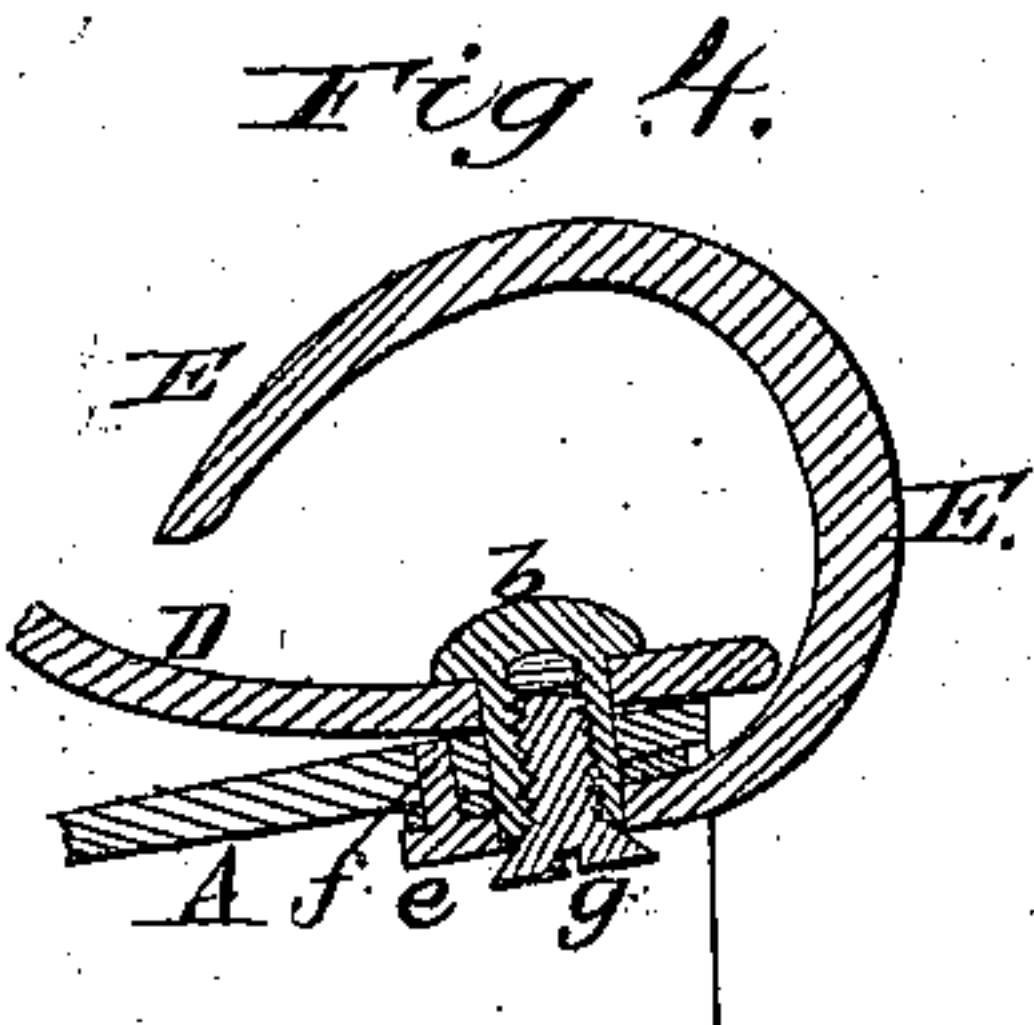
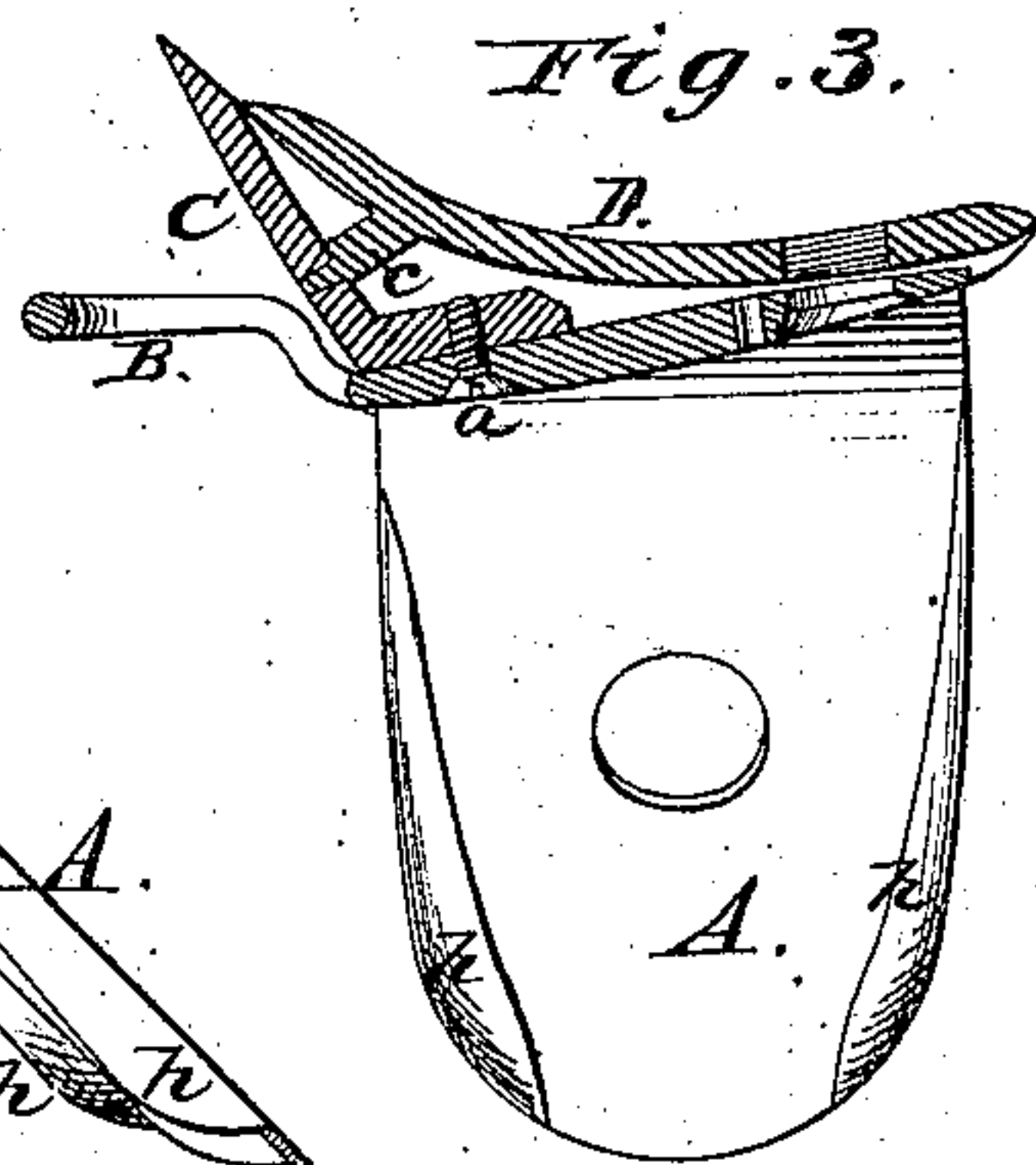
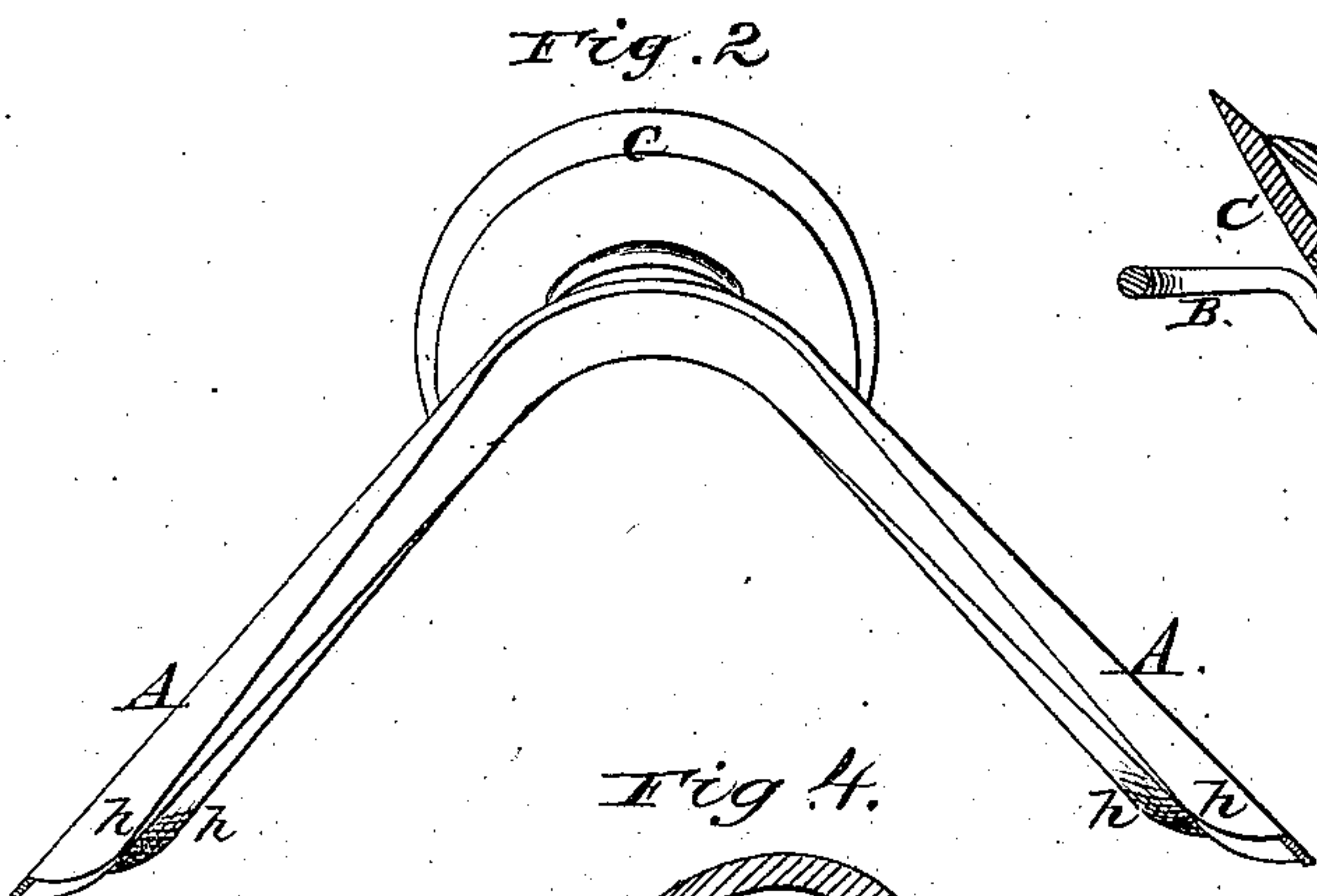
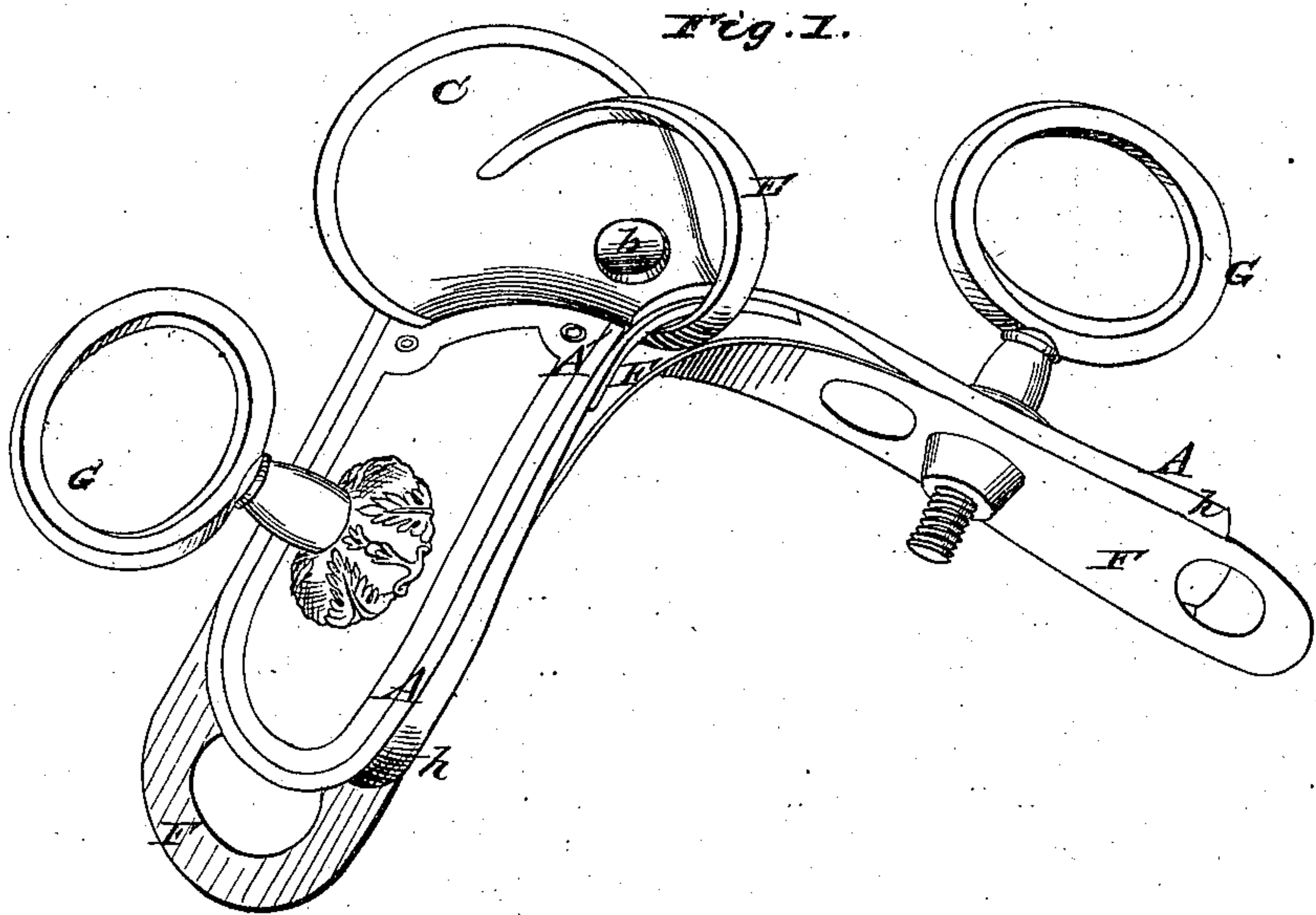


*O. B. North,*  
*Harness Saddle.*

*N<sup>o</sup> 46,489.*

*Patented Feb. 21, 1865.*



*Witnesses:*  
*J. B. Patten*  
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*Inventor.*  
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*By atty A. B. Sloughton.*



# UNITED STATES PATENT OFFICE.

OLIVER B. NORTH, OF NEW HAVEN, CONNECTICUT.

## IMPROVED HARNESS SADDLE-TREE.

Specification forming part of Letters Patent No. 46,489, dated February 21, 1865.

*To all whom it may concern:*

Be it known that I, OLIVER B. NORTH, of the city and county of New Haven, and State of Connecticut, have invented a new and useful Improvement in Harness Saddle-Trees; and I do hereby declare the following to be a full, clear, and exact description of the same, reference being had to the accompanying drawings, making a part of this specification, in which—

Figure 1 represents, in perspective, one of the saddle-trees in question highly ornamented. Fig. 2 represents a front elevation of one more plain. Fig. 3 represents a vertical longitudinal section through the seat and cantel, to show its construction. Fig. 4 represents a section through a portion of the saddle-tree, to show the manner of uniting the check-hook.

Similar letters of reference where they occur in the separate figures denote like parts in all cases.

The object and purpose of my invention is to construct a metal saddle-tree for harness, wherein the seat and "jockeys" are so combined as to give them the appearance of the best leather-covered trees, and closely resembling the shape and form of such covered trees, and when japanned presenting very nearly the appearance of patent leather, and this I accomplish by forming the jockeys in connection with that portion of the bow to which the crupper-loop is attached, all in one piece, the seat being separate from the other portions of the tree, and secured thereto, as hereinafter stated; and my invention further relates to the casting of a stud upon the under side of the upper portion of the seat, for the purpose of securing the upper portion of the seat with the back portion of the same, thus avoiding the necessity of rivets passing through, which interferes with the plating or japanning; and my invention further relates to the manner of uniting the check-hook to the bow of the jockeys by inserting the shank of the hook between the bow of the jockeys and the under or lower frame, and using a screw and pin to firmly secure it there.

To enable others skilled in the art to make and use my invention, I will proceed to describe the same with reference to the drawings.

The jockeys A A and crupper-loop B, I cast in one piece. The cantel C, I cast in another and separate piece, and unite it to the bow of the jockeys by a screw, *a*, or its equiv-

alent, and the seat D, which rises up in rear, so as to form a portion or one side of the cantel, I cast in another and a separate piece. On the under side of the seat portion D, I cast a stud, *c*, which passes through the cantel, and thus unites the seat to the tree in rear of the screw or nut *b*, by which the check-hook E is fastened to the tree, securing also the front part of the seat to the jockey-bow.

F is the frame underneath the jockeys, and the shank of the check-hook *e* passes between said frame and the jockey-bow, and has a pin, *f*, at its extreme rear end, which passes up into the jockey-bow to prevent the check-hook from turning, said hook being further secured by a screw, *g*, passing up into a headed hollow nut, *b*, as shown in Fig. 4. The jockeys at the lower ends are slightly turned at their edges *h*, for the sake of strength and finish. The turrets G may be united to the tree as shown, or in any other manner that may be preferred.

When the jockeys, seat, and cantel are cast all in one piece, as has been done, such shape was given to the cantel as would allow of the pattern being readily withdrawn from the mold, but not such shape as was most chaste and fancied by makers and users. Hence I make my tree in pieces, so as to get that desirable shape. Though I may make my trees to represent patent leather, I can also cover the seats with such leather, or I may use silver or brass mounting, if I so prefer.

Having thus fully described my invention, what I claim is—

1. A metallic saddle tree for harness, composed of the jockeys, cantel, and seat, cast in separate pieces and united together, substantially in the manner and for the purpose described.

2. Casting a stud upon the under side of the seat, for the purpose of uniting said seat to the cantel without passing rivets or screws through, which interfere with and mar the plating or japanning, as herein described.

3. Uniting the check-hook to the tree by passing the shank of the hook under the bow of the jockeys and above the frame, and uniting it by the stud or pin *f* and the screw and nut *g b*, or their equivalent devices, substantially as herein described and represented.

O. B. NORTH.

Witnesses:

A. B. STOUGHTON,  
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