

(No Model.)

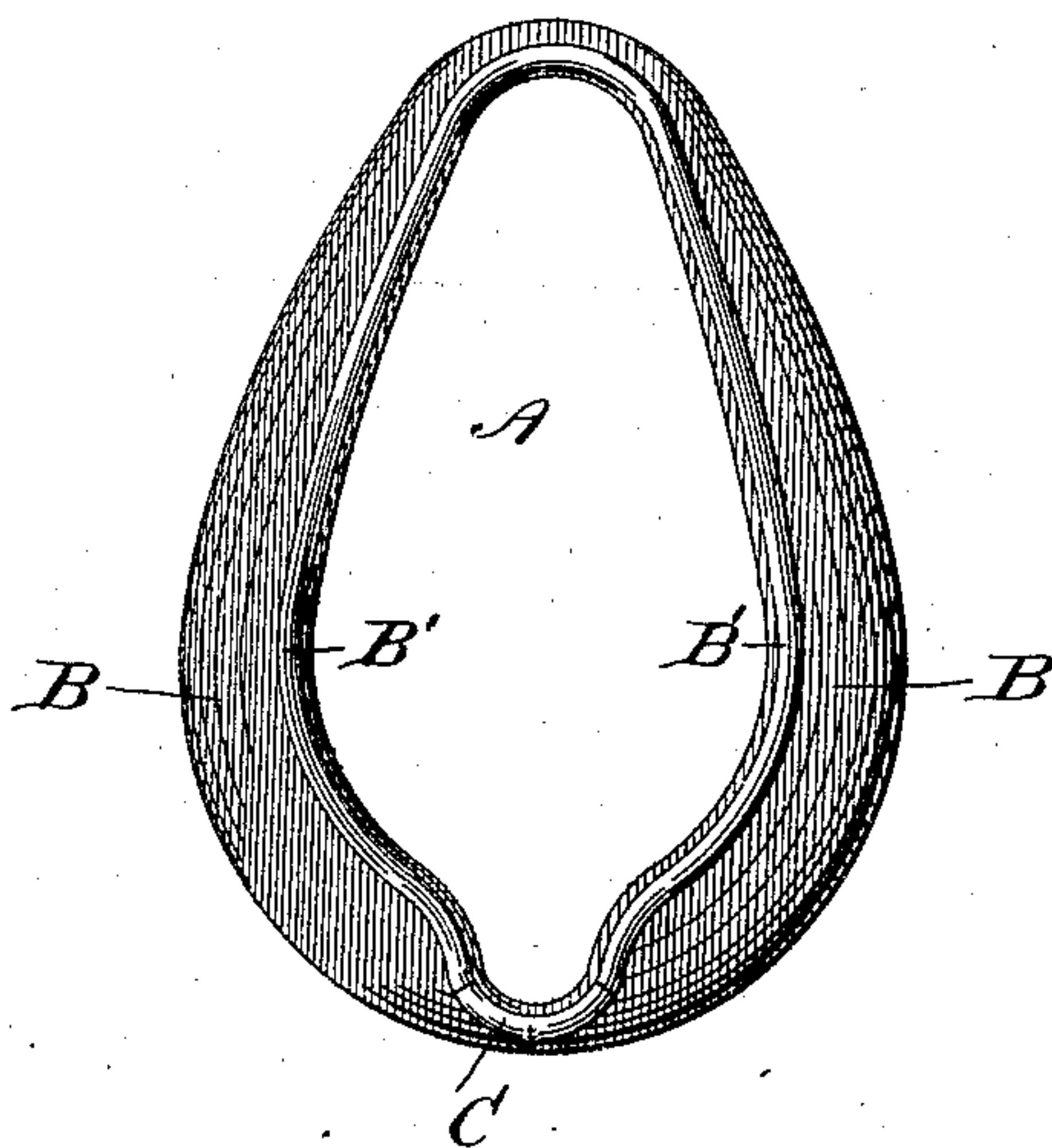
T. F. HAGERTY.

HORSE COLLAR.

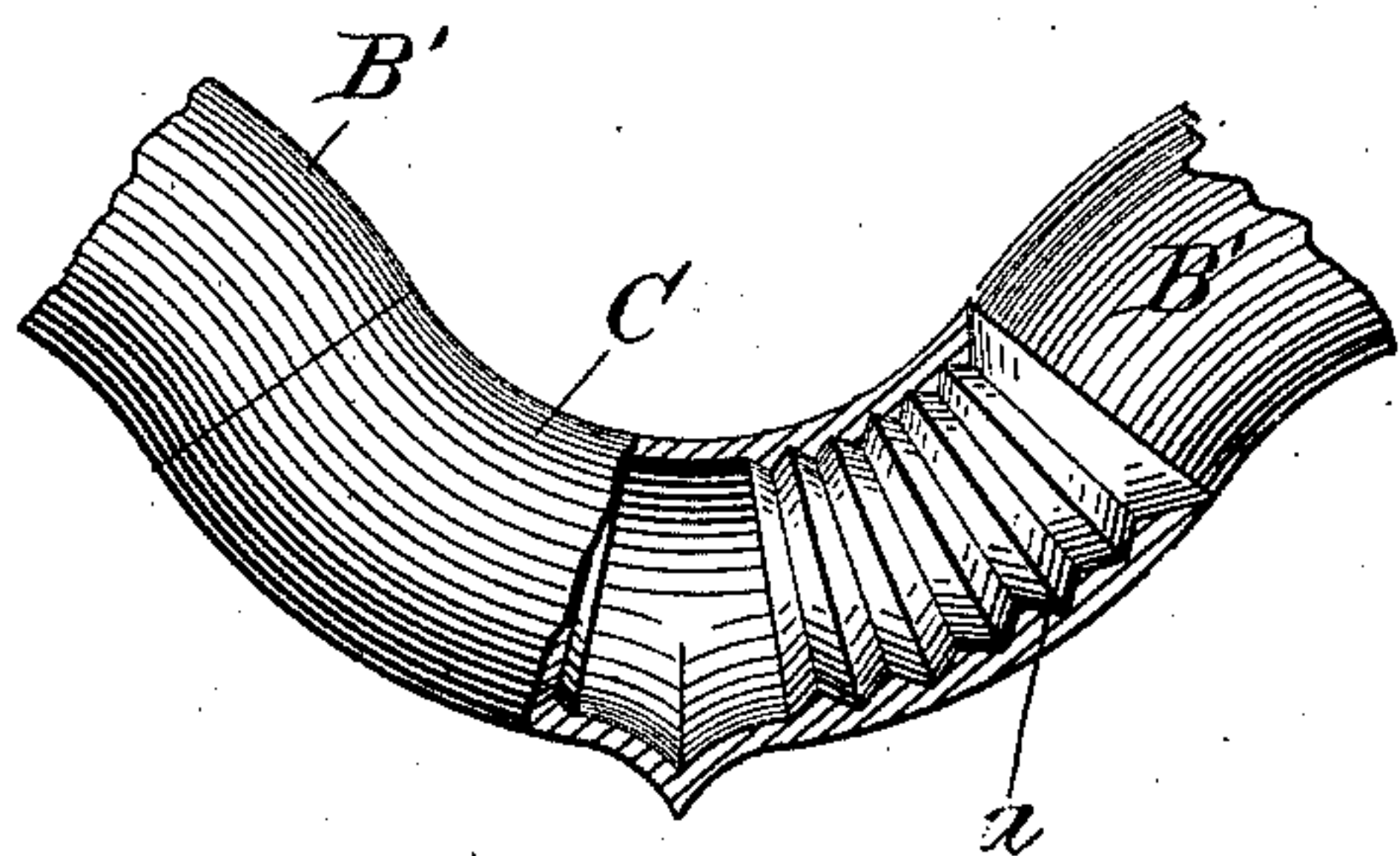
No. 305,179.

Patented Sept. 16, 1884.

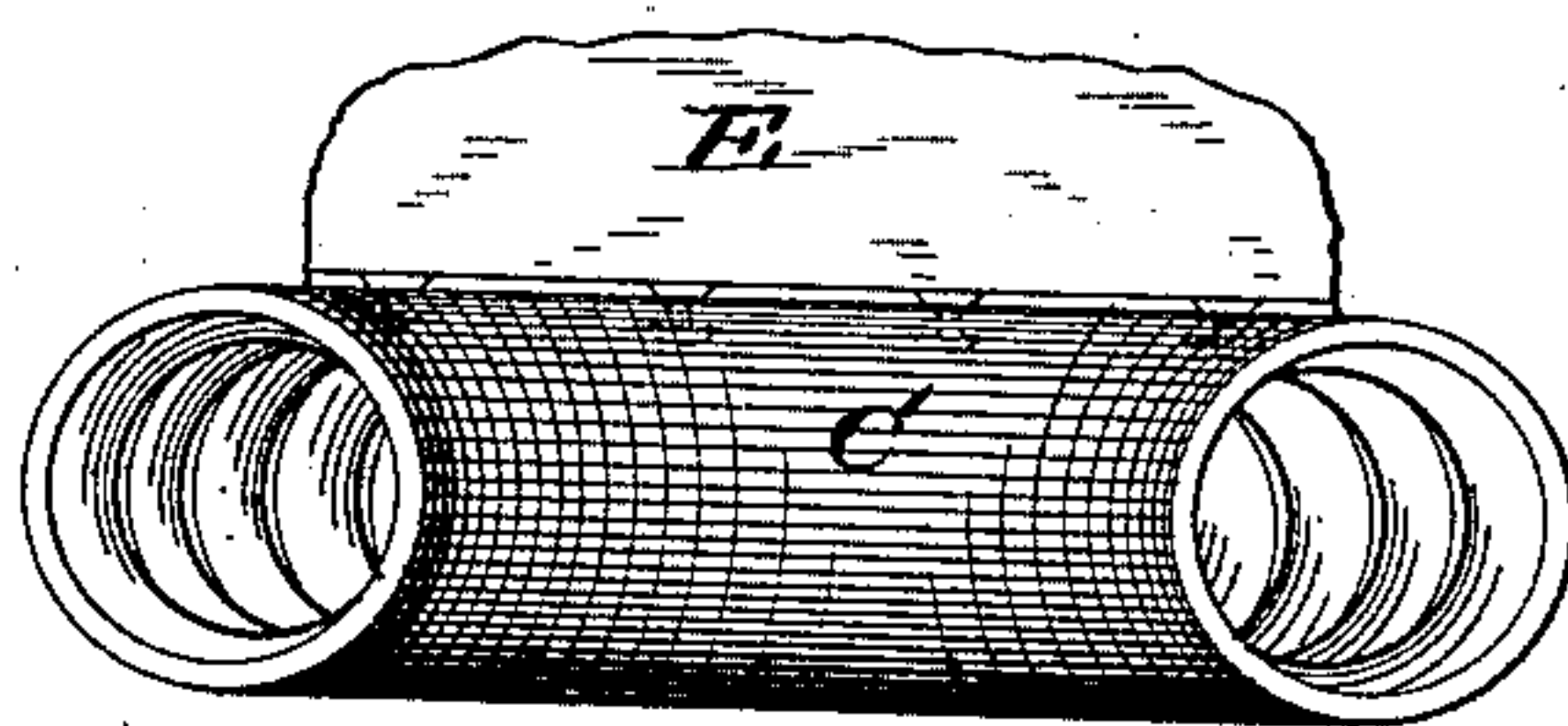
*Fig. 1.*



*Fig. 2.*



*Fig. 3.*



WITNESSES

Chas. R. Burr  
Fred H. Church

INVENTOR

Thomas F. Hagerty  
by Church & Church  
His Attorneys



# UNITED STATES PATENT OFFICE.

THOMAS F. HAGERTY, OF SAN FRANCISCO, CALIFORNIA.

## HORSE-COLLAR.

SPECIFICATION forming part of Letters Patent No. 305,179, dated September 16, 1884.

Application filed July 25, 1884. (No model.)

*To all whom it may concern:*

Be it known that I, THOMAS F. HAGERTY, of the city and county of San Francisco, and State of California, have invented certain new and useful Improvements in Horse-Collars; 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, forming a part of this specification, and to the figures and letters of reference marked thereon.

My invention relates to that class of horse-collars in which the throat parts are united by means of a metallic tubular throat-piece; and it consists, first, in an improved form of throat-piece; secondly, in a novel mode of attaching such throat-piece; and, thirdly, in the combination, with the improved throat-piece, of a supplemental flange or flap of leather sewed or riveted to said throat-piece and adapted to be sewed to the body side of the collar, all as will be hereinafter described and claimed.

In the accompanying drawings, Figure 1 represents a front view of a horse-collar constructed in accordance with my invention. Fig. 2 is a detail view, partly in section and partly in elevation, showing the construction of the throat-piece and its manner of attachment to the fore wale or rim of the collar. Fig. 3 is a top plan view of the throat-piece and the supplemental leather flap applied thereto.

Similar letters of reference in the several figures indicate like parts.

The letter A represents a horse-collar formed with the body side B and fore wale or rim B', as usual. C is the metallic tubular throat-piece, made curved, as shown, and having upon its inside suitable holding-rings, threads, projections, or recesses, preferably such as shown at *a*, Fig. 2, cast, pressed, cut, or otherwise formed, though preferably cast integral with the throat-piece.

In the manufacture of the collar according to my invention, the fore wale or rim and the body side are sewed together in the usual manner, except that an opening is left in the lower part of the fore wale or rim for the reception of the throat-piece, and the upper part of the fore wale or rim is left open for the introduction of the straw or other filling. The ends of the rim or fore wale, while they

are yet wet and pliable, are then inserted into the ends of the throat-piece, after which the straw or other filling is stuffed down into the rim or fore wale and into the ends of the throat-piece and firmly hammered home, thus causing the tubular end of the rims to be expanded within the throat-piece, and to be pressed into positive engagement with the recesses or rings, so as to form a firm connection therewith, which no amount of longitudinal strain will affect. The throat-piece has preferably a flange or flap of leather, E, sewed or riveted to its rear side previous to its being attached to the throat of the collar. This flange or flap is sewed in with the rim to the body of the collar and serves as an auxiliary means of connection.

By practicing my invention there is a saving of labor and time in the manufacture of collars, and by the method of attaching the leather to the metal throat-piece not only is the connection made durable and permanent, but a smooth and flush joint is formed between the metal and the leather.

Having thus described my invention, what I claim as new is—

1. In a horse-collar, the combination, with the throat ends of the rim or fore wale, of the tubular metallic throat-piece having the rings, projections, or depressions on its inside, substantially as described.

2. The herein-described mode of attaching the throat ends of the rim or fore wale to the tubular metallic throat-piece, consisting in first inserting the tubular ends of the rim into the ends of the throat-piece, and then expanding the rim ends into engagement with the rings, projections, or recesses of the throat-piece by stuffing in straw or other filling material, substantially as described.

3. In the herein-described horse-collar, the combination, with the throat ends of the rim or fore wale, of the tubular metallic throat-piece having the internal rings, projections, or recesses, and the leather flange or flap riveted to the throat-piece and sewed to the body of the collar, substantially as described.

THOMAS F. HAGERTY.

Witnesses:

HENRY M. MCGILL,  
JOHN SIMON.