

# MOSELEY STAKING TOOL

WITH ATTACHMENT, ALSO A  
FRICTION JEWELING TOOL



- Inside Box — without  
Jewelry Attachment
- Outside Box — with  
Jewelry Attachment

PUNCHES SUPPLIED WITH WATCH-  
CRAFT AND MOSELEY STAKING  
TOOLS ARE LISTED Pgs. 8-12

## READ THE FOLLOWING CAREFULLY

IT WILL HELP YOU UNDERSTAND AND  
APPRECIATE THIS TOOL

**THE MOSELEY** is designed so all punches can be reversed and inserted in frames and used as stumps. Cast in one piece, the frame is relieved so punches can be easily inserted and removed. . . . also any parts driven out through die plate drop clear of frame. The punch guide is equipped with a friction sleeve which holds punches in any position.

**THE DIE PLATE** which is easily locked into position, is made of THE TOUGHEST ALLOY STEEL KNOWN TO SCIENCE AND CORRECTLY HARDENED TO GIVE MANY YEARS OF SERVICE. It has TWENTY-SIX HOLES, the smallest being .010 which will accommodate the smallest modern watches. Available in 7 different punch, stump and jewelry attachment combinations, as follows:

120 Punches— 25 Stumps	*Friction Jewelry Attachment	No. 42717
100 Punches— 25 Stumps	*Friction Jewelry Attachment	No. 42716
80 Punches— 20 Stumps	*Friction Jewelry Attachment	No. 42715
120 Punches—25 Stumps		No. 42714
100 Punches—25 Stumps		No. 42713
80 Punches—20 Stumps		No. 42712

\*Friction Jewelry Attachment only, for Moseley Staking Tool, consisting of:

Attachment	12 Pushers	
12 Reamers	1 Reamer Holder	
	1 Ball Miller	No. 42718

**ALL TOOLS** are cased in a mahogany finished wood case. All cases are drilled for 120 punches and 30 stumps, regardless of the size purchased, making it possible for you to add punches and stumps to the smaller sets at any time.

## EXCLUSIVE FEATURE!

Punches supplied with WATCH-CRAFT and MOSELEY Staking Tools are numbered with a letter prefixing the number. This letter indicates the style of punch, the number indicates the size in that style. This system is of great assistance to the watchmaker in selecting punches. For instance, if a punch number B22, which is a round faced hole punch, is used to spread the shoulder of a balance staff, the companion punch for riveting the same staff is number A22, a flat faced punch, found in the same relative position on the opposite side of the case. This system, found only in WATCH-CRAFT and MOSELEY Staking Tools, eliminates tedious searching for the companion punch each time.

**C. & E. MARSHALL CO.**  
CHICAGO AND PRINCIPAL CITIES

# THE FOLLOWING INSTRUCTIONS ARE FOR BOTH WATCH-CRAFT AND MOSELEY JEWELING TOOL

## How to Use the Reamers

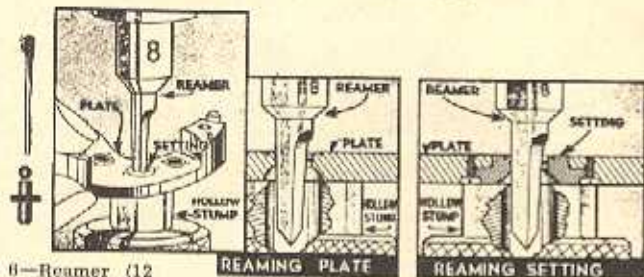


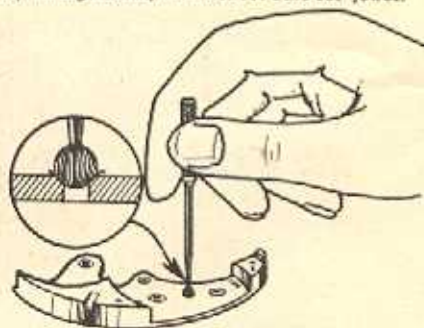
Fig. 6—Reamer (12 included) for making proper size holes in watch plates or settings, into which jewels are inserted.

1. Remove broken jewel from plate or setting.
2. Select reamer that will enlarge present hole very slightly. Do not use larger reamer than necessary.
3. Place reamer in holder as in Figure 6.

### Holder for Reamers.

1. Select smallest Hollow Stump that will accommodate reamer and place it in frame.
2. Hold plate or bridge in position on Hollow Stump.
3. Insert Holder with Reamer into jewelring tool as shown in illustration. Then, grasp knurled handle of reamer holder and ream out setting or plate, **RUNNING REAMER COMPLETELY THROUGH plate or setting UP TO SHOULDER OF REAMER.** Reamers are precision tools, self-centering, and will cut a perfectly straight hole, the correct size for jewel.

If a FRICTION jewel has been used previously, it may not be necessary to ream out hole. Instead, reamer should be used as gauge to determine size of hole in order to select proper size of friction jewel. (The old jewel first having been forced out with a pusher.) For example, if a No. 6 reamer fits the old hole perfectly, a No. 5 diameter jewel would be used.



**NOTE:** Plates or Bridges can be held with fingers while reaming. Settings too small to hold securely in fingers should be reamed out while in plate or bridge. If setting fits loosely so it revolves when reamer is turned, it should be "spread" slightly so it will be held friction tight in plate or bridge, and then reamed out.

A ball countersink is included with outfit for purpose of smoothing edges of hole in plate or setting. Use it very sparingly as its purpose is NOT to bevel edges, but merely to remove any rough or sharp burrs that may remain after reaming.

"Spreading" is accomplished by striking lightly with flat-faced punch or staking tool . . . Spread setting is then forced back into hole in bridge or plate with jewelring Tool, in same manner that jewels are pressed to place. It can then be reamed out without difficulty. Another method of reaming setting that is not tight in plate or bridge is to chuck setting in a wire chuck in your lathe, put reamer in a chuck holder placed in the lathe stock, and ream out the setting.

## How to Set Friction Jewels

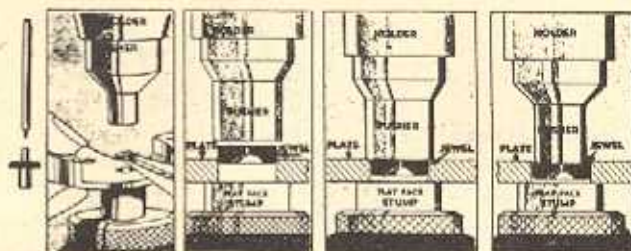


Fig. 2 Fig. 3 Fig. 4 Fig. 5

Fig. 1—Pusher (12 included) used for pressing jewels into holes made by reamers.

### Pusher

1. Select Flat-Faced Stump that will fit recess in watch plate where jewel is to be set. Place stump in jewelring tool.
2. Select L no. punch or pusher slightly larger than reamed-out hole, which is to receive jewel, and place in frame.
3. Place Plate or Bridge on Flat-Faced stump, with inside of plate facing up.
4. Place jewel in reamed-out hole, with oil cup facing down. (See Figs. 2 and 3.)
5. Press on handle of jewelring tool, to gently but firmly force jewel into reamed-out hole, flush with surface of plate or setting. (See Fig. 4.) Settings should be in plate or bridge while jewels are being pressed into them.
6. End-shake should now be examined and if more end-shake is required, jewel can be pressed below flush with pusher slightly smaller than jewel. (See Fig. 5.)

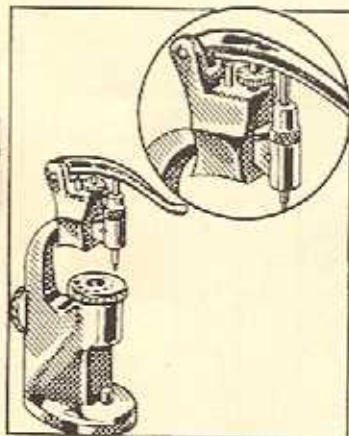
Plate or Center jewels are pressed into plate or setting from INSIDE. Using a larger pusher than hole into which jewel is to go automatically causes jewel to set flush with plate, since pusher can drive it no farther than surface of plate. Balance Hole jewels, in order to be in proper position for Cup Jewels, should be pressed in from the OUTSIDE of Balance Bridge.

### IMPORTANT

The proper depth to which jewel is to be set can be determined before broken jewel is removed and the depth adjustment screw set. MICROMETER depth adjusting screw is also used when it is necessary to increase end-shake after jewel has been set flush as in Fig. 4 and also in Fig. 5.

### NOTE

Watch-Craft Friction Jewels are accurately sized to fit the holes made by the reamers. The reamers are numbered to correspond with the jewel diameter in the Watch-Craft Friction Jewel System. No need to gauge jewel diameters. Write for further details on the system.



Punches Supplied With Each Size Staking Tool Are Indicated by †  
in Column Under Each Size Tool

(All Measurements Are in Millimeters)

**Flat Faced  
Hollow  
Punch**

No.	Hole Diam.	Punches Supplied With Each Size Staking Tool					† Price
		Watch-Craft 133 Puncher 25 Stumps	120 Puncher 25 Stumps	100 Puncher 25 Stumps	80 Puncher 20 Stumps	60 Puncher 18 Stumps	
A1	2.56						
A2	2.35	†	†	†	†	†	
A3	2.18	†	†	†	†	†	
A4	2.05	†	†	†	†	†	
A5	1.97	†	†	†	†	†	
A6	1.85	†	†	†	†	†	
A7	1.70	†	†	†	†	†	
A8	1.60	†	†	†	†	†	
A9	1.49	†	†	†	†	†	
A10	1.39	†	†	†	†	†	
A11	1.32	†	†	†	†	†	
A12	1.25	†	†	†	†	†	
A13	1.16	†	†	†	†	†	
A14	1.06	†	†	†	†	†	
A15	.99	†	†	†	†	†	
A16	.91	†	†	†	†	†	
A17	.84	†	†	†	†	†	
A18	.79	†	†	†	†	†	
A19	.74	†	†	†	†	†	
A20	.69	†	†	†	†	†	
A21	.66	†	†	†	†	†	
A22	.63	†	†	†	†	†	
A23	.61	†	†	†	†	†	
A24	.56	†	†	†	†	†	
A25	.53	†	†	†	†	†	
A26	.51	†	†	†	†	†	
A27	.46	†	†	†	†	†	
A28	.41	†	†	†	†	†	
A29	.37	†	†	†	†	†	
A30	.31	†	†	†	†	†	
A31	.25	†	†	†	†	†	
A32	.20	†	†	†	†	†	
A33	.14	†	†	†	†	†	
A34	.13	†	†	†	†	†	

† Prices upon request.

Punches Supplied With Each Size Staking Tool Are Indicated by †  
in Column Under Each Size Tool

(All Measurements Are in Millimeters)

**Round Faced  
Hollow  
Punch**

No.	Hole Diam.	Punches Supplied With Each Size Staking Tool					† Price
		Watch-Craft 133 Puncher 25 Stumps	120 Puncher 25 Stumps	100 Puncher 25 Stumps	80 Puncher 20 Stumps	60 Puncher 18 Stumps	
B1	2.56						
B2	2.35	†	†	†	†	†	
B3	2.18	†	†	†	†	†	
B4	2.05	†	†	†	†	†	
B5	1.97	†	†	†	†	†	
B6	1.85	†	†	†	†	†	
B7	1.70	†	†	†	†	†	
B8	1.60	†	†	†	†	†	
B9	1.49	†	†	†	†	†	
B10	1.39	†	†	†	†	†	
B11	1.32	†	†	†	†	†	
B12	1.25	†	†	†	†	†	
B13	1.16	†	†	†	†	†	
B14	1.06	†	†	†	†	†	
B15	.99	†	†	†	†	†	
B16	.91	†	†	†	†	†	
B17	.84	†	†	†	†	†	
B18	.79	†	†	†	†	†	
B19	.74	†	†	†	†	†	
B20	.69	†	†	†	†	†	
B21	.66	†	†	†	†	†	
B22	.63	†	†	†	†	†	
B23	.61	†	†	†	†	†	
B24	.56	†	†	†	†	†	
B25	.53	†	†	†	†	†	
B26	.51	†	†	†	†	†	
B27	.46	†	†	†	†	†	
B28	.41	†	†	†	†	†	
B29	.37	†	†	†	†	†	
B30	.31	†	†	†	†	†	
B31	.25	†	†	†	†	†	
B32	.20	†	†	†	†	†	
B33	.14	†	†	†	†	†	
B34	.13	†	†	†	†	†	

† Prices upon request.

Punches Supplied With Each Size Staking Tool Are Indicated by †  
in Column Under Each Size Tool

(All Measurements Are in Millimeters)

### Flat Faced Solid Punch

No.	End Diam.	133 Punches Watch-Craft 25 Stumps	120 Punches 25 Stumps	100 Punches 25 Stumps	80 Punches 25 Stumps	60 Punches 20 Stumps	40 Punches 18 Stumps	† Price
C1	4.26	†	†	†	†	†		
C2	3.50	†	†	†	†	†		
C3	2.90	†	†	†	†	†		
C4	2.48	†	†	†	†	†		
C5	2.05	†	†	†	†	†		
C6	1.67	†	†	†	†	†		
C7	1.40	†	†	†	†	†		
C8	1.07	†	†	†	†	†		
C9	.81	†	†	†	†	†		

### Round Faced Solid Punch

No.	End Diam.	133 Punches Watch-Craft 25 Stumps	120 Punches 25 Stumps	100 Punches 25 Stumps	80 Punches 25 Stumps	60 Punches 20 Stumps	40 Punches 18 Stumps	† Price
D1	4.26	†	†	†	†	†		
D2	3.50	†	†	†	†	†		
D3	2.90	†	†	†	†	†		
D4	2.48	†	†	†	†	†		
D5	2.05	†	†	†	†	†		
D6	1.67	†	†	†	†	†		
D7	1.40	†	†	†	†	†		
D8	1.07	†	†	†	†	†		
D9	.81	†	†	†	†	†		

### Taper Mouth Closing Punch

No.	Hole Diam.	133 Punches Watch-Craft 25 Stumps	120 Punches 25 Stumps	100 Punches 25 Stumps	80 Punches 25 Stumps	60 Punches 20 Stumps	40 Punches 18 Stumps	† Price
E1	1.70	†	†	†	†	†		
E2	1.02	†	†	†	†	†		
E3	.97	†	†	†	†	†		
E4	.94	†	†	†	†	†		
E5	.79	†	†	†	†	†		
E6	.74	†	†	†	†	†		
E7	.61	†	†	†	†	†		
E8	.51	†	†	†	†	†		
E9	.41	†	†	†	†	†		

### Double Roller Punch

No.	Hole Diam.	133 Punches Watch-Craft 25 Stumps	120 Punches 25 Stumps	100 Punches 25 Stumps	80 Punches 25 Stumps	60 Punches 20 Stumps	40 Punches 18 Stumps	† Price
F1	1.99	†	†	†	†	†		
F2	1.51	†	†	†	†	†		
F3	1.07	†	†	†	†	†		
F4	.89	†	†	†	†	†		

† Prices upon request.

Punches Supplied With Each Size Staking Tool Are Indicated by  
in Column Under Each Size Tool

(All Measurements Are in Millimeters)

### Roller Staking Punch

No.	Hole Diam.	133 Punches Watch-Craft 25 Stumps	120 Punches 25 Stumps	100 Punches 25 Stumps	80 Punches 20 Stumps	60 Punches 18 Stumps	† Price
G1	1.32	†	†	†	†	†	
G2	1.01	†	†	†	†	†	
G3	.79	†	†	†	†	†	
G4	.61	†	†	†	†	†	

### COLLETS CLOSING PUNCH

H1	1.49	†	†	†	†	†	
H2	1.32	†	†	†	†	†	

### SCREW KNOCKING PUNCH

I1	.64	†	†	†	†	†	
I2	1.07	†	†	†	†	†	
I3	1.32	†	†	†	†	†	
I4	1.58	†	†	†	†	†	

### DRIVING OUT WAL. FRICTION STAFF

J1	.31	†	†	†	†	†	
J2	.20	†	†	†	†	†	
J3	.17	†	†	†	†	†	
J4	.14	†	†	†	†	†	
J5	.13	†	†	†	†	†	
J6	.13	†	†	†	†	†	

### DRIVING IN WAL. FRICTION STAFF

K1	.61	†	†	†	†	†	
K2	.58	†	†	†	†	†	
K3	.46	†	†	†	†	†	

### FRICTION JEWELING PUNCHES

No.	End Diam.	133 Punches Watch-Craft 25 Stumps	120 Punches 25 Stumps	100 Punches 25 Stumps	80 Punches 20 Stumps	60 Punches 18 Stumps	† Price
L1	.55	†					
L2	.65	†					
L3	.75	†					
L4	.85	†					
L5	.95	†					
L6	1.05	†					
L7	1.25	†					
L8	1.40	†					
L9	1.65	†					
L10	1.85	†					
L11	2.15	†					
L12	2.70	†					

† Prices upon request.

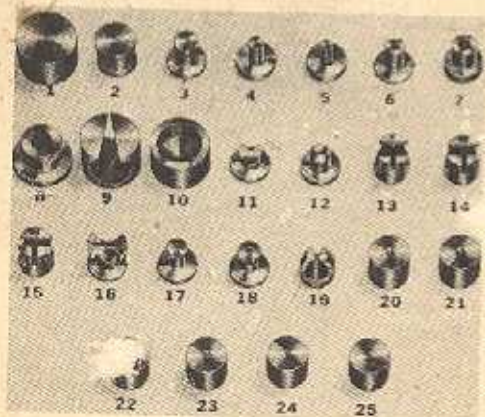
Punches Supplied With Each Size Staking Tool Are Indicated by † in Column Under Each Size Tool

### SPECIAL PUNCHES

(All Measurements Are in Millimeters)

No.		Watch-Craft 125 Punches 25 Stumps	120 Punches 25 Stumps	100 Punches 25 Stumps	80 Punches 20 Stumps	60 Punches 18 Stumps	Price
M1	Stretching						
M2	Roller Closing	†	†	†	†	†	.....
M3	Prick						.....
M4	Centering						.....
M5	Reamer Holder						.....
M6	Peen						.....

Stump No.	Diameter	Hole Size	Slot Width	Description
1	.54"			Solid Face
2	.54"			Solid Face
3	.155"			Solid Face
4	.093"			Solid Face
5	.063"			Solid Face
6	.120"	.052"		Solid Face
7	.157"	.070"		Hollow Face
8	.245"	.128"		Hollow Face
9				Hollow Face
10	.54"	.56"		Roller Removing Large
11				Large Hollow Face
12				Canon Pinion Tightening
13				Center Stump
14			.110"	Roller Removing
15			.081"	Roller Removing
16			.059"	Roller Removing
17	.136"	.035"	.028"	Pinset Fork
18	.128"	.028"		Roller Staking
19				Roller Staking
20	.54"	.037"		Roller Removing Small
21	.54"	.040"		Waltham Friction Staff
22	.54"	.056"		Waltham Friction Staff
24	.54"	.039"		Waltham Friction Staff
24	.54"	.039"		Waltham Friction Staff
24	.54"	.029"		Waltham Friction Staff
25	.54"	.024"		Waltham Friction Staff
				Straight Hole
				Straight Hole



† Prices upon request.

Illustration shows stumps supplied with WATCH-CRAFT and MOSELEY Staking Tools.

Manufactured in America  
by

**C. & E. MARSHALL CO.**

Box 7737

Chicago 80

# WATCH-CRAFT

U.S. PATENT OFFICE No. 148436

## TRI-DUTY STAKING TOOL

Combining in  
One Tool

1. STAKING TOOL
2. DRILL PRESS
3. FRICTION JEWELING TOOL



ALSO . . .

## MOSELEY Inversion STAKING TOOL

WITH ATTACHMENT  
ALSO A FRICTION JEWELING TOOL

Manufactured by

**C. & E. MARSHALL CO.**  
A GREATER VALUE — A GREATER SERVICE

BOX 7737

CHICAGO 80