blanks with the original record by means of this knurl, substantially as set forth.

This specification signed and witnessed this 3d day of March, 1888.

THOS. A. EDISON.

Witnesses:

WM. PELZER,  
E. C. ROWLAND.