

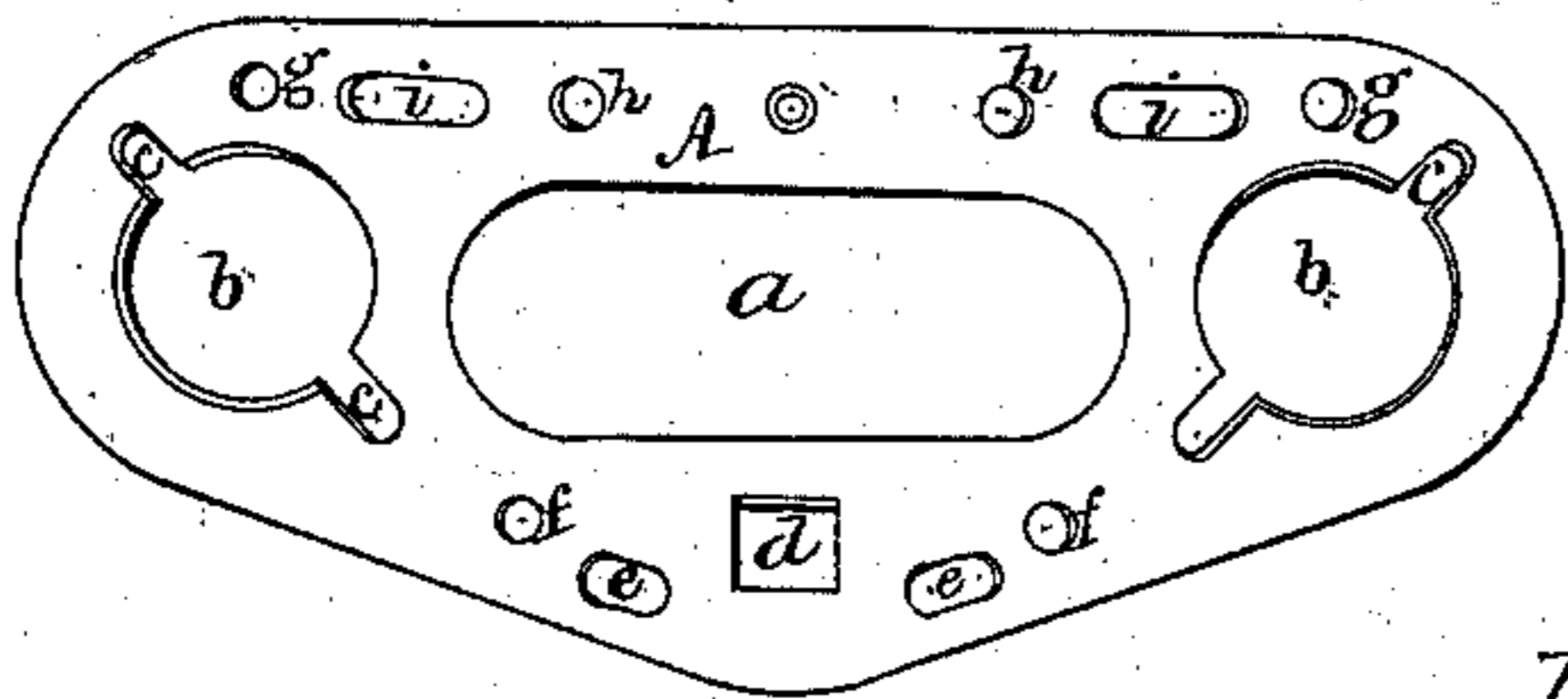
*R. Spencer,*

*Harness Saddle,*

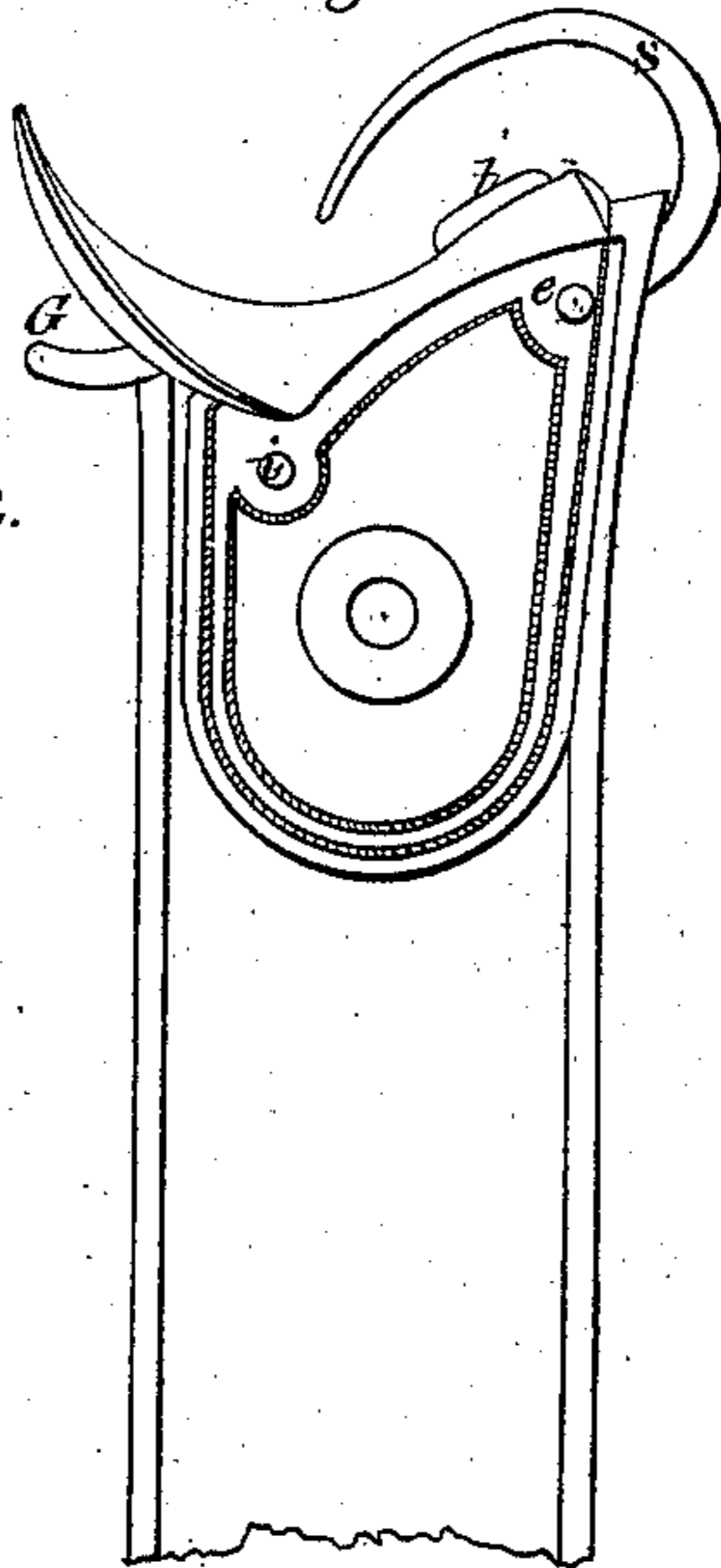
*Nº 11,573.*

*Patented Aug. 22, 1854*

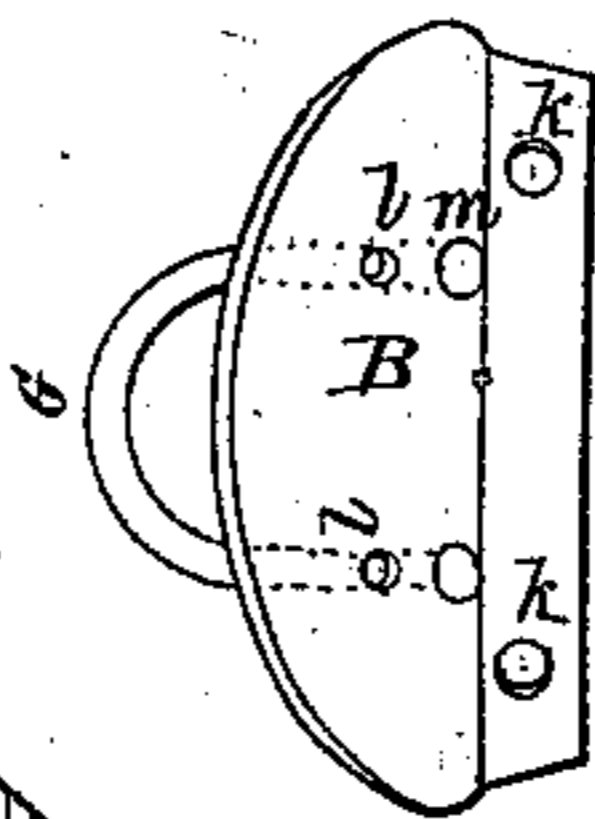
*Fig. 1.*



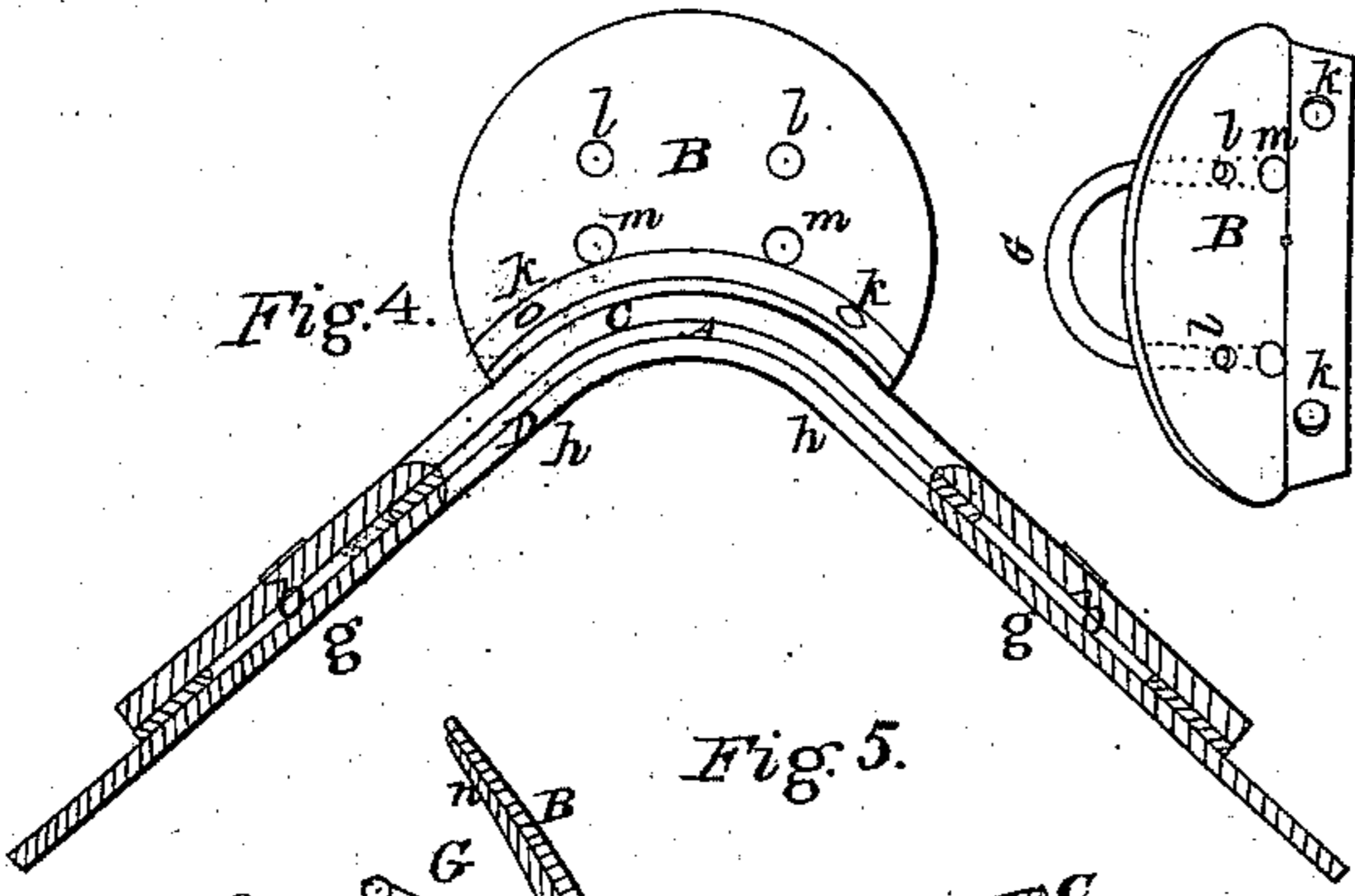
*Fig. 6.*



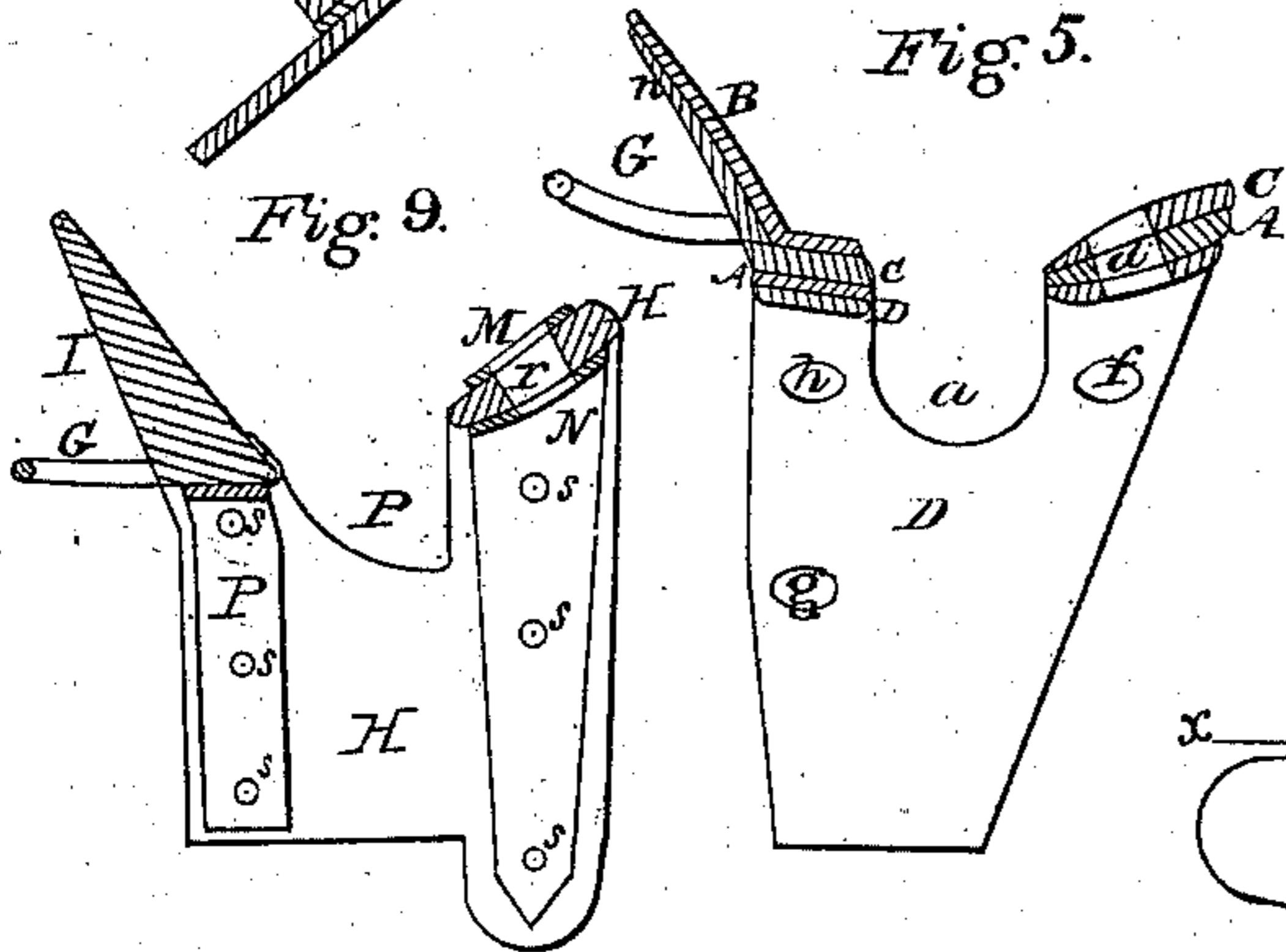
*Fig. 2.*



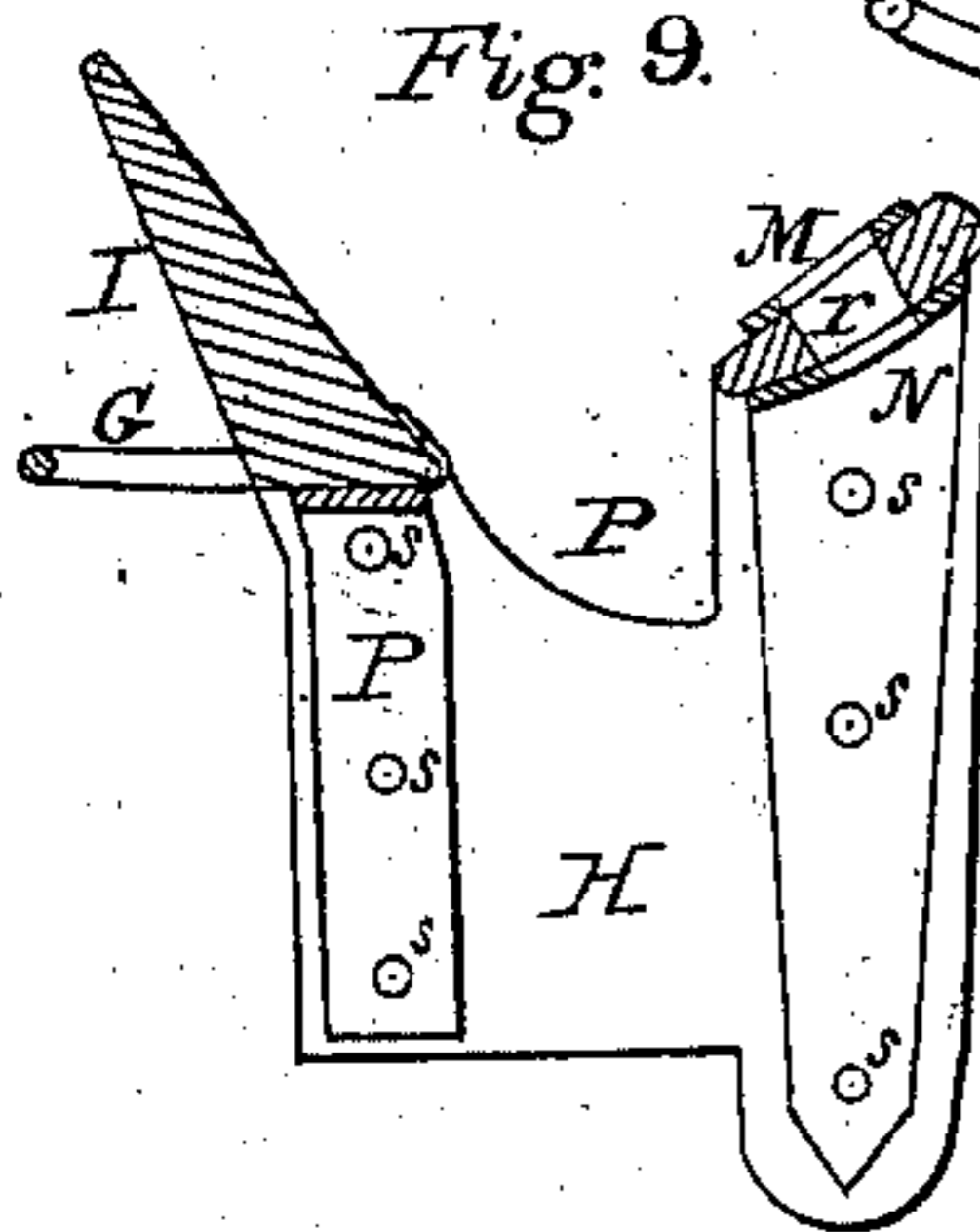
*Fig. 4.*



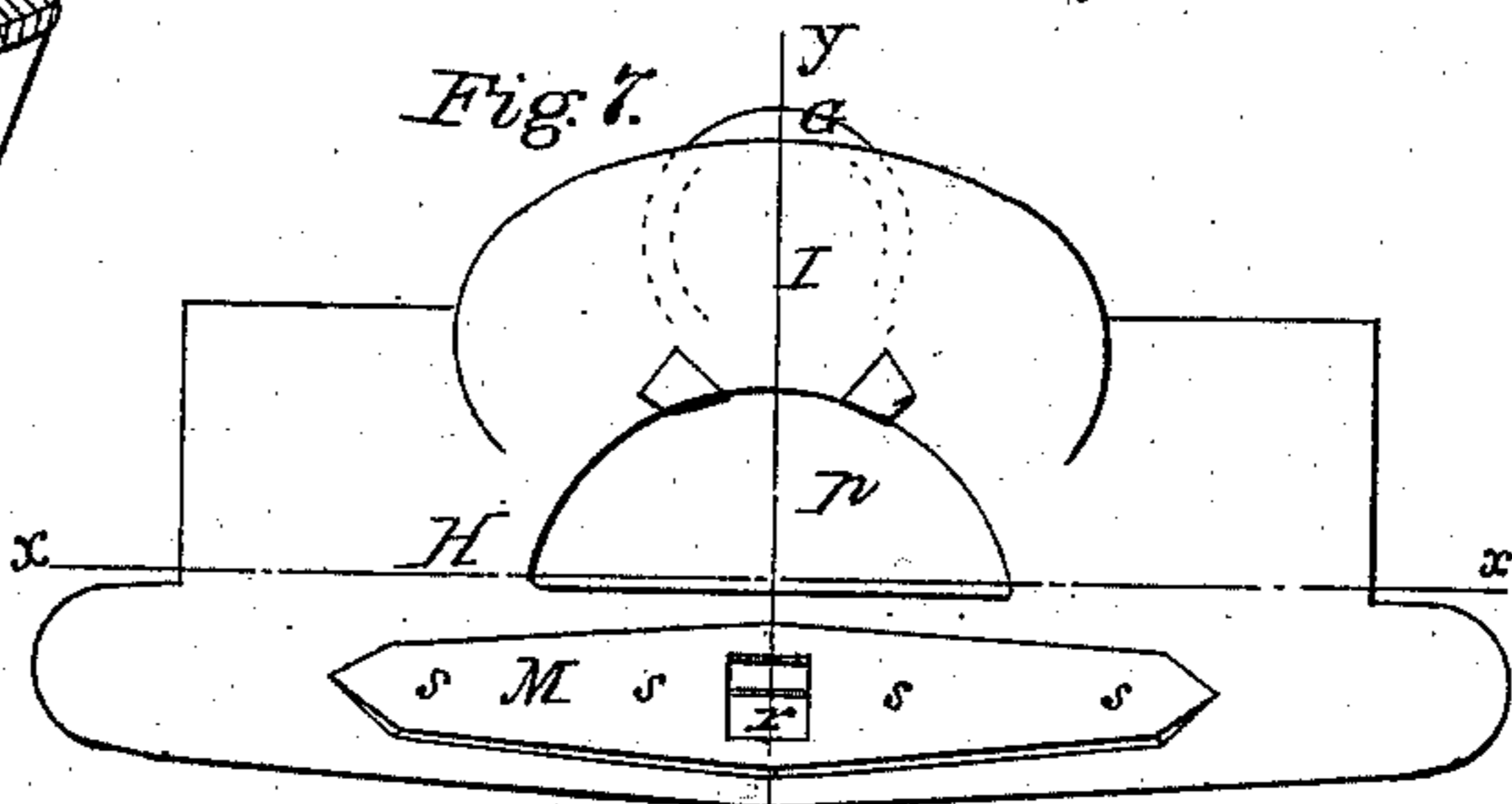
*Fig. 5.*



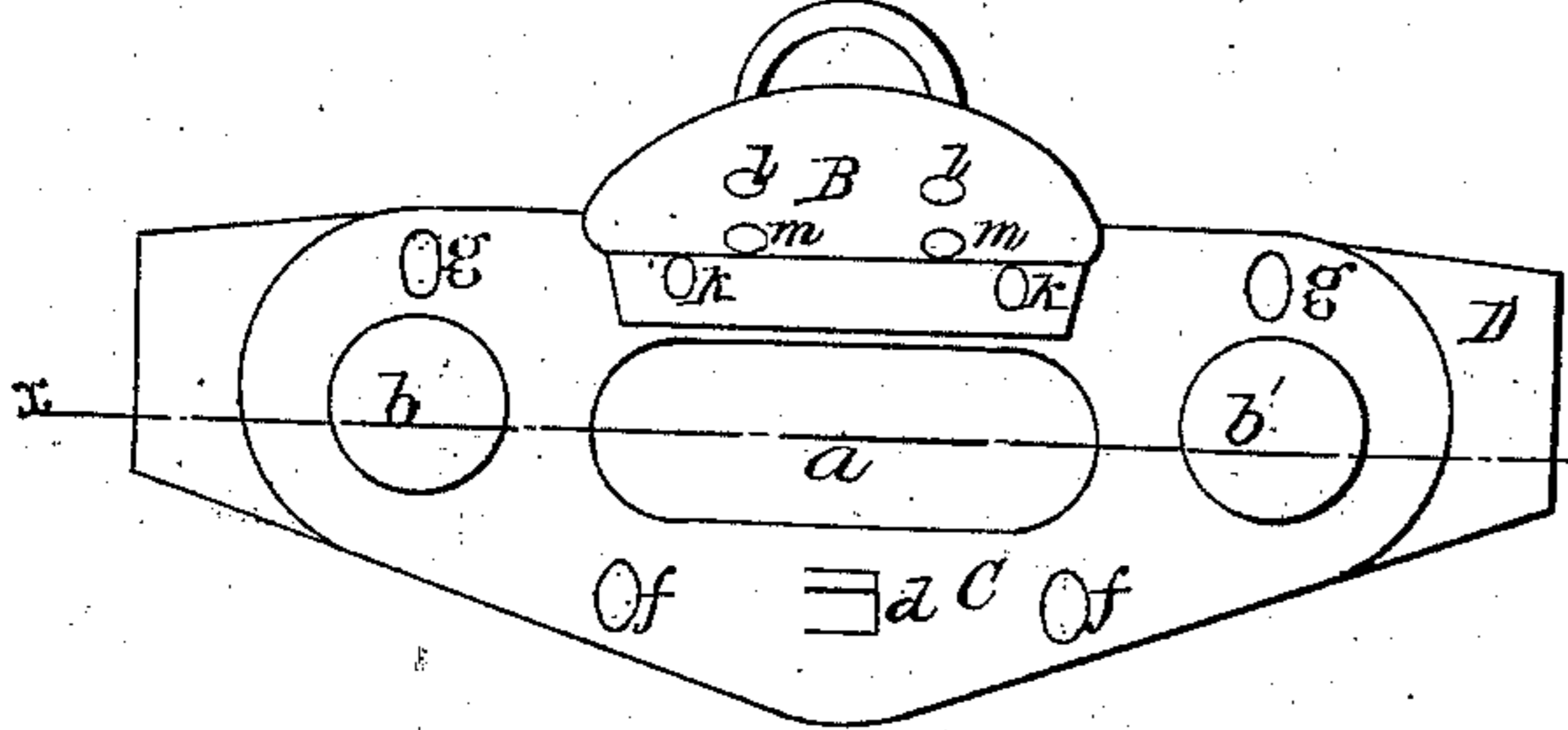
*Fig. 9.*



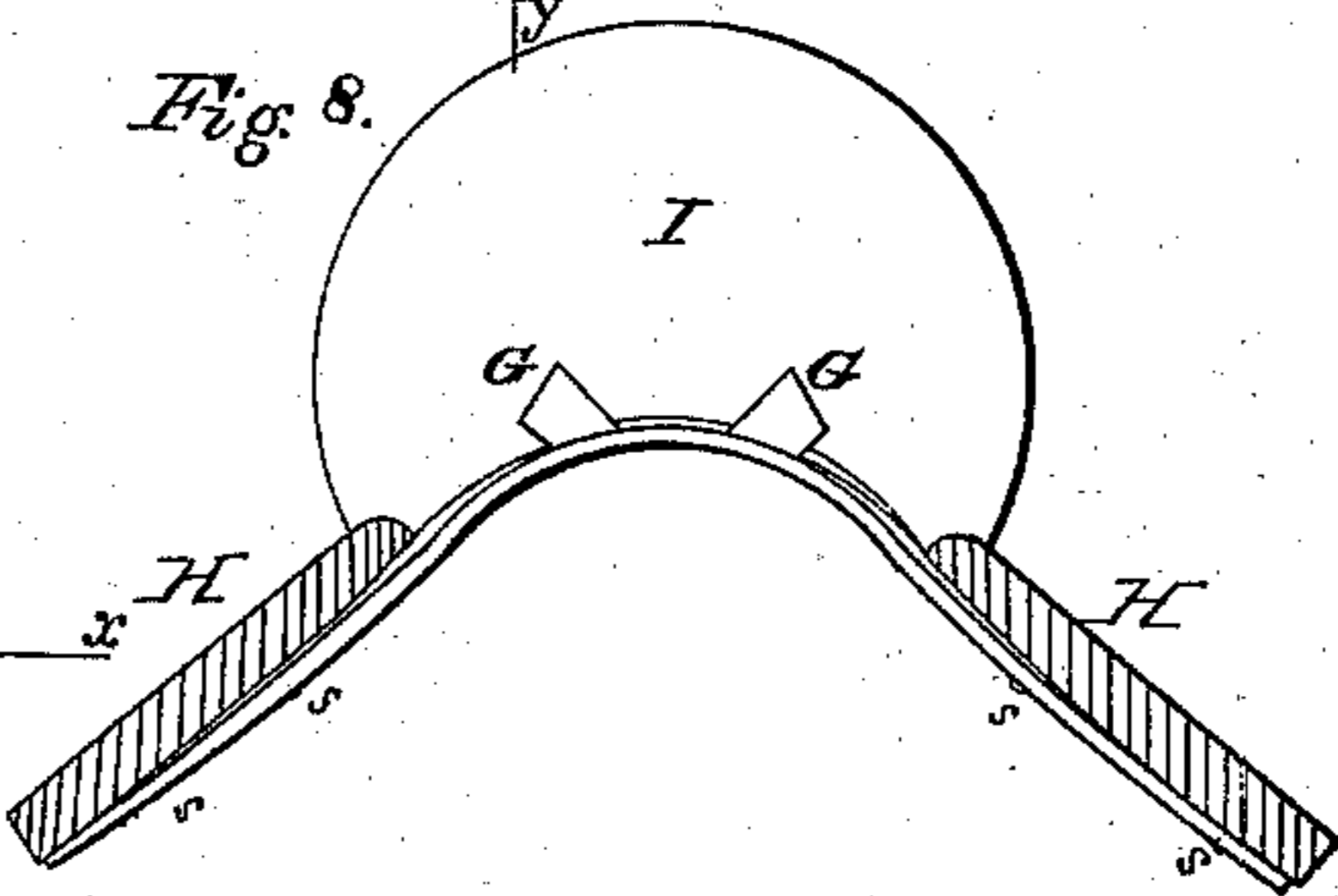
*Fig. 7.*



*Fig. 3.*



*Fig. 8.*



# UNITED STATES PATENT OFFICE.

ROBERT SPENCER, OF SOUTHPORT, CONNECTICUT.

## HARNESS-SADDLETREE.

Specification of Letters Patent No. 11,573, dated August 22, 1854.

*To all whom it may concern:*

Be it known that I, ROBERT SPENCER, of Southport, in the county of Fairfield and State of Connecticut, have invented a new and Improved Harness Saddletree; and I do hereby declare that the following is a full and exact description thereof, reference being had to the accompanying drawings, making part of this specification.

Figure 1, being a top view of a thin iron skeleton plate, which forms one part of my improved harness-saddletree; Fig. 2, a top view of the cantle, also made of iron cast in a separate piece; Fig. 3, a top view of the whole saddletree composed of the aforesaid cast-iron skeleton plate and cantle combined together and with two pieces of leather embracing the skeleton plate; Fig. 4, a section thereof in the line *x x* of Fig. 3; Fig. 5, a section of the same in line *y y* of Fig. 3; Fig. 6, a side view of a portion of a finished saddle made with my improved saddletree; Fig. 7, a top view of a harness-saddletree made in the ordinary manner; Fig. 8, a section thereof in the line *x x* of Fig. 7; Fig. 9, a section of the same in the line *y y* of Fig. 7.

Like letters designate corresponding parts in all the figures.

Harness saddletrees are usually made as represented in Figs. 7, 8, and 9, viz:—of a piece (or pieces glued together) of wood carved into the desired shape to form the skeleton H, and cantle I, and strengthened by metallic strips M, N, P, properly fitted thereto and secured by rivets *s*. There are several objections to these saddletrees; one of which is, that they require to be made so thick, to produce the necessary strength, that saddles of light and elegant form can not be made with them. This is especially the case with the cantle I, which is made thick and erect, as indicated in Fig. 9. Another objection to wooden saddletrees is, that they soon become more or less decayed by the perspiration and heat of the horses, so that they give way, or, at least, allow the nails and rivets which unite other parts to them, to pull out. Another objection is, a large demand can not be quickly supplied, because their manufacture is limited to the number which persons, skilled in the art of carving them, can make.

The nature of my invention consists in the production of a new and improved harness saddletree by the combination of

pieces of iron and leather substantially as hereinafter set forth.

The skeleton plate A, is made of thin malleable cast-iron, of the required shape. It is provided with the usual aperture *a*, in the central portion; and with a sufficient number of holes and apertures, as seen in Fig. 1, for uniting with each other the respective parts of the saddletree; and also for attaching to the finished tree, the respective parts of the saddle. Thus *b, b*, are terret holes, with notches *c, c*, on their opposite sides for the reception of nails or rivets to attach the nuts, into which the shanks of the terrets are screwed; *d*, is an aperture through which a bolt *t*, (Fig. 6,) passes, and secures the water-hook S, to the pommel; *f, f, g, g*, and *h, h*, are holes for the insertion of rivets, indicated by the same letters in Figs. 3, 4, and 5, to secure the parts of the saddletree together; *e, e*, and *i, i*, oblong apertures for receiving nails *e*, and *i*, (Fig. 6,) to secure the jockeys and skirts to the saddletree. Instead of cast-iron, sheet-iron swayed into the proper shape, might be used. The cantle B, is also made of iron cast in a separate piece of the proper shape, with holes *k, k*, through which the rivets *h, h*, (Figs. 3, 4, and 5,) pass and secure it to the other parts of the saddletree. It also has holes *l, l*, for attaching a piece of leather *n*, (Fig. 5,) behind it; and two other holes *m, m*, into which the crupper loop G, is riveted.

Two pieces of strong, thick leather C, D, of suitable size and shape to cover the skeleton plate A, are placed, one beneath and the other above said plate, and secured there by the aforesaid rivets *f, f, g, g*, and *h, h*, the latter of which also pass up through the holes *k, k*, in the cantle B, as above described, and secure it upon the upper piece of leather C, as represented in Figs. 3, 4, and 5.

My saddletree, constructed in the above described manner, possesses the especial advantages of superior strength, greater durability, small cost and great rapidity of manufacturing. The other parts of the saddle are also enabled to be secured upon it by stitching to the leather portion, or by rivets, or nails, so that any manner or style of mounting may be employed. Besides, it can be more readily shaped into the desired form, by trimming the leather por-

tion. And it particularly recommends itself on account of the great thinness of the material used, especially in the cantle B, which may also thereby recede backward 5 more than in the ordinary wooden saddletree, as may readily be seen by comparing Figs. 5, and 9, in the drawings. Hence, in the finished saddle, the form will appear much more light and elegant, as exemplified 10 in Fig. 6.

In Fig. 3,  $b'$ ,  $b'$ , on the upper leather portion C, of the tree, indicate the outlines of the holes  $b$ ,  $b$ , in the skeleton plate A, below the same; and serve as guides in making the 15 terret holes, previous to putting the parts of the saddle together.

In Fig. 6, the outer circle on the jockey, indicates the usual size of the base, and the inner circle the size of the shank, of the 20 terret, which is not represented.

I do not claim constructing the frame

and cantle of a harness saddletree, in separate pieces, nor the insertion of leather between them; but what I do claim as my invention and desire to secure by Letters 25 Patent, as a new article of manufacture, is—

My improved harness saddletree, constructed substantially as herein described of combined iron and leather; (or the 30 equivalent of leather;) the iron serving the purpose of a skeleton and giving it the proper rigidity, while by trimming the leather portions of the tree, the exact conformation is attained. 35

The above specification of my improved harness saddletree signed and witnessed this 22nd day of June 1854.

ROB. SPENCER.

Witnesses:

Z. C. ROBBINS,  
J. S. BROWN.