

W. F. OSBORNE.

Mode of Manufacturing Buckle-Tongues.

No. 207,769.

Patented Sept. 3, 1878.

fig. 1

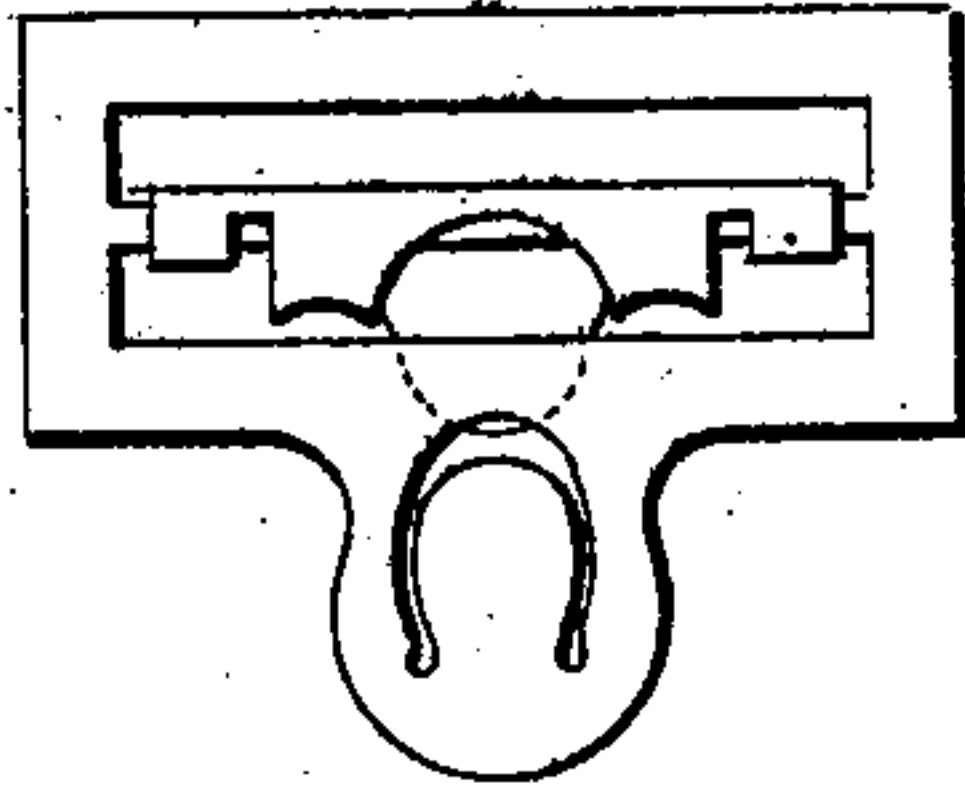


fig. 3.

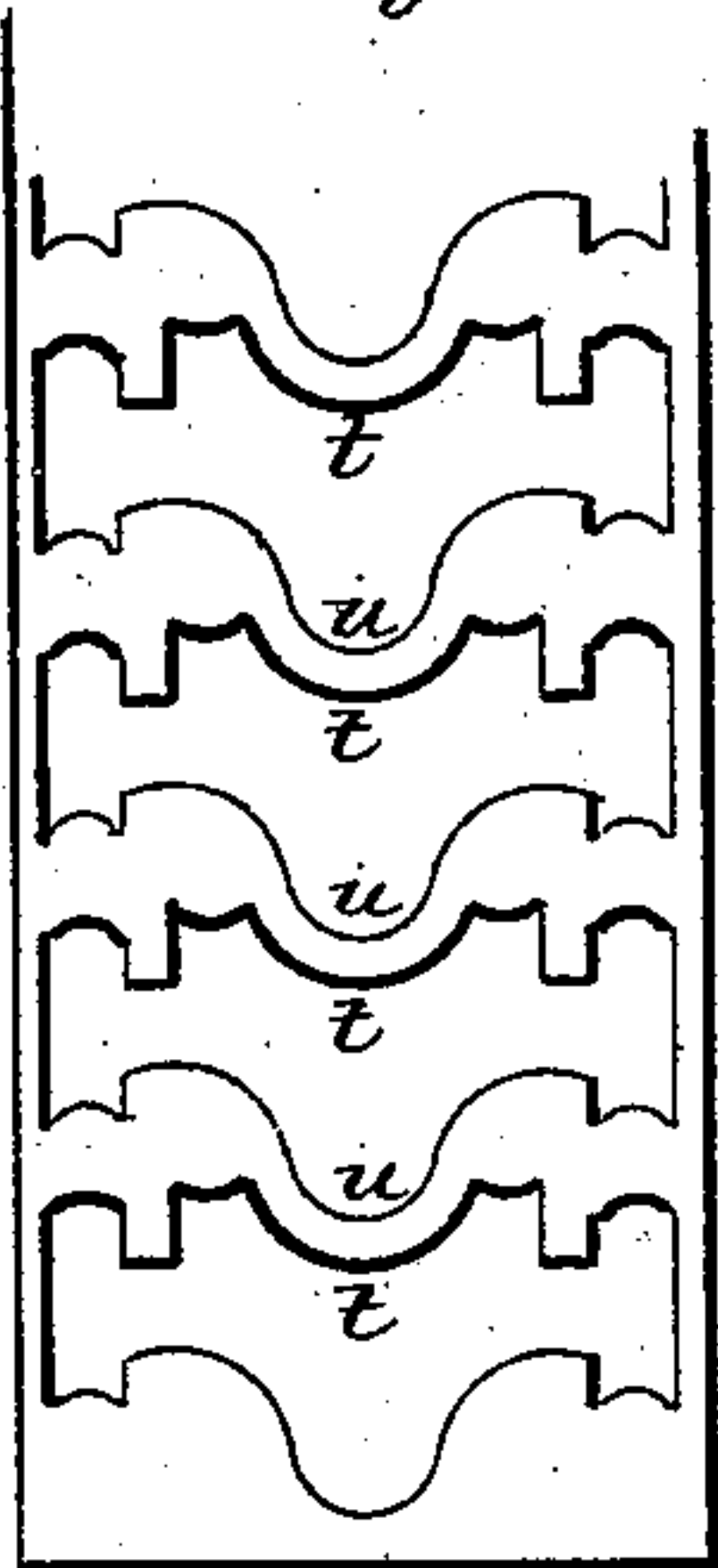


fig. 2

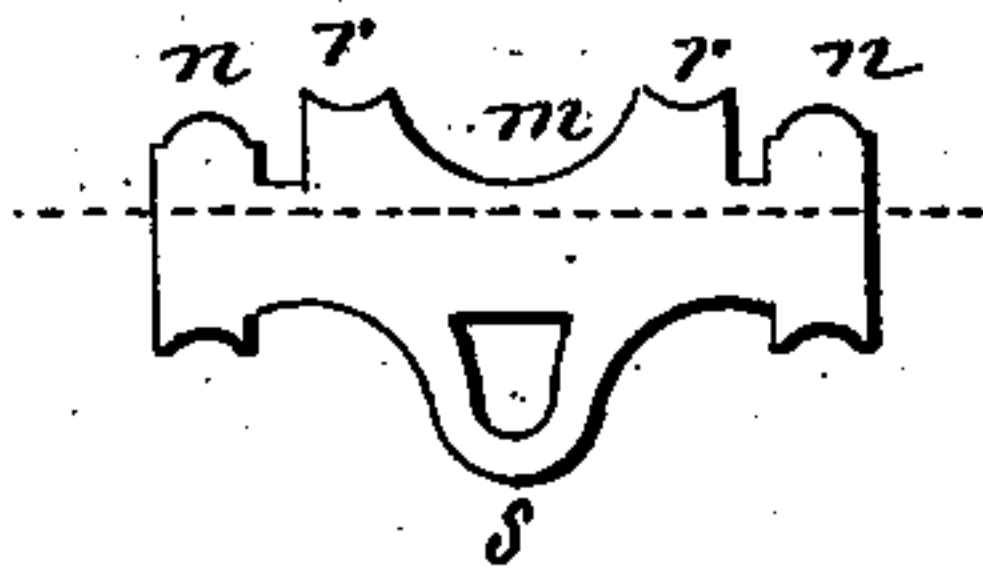


fig. 4

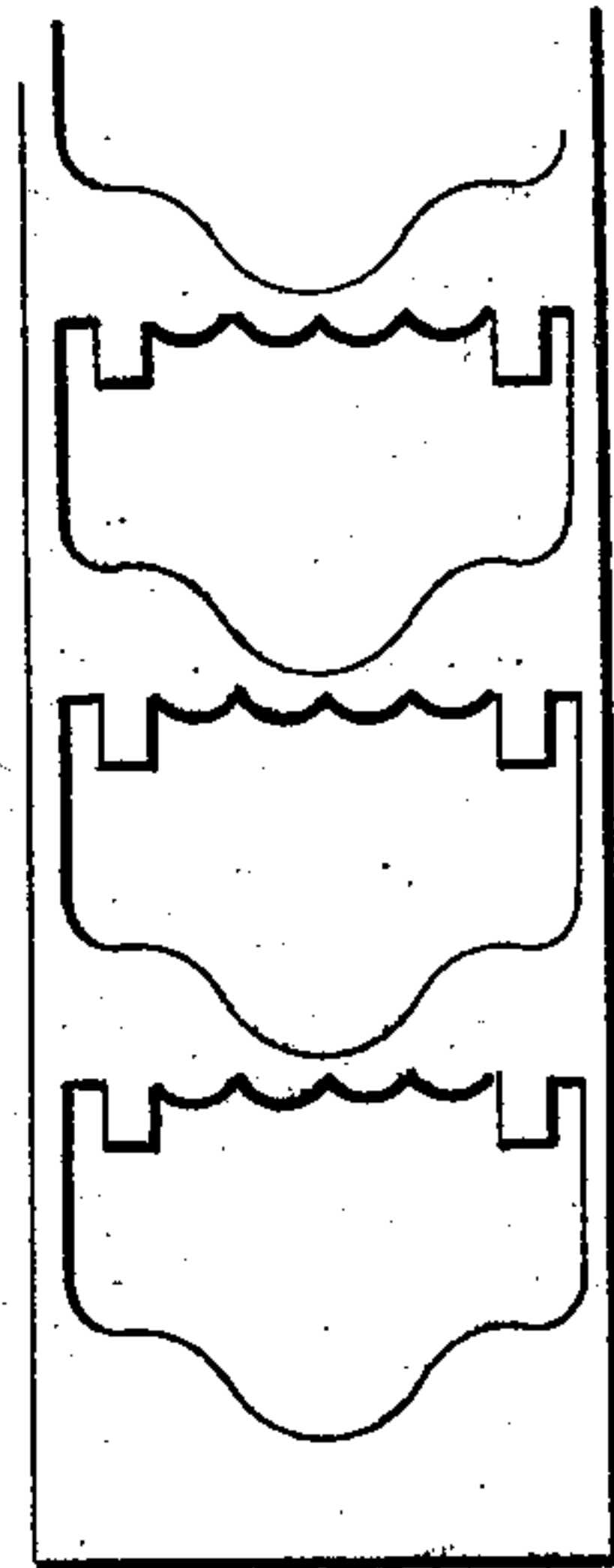


fig. 5

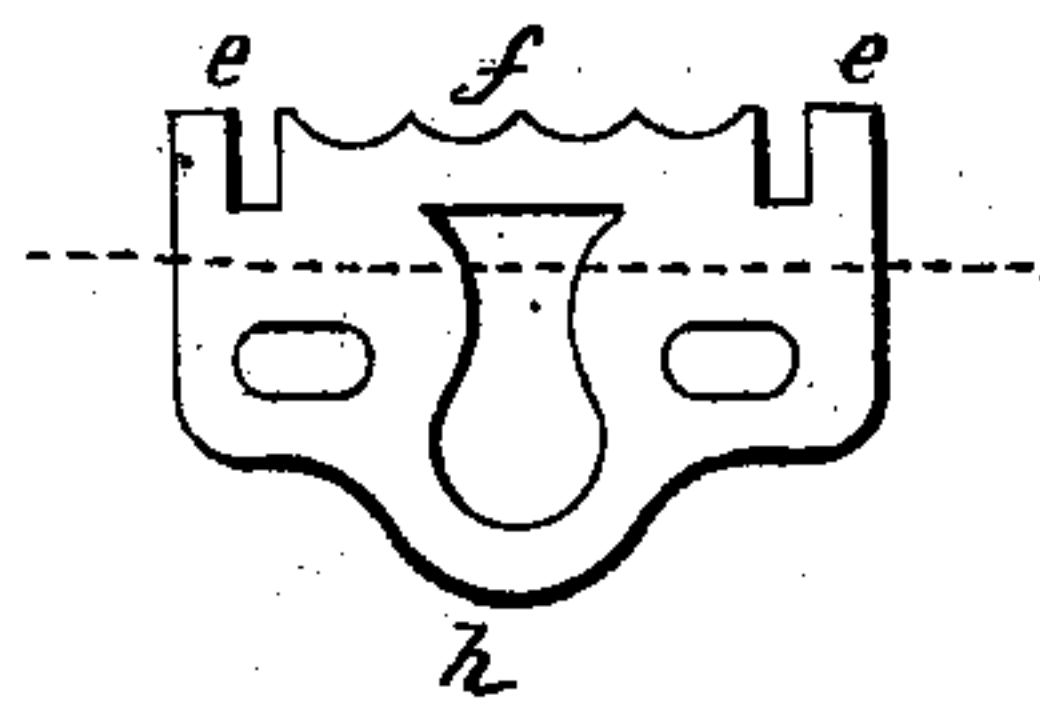
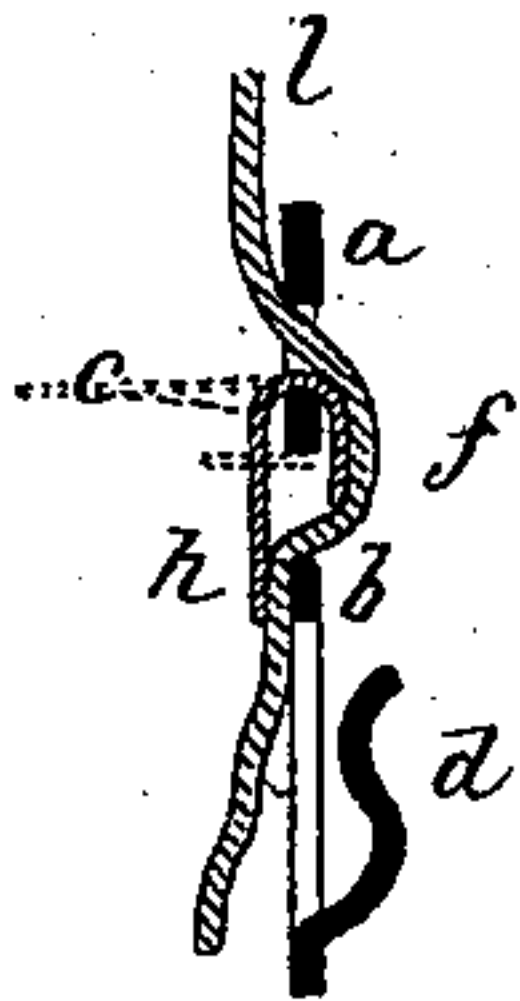


fig. 6.



Witnesses.

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## IMPROVEMENT IN MODES OF MANUFACTURING BUCKLE-TONGUES.

Specification forming part of Letters Patent No. **207,769**, dated September 3, 1878; application filed August 8, 1878.

*To all whom it may concern:*

Be it known that I, WILBUR F. OSBORNE, of Ansonia, in the county of New Haven and State of Connecticut, have invented a new Improvement in Buckles; and I do hereby declare the following, when taken in connection with the accompanying drawings and the letters of reference marked thereon, to be a full, clear, and exact description of the same, and which said drawings constitute part of this specification, and represent, in—

Figure 1, a front view of the buckle with improved lever; Fig. 2, the lever detached and flat; Fig. 3, diagram illustrating the method of cutting; Fig. 4, diagram illustrating the method of cutting the lever as heretofore constructed; Fig. 5, the lever as cut according to Fig. 4; Fig. 6, vertical section through the buckle, with the strap engaged.

This invention relates to an improvement in the manufacture of buckles commonly called "suspender-buckles," and which consist of a frame with a lever hinged therein, one arm of which serves as a means for turning the lever, and the other for engaging the strap, as seen in Fig. 6, in which *a* represents the upper bar, *b* the lower bar, and *c* the intermediate bar, of the frame, the lower bar extended and provided with a hook, *d*, with which to engage the brace of the suspender.

The tongues as heretofore made are successively cut from sheet metal, as seen in Fig. 4, Fig. 5 showing the lever so cut. This lever is doubled on the broken line, and the two tongues *e* bent around the said central bar to secure the lever thereon. The serrated edge *f* turns to the front, the reverse edge or end *h* to the back, forming a handle by which to turn the lever, as indicated in broken lines, Fig. 6, to free the strap, and also to bear against the strap when set as seen in Fig. 6, so that the

serrated edge *f* will engage the strap *l*. This construction is common and well known.

The object of this invention is to construct the tongue so as to make a great saving of metal; and it consists in the method of cutting the tongues of buckles, as hereinafter described, and more particularly recited in the claim.

The lever, as shown in Fig. 2, has tongues *n* on one edge to secure it upon the bar in the usual manner. Between these tongues is the engaging portion of the lever. In the center is a deep depression or cut, *m*, forming practically projections *r* at each side, which are the engaging-prongs of the lever. On the opposite edge there is the usual projection *s* to form the handle or stop for the lever.

By this peculiar shape of the buckle the blanks are cut as seen in the diagram, Fig. 3. The recess *m* on the holding-edge of the lever leaves the metal as at *t*, so that the handle or stop *s* may extend down within the line of the edge of the lever, as at *u*.

By this peculiar shape of lever very nearly, if not quite, fifty per cent. of the metal is saved, and consequently the cost of the buckle is proportionately reduced.

I claim—

The herein-described improvement in the method of manufacturing buckle-levers, consisting in cutting the lever from the blank, with a recess, *m*, on its holding-edge, corresponding substantially to the handle or stop on the opposite edge, and so that, in cutting, the handle of one extends into the recess of the other, substantially as described.

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Witnesses:

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