

G. H. FULLER.
Manufacture of Jewelry.

No. 215,113.

Patented May 6, 1879.



FIG. 1.

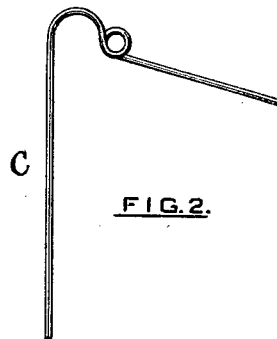


FIG. 2.

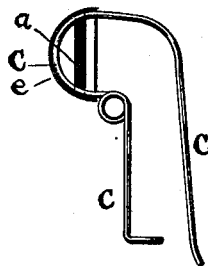


FIG. 4.



FIG. 3.

WITNESSES.

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UNITED STATES PATENT OFFICE.

GEORGE H. FULLER, OF PAWTUCKET, RHODE ISLAND.

IMPROVEMENT IN THE MANUFACTURE OF JEWELRY.

Specification forming part of Letters Patent No. **215,113**, dated May 6, 1879; application filed February 20, 1879.

To all whom it may concern:

Be it known that I, GEORGE H. FULLER, of Pawtucket, in the county of Providence and State of Rhode Island, have invented a new and useful Improvement in the Manufacture of Jewelry, of which the following is a specification.

My said invention relates to an improvement in the manufacture of jewelry; and consists of an improved method for fastening the wire to the base of the ear-drop, breastpin, and all similar articles, where the base used is of a cup-shaped pattern.

The accompanying drawings are hereby made a part of this specification, similar letters of reference thereon indicating corresponding parts.

The old method was to bend the wire *c* to fit the interior of the cup *e*, and then to secure the two together by the common process of hard soldering. This has been found to be imperfect, because during the process of soldering the temper is so drawn from the wire that it becomes soft and yielding, and quite unfitted for constant wear.

To remedy these difficulties I have devised a new method for uniting the parts, substantially as follows: I fit the wire to the interior of the cup, as before; then, placing the cup in a die fitting closely enough to firmly support the sides of the cup, I put in the angular piece of solid metal shown at Figure 3 in said drawings, and, with a plunger of the same size as

the interior of the cup, I force home this piece of metal so strongly that its corners are crowded into the sides of the cup. The corners being so forced into the interior sides of the cup keeps the metallic plug firmly in place, and this, in turn, secures the wire in the cup in the strongest manner.

A round instead of an angular piece of metal might be used in substantially the same way, and with like results.

In the accompanying drawings, Fig. 1 represents the cup-shaped base above described. Fig. 2 shows the wire bent for insertion in the cup. Fig. 3 shows the metallic plug before mentioned; and Fig. 4 is a sectional view of the wire and base so secured together as aforesaid, by means of the firmly-inserted piece of metal, as seen at *a*.

By use of the means described the soldering process is entirely dispensed with, the temper of the wire remains intact, and there is a smooth and clean finish of all the parts.

I claim as my invention and desire to secure by Letters Patent—

The combination of the metallic plate *a* with the wire *c* and the cup-shaped base *e*, substantially in the manner and for the purposes set forth.

GEO. H. FULLER.

Witnesses:

THOS. P. BARNEFIELD,
JAMES B. FREEMAN.