(No Model.)

L. TOWNE.

ORNAMENTAL CHAIN BAR.

No. 454,629. Patented June 23, 1891.

Fig. 1.

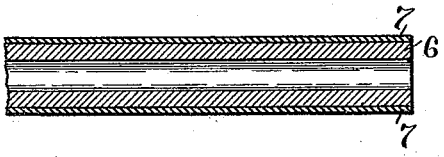


Fig. 2.

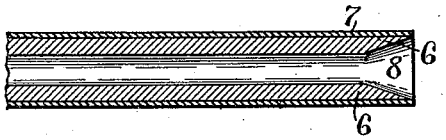


Fig. 3.

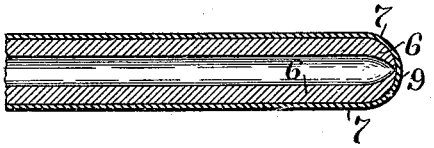
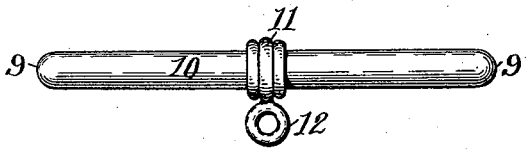


Fig. 4.



WITNESSES:

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UNITED STATES PATENT OFFICE.

LAURISTON TOWNE, OF PROVIDENCE, RHODE ISLAND.

ORNAMENTAL CHAIN-BAR.

SPECIFICATION forming part of Letters Patent No. 454,629, dated June 23, 1891.

Application filed November 5, 1890. Serial No. 370,368. (No model.)

To all whom it may concern:

Be it known that I, LAURISTON TOWNE, of Providence, in the county of Providence and State of Rhode Island, have invented a new and useful Improvement in Ornamental Chain-Bars; and I hereby declare that the following is a full, clear, and exact description of the same, reference being had to the accompanying drawings, forming part of this specification.

This invention has reference to an improvement in the construction of the chain-bars usually secured to the ends of watch-chains; and it consists in the peculiar and novel construction by which the same are formed of tubular plated wire, so that the whole outer surface of the bars is covered by the precious metal. Chain-bars consisting of a cylindrical bar having rounded ends are a very desirable form of watch-chain bar, presenting no corners. They are convenient in use and they are sold in large quantities. Such chain-bars are made of brass and are then plated with precious metal. One mode consists in covering the brass bar with drawn tubular caps having rounded ends made of a thin sheet of precious metal and secured to the brass rod or core by solder.

The object of my invention is to produce such chain-bars of the plated tubular wire of commerce, and to this purpose I prepare the ends of the tubular wire and then close the ends so that the precious metal will cover the ends of the bar.

Figure 1 is a longitudinal section of a piece of plated tubular wire as manufactured and sold to the jewelers' trade. Fig. 2 is a longitudinal section of a piece of plated tubular wire, one end of which is prepared for closing the end. Fig. 3 is a longitudinal section of part of a chain-bar made of plated tubular wire in accordance with my invention. Fig. 4 is a side view of a finished chain-bar.

In the drawings the number 6 indicates the walls of the tubular wire, made of any suitable inferior metal, usually brass.

7 indicates the plating of the tubular wire, usually of gold or silver or of an alloy containing a large percentage of precious metal.

The number 8 indicates the capped end of the bar, formed by cutting away the walls 6 of inferior metal, so as to form a funnel-shaped cup. The so-prepared end of the bar is now closed by spinning, burnishing, or forcing the thin edges of the end toward the center and closing the precious metal over the end, thus forming the rounded end 9 at each end of the bar. The whole surface of the bar 10 is covered with precious metal. The swivel 11, having the connecting-ring 12, is now secured to the bar in the usual manner. A tubular chain-bar thus formed has the advantage of having all parts covered with precious metal without seam or joint, and without any solder that will be exposed in time or by the acid test. Such a tubular bar is lighter than a solid bar, and at the same time is more rigid and less liable to be bent than a solid bar.

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

A chain-bar consisting of an interior body of inferior metal covered with a tube of precious metal, both ends of the tube being closed so as to cover the inferior metal, as described.

LAURISTON TOWNE.

Witnesses:
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