

**Horologix**



The place to come for all your Bulle and Eureka restoration parts.

Contact Peter Smith  
Telephone 01454-880825  
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## Making a Eureka Bezel

*A sequence of photos showing the stages in machining a Eureka Bezel.*

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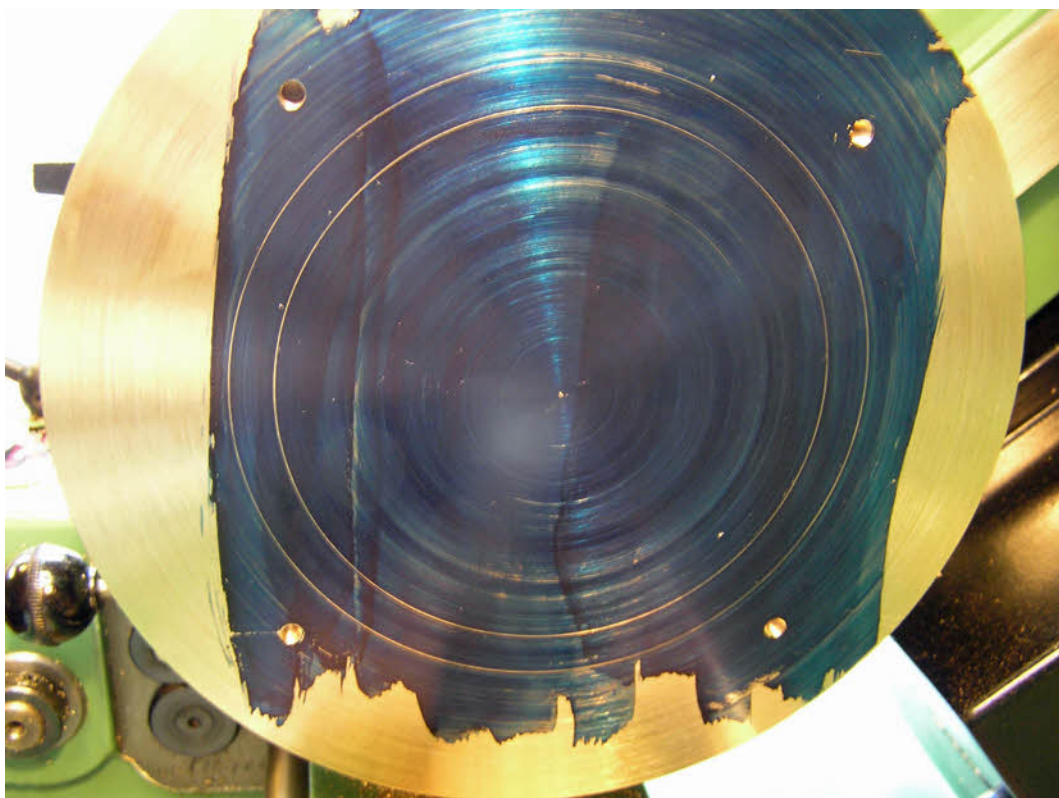


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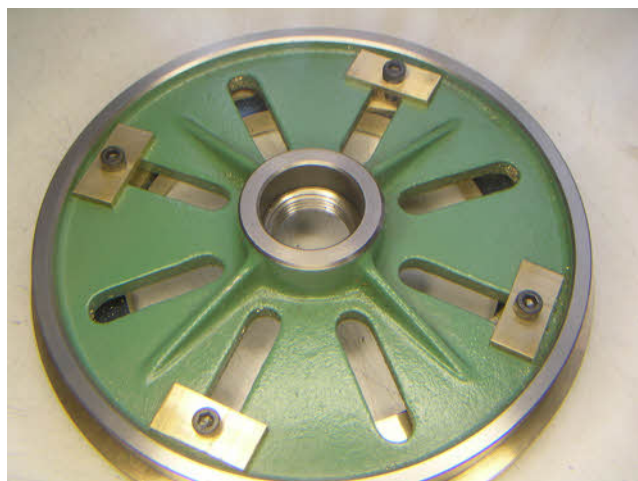
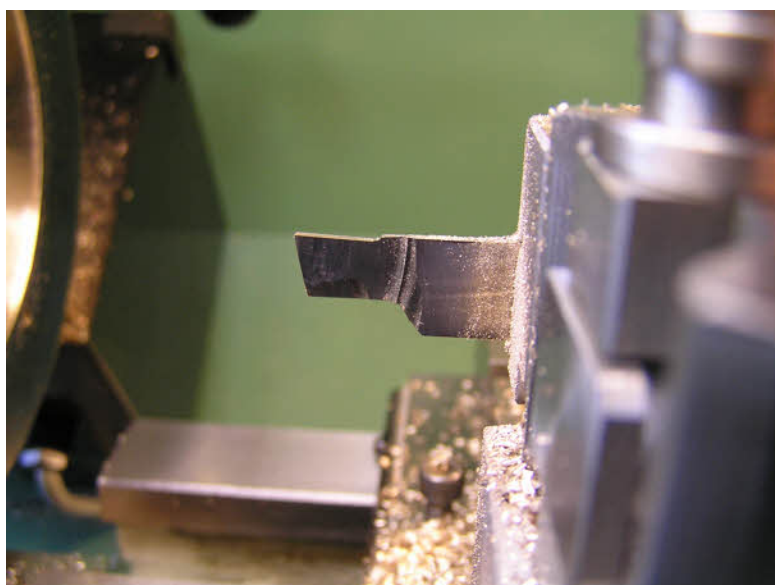
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## Making a Eureka Bezel

I had occasion to replace a spun bezel that was on a Eureka clock so I thought I would shoot a sequence of photos showing the process I used. This is the second time I have had to make one and I used the same process each time. It seems to work OK although it is rather expensive on brass. The first time I was able to order plate brass 1/2" thick. This time though I had couldn't get plate at a reasonable cost so I resorted to ordering a 1/2" cut off from 8" bar stock. It was still expensive at £65.00.



I mounted the bar using the face plate and four 6mm socket screws with brass washers. I then faced off the bar and marked out the overall dimensions of the bezel. The bezel I needed was 122mm outside diameter but not all Eureka clocks are the same. I then prepared a trepanning tool ground to make sure I could pass through the the complete 1/2".



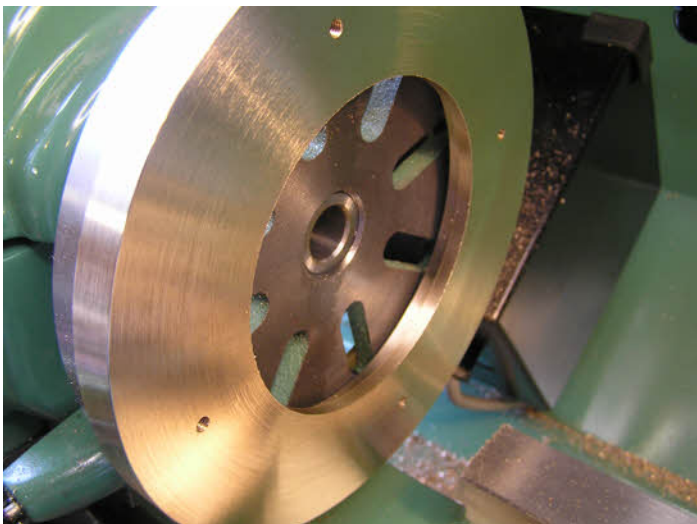
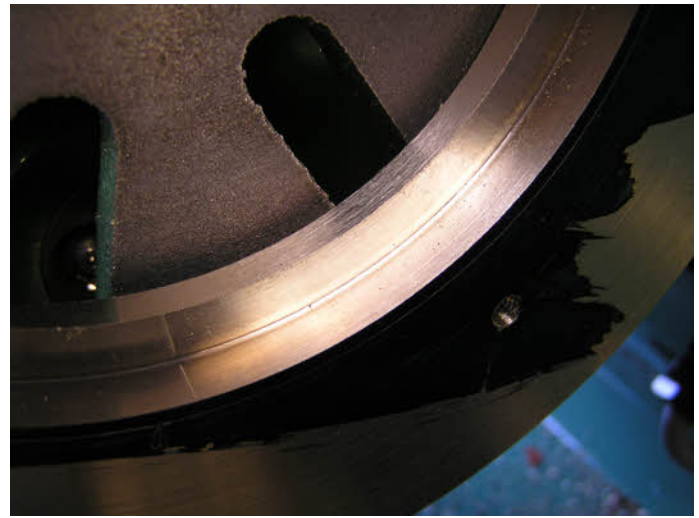
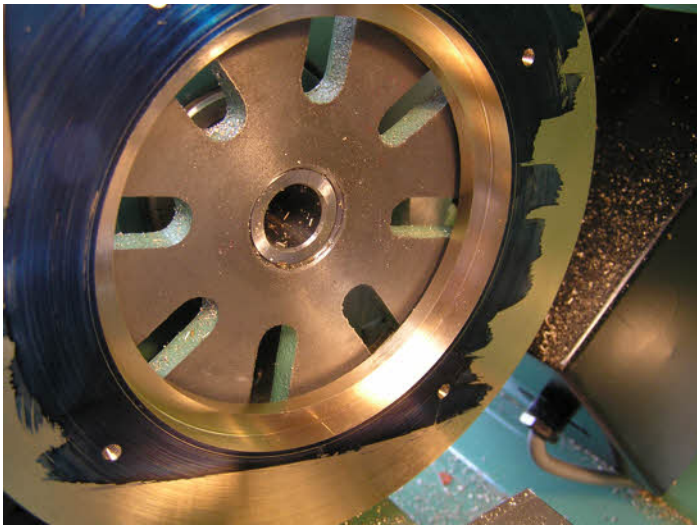
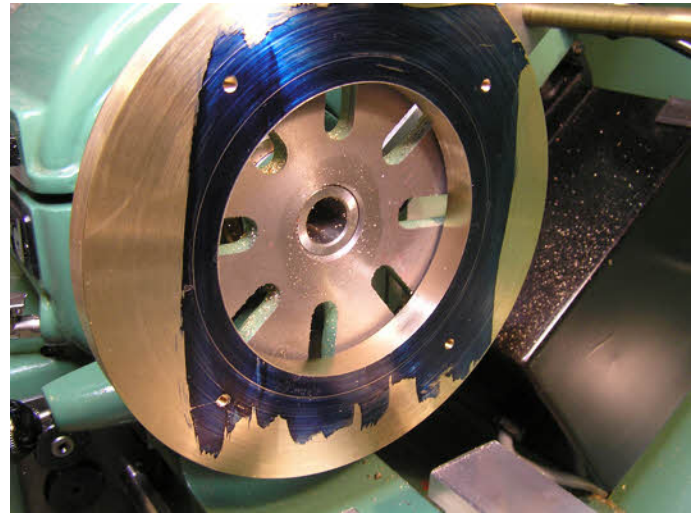
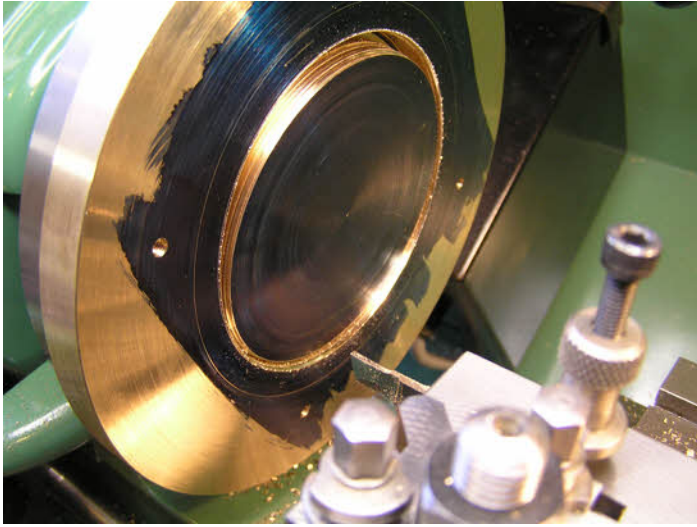
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*The trepanning went very well with no problems with chatter etc. I then marked out the width of the dial recess and machined to leave a good 2mm for the outside rim. The billet was then removed from the faceplate and reversed using the recess to centre carefully on the faceplate. I then faced off the reverse.*

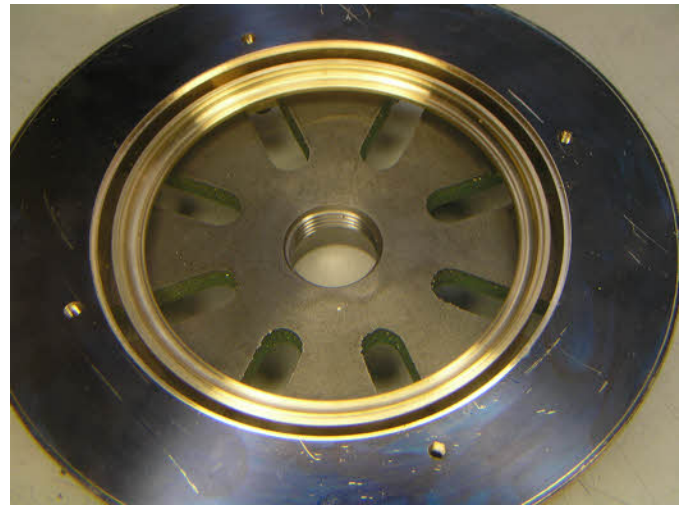
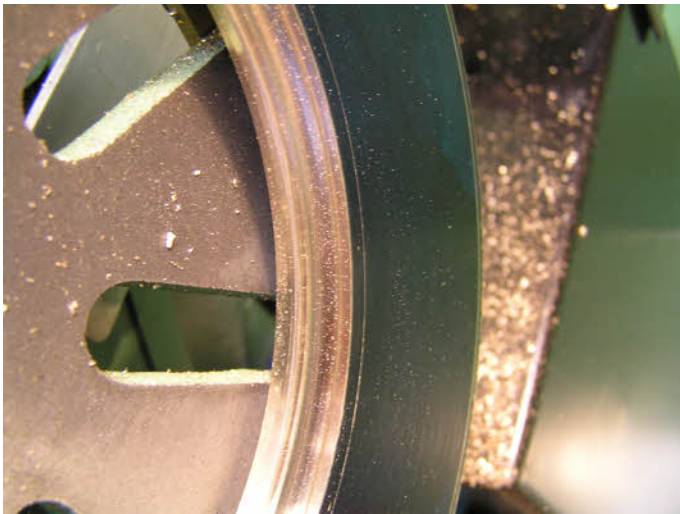
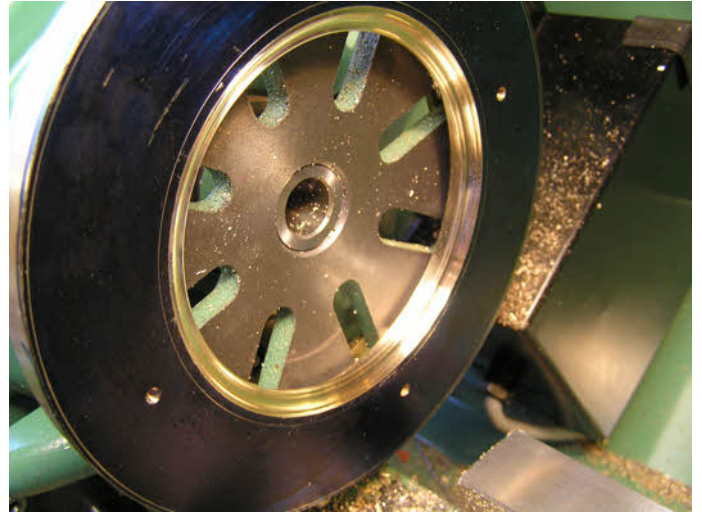
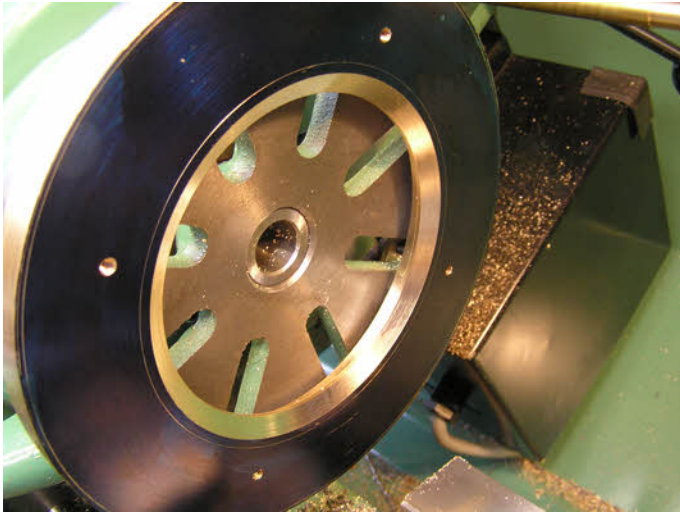
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*The face of the bezel was then machined at 45 degrees and two plunge cuts made at 90 degrees to the face with a 90 degree tool to form the two grooves. A large round nosed tool was then used to form the decorative concave design.*

*The bezel was then finally trepanned from the billet.*

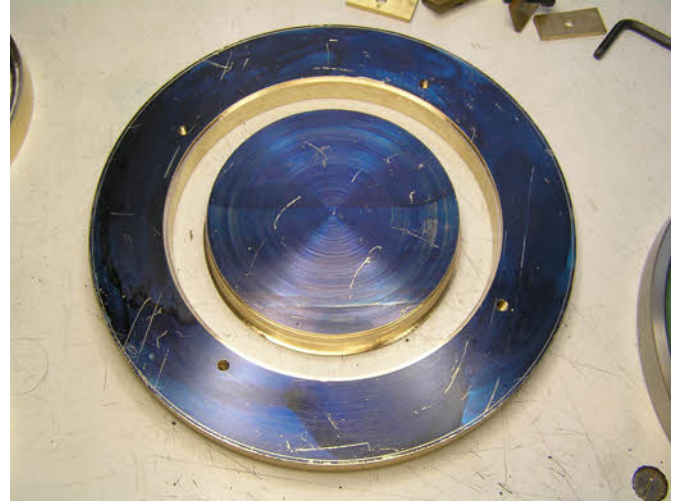
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*The bezel was then gently held in the three jaw chuck with jaws opened out to support the bezel on the inside of the recess. The outside of the bezel was then machined to its final diameter. I was a bit peeved at how much brass was left after the process. All that brass for such a small bezel.*

*It doesn't look too bad.*

