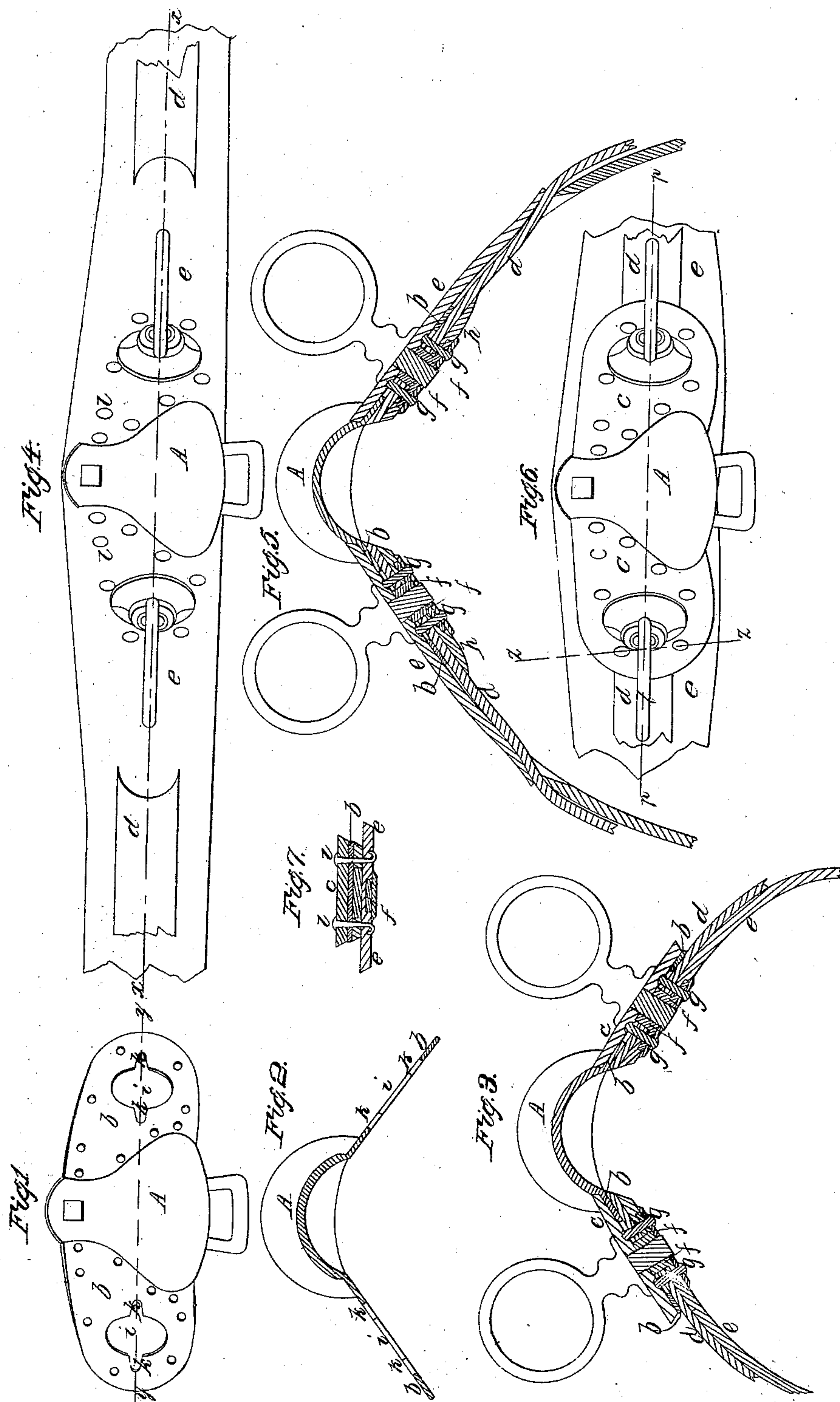


R. SPENCER.
HARNESS SADDLE.

No. 11,576.

Patented Aug. 22, 1854.



UNITED STATES PATENT OFFICE.

ROBERT SPENCER, OF NEW YORK, N. Y.

HARNESS-SADDLE.

Specification of Letters Patent No. 11,576, dated August 22, 1854.

To all whom it may concern:

Be it known that I, ROBERT SPENCER, of the city, county, and State of New York, have invented a new metallic Harness-Saddle Seat Combined with the Side Bars of the Ordinary Harness-Saddle Trees; 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 the piece of iron which composes my said saddle-seat and the bars of a harness-saddle tree; Fig. 2 a vertical section of the same in the line *y y* of Fig. 1; Fig. 3, a vertical section in the line *p p* of Fig. 6; Fig. 4, plan of the saddle finished without jockeys, the flaps being placed above the bars of the tree; Fig. 5, a vertical section of the same in the line *x x* of Fig. 4; Fig. 6, plan of a portion of a harness-saddle furnished with jockeys above and the flaps below the bars of the saddle-tree; Fig. 7, a transverse section thereof in the line *z z* of Fig. 6.

Like letters designate corresponding parts in all the figures.

The nature of my invention consists in the production of a new article of manufacture, consisting of a properly shaped metallic harness-saddle seat cast in one piece with the side bars of the ordinary harness-saddle tree; the said seat being so finished and japanned as to require no covering when it forms a part of a finished harness-saddle.

The seat A, including the cantle, is cast in the exact form which the finished seat is required to have; and two wings *b, b*, in the proper shape and position to form the side bars of a harness-saddle tree, are cast in one piece with said seat. These bars are provided with terret holes *i, i*, and notches *k, k*, in the opposite edges thereof, through which rivets, or nails, *g, g*, are inserted, to secure the flanches of the terret nuts *f, f*, together with the leather parts that are situated beneath the bars. They have also a suitable number of holes in proper positions for the insertion of the nails *l, l*, which secure the jockeys and other parts to them. The seat A, is then finished smooth and japanned to give the appearance of polished leather. Consequently it requires

no leather covering in finishing the saddle; so that considerable expense is saved in manufacturing, and yet a neat and handsome saddle is produced.

Different ways of attaching the leather portions of the saddle may be employed with this combined saddle tree and finished saddle seat.

Figs 4, and 5, represent a saddle finished without jockeys, the flaps *e, e*, being placed over the tree-bars, so that their upper ends come flush up to the edges of the seat A, as represented. The girt leathers *d, d*, are situated, as usual, beneath the tree-bars, and pass out through holes in the flaps, as shown. In this case, pieces of leather *h, h*, are added beneath the girt leathers to give the requisite thickness for putting on the terret nuts. Figs. 3, 6, and 7, represent another manner of finishing, with jockeys *c, c*, over the tree-bars, while the flaps and girt leathers *e, d*, are secured beneath the tree-bars in the ordinary manner.

The crupper loop may also be cast in the same piece with the seat and tree-bars. I make use of cast iron as the most suitable material for casting the seat and tree-bars, but shall not confine my invention to any particular material.

What I claim as my invention and desire to secure by Letters Patent, is—

The within described new article of manufacture, consisting of a properly shaped harness saddle seat cast in one piece with the unfinished jockey shaped side-bars; the said seat requiring to be only smooth and japanned to adopt it to use, and the said side bars requiring to be covered with patent leather or other jockeys or skirts, of sufficient thickness to make a smooth and harmonious finish with the japanned surface of the seat, substantially as herein represented and described.

The above specification of my improved combination of harness saddle and tree signed and witnessed this 22nd day of June, 1854.

ROBT. SPENCER.

Witnesses:

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