

R. F. SIMMONS.
Watch-Chain Bar.

No. 215,250.

Patented May 13, 1879.

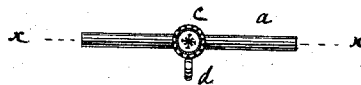


FIG. 1.



FIG. 2.



FIG. 4.



FIG. 5.



FIG. 6.



FIG. 7.



FIG. 3.

WITNESSES.

Shirley Carpenter
Eng'g R. Richardson

INVENTOR.

Robert F. Simmons

UNITED STATES PATENT OFFICE.

ROBERT F. SIMMONS, OF ATTLEBOROUGH, MASSACHUSETTS.

IMPROVEMENT IN WATCH-CHAIN BARS.

Specification forming part of Letters Patent No. **215,250**, dated May 13, 1879; application filed March 1, 1879.

To all whom it may concern:

Be it known that I, ROBERT F. SIMMONS, of Attleborough, in the State of Massachusetts, have invented a new and useful Improvement in Bars for Plated Watch-Chains, of which the following is a specification.

The improvement consists in making that part of the bar to which the chain is to be attached in the form of a cylinder, with its ends closed by engraved or chased disks, the cylinder being of plated metal and the disks of pure metal.

Similar cylinders with their ends closed by disks, or, in other words, similar boxes, have heretofore been used for tips for curb watch-chains made of plated metal. In such tips the disks have been made of pure gold, and have been engraved or chased; and since such ornamentation cannot successfully be given to plated metal, the little real gold present, being unmistakably recognized, has given to the tip and to the chain as a whole a genuine appearance.

I have substituted a similar box for the ordinary connection between the bar proper and the chain; and this new combination is of much greater value than the tip, for the bar of the chain is at all times a prominent feature of the chain as a whole, while the tip is not much seen.

In the drawings, Figure 1 is a view of a bar embracing my invention. Fig. 2 is a section

on line *xx* of Fig. 1. Fig. 3 is a view of the bar proper. Figs. 4 and 5 are views of the cylinder, and Figs. 6 and 7 are views of the disk.

The bar proper is marked *a*, the disks *b b*, the cylinder *c*, and *d* is a ring inserted in the cylinder, as shown, to which the chain is to be immediately attached.

The cylinder is made by drawing out a tube of plated metal in the ordinary manner, and cutting it off at required lengths. The disks are of pure metal, and are soldered to the cylinder, as shown. The bar is made of plated metal, in the ordinary way, and is secured by solder in holes bored in the cylinder for its reception, as shown. The disks are engraved or chased either before or after the parts are thus put together; or they may be left plain, for the edges of the disks being of pure gold, and the disks themselves hiding the edges of the plated cylinder, only gold is seen.

I claim—

As a new article of manufacture, a bar for a watch-chain, consisting of a bar proper combined with a cylinder of plated metal, the ends of which are closed by disks of pure metal, substantially as described.

ROBERT F. SIMMONS.

Witnesses:

SHIRLEY CARPENTER,
EUGENE R. RICHARDSON.