

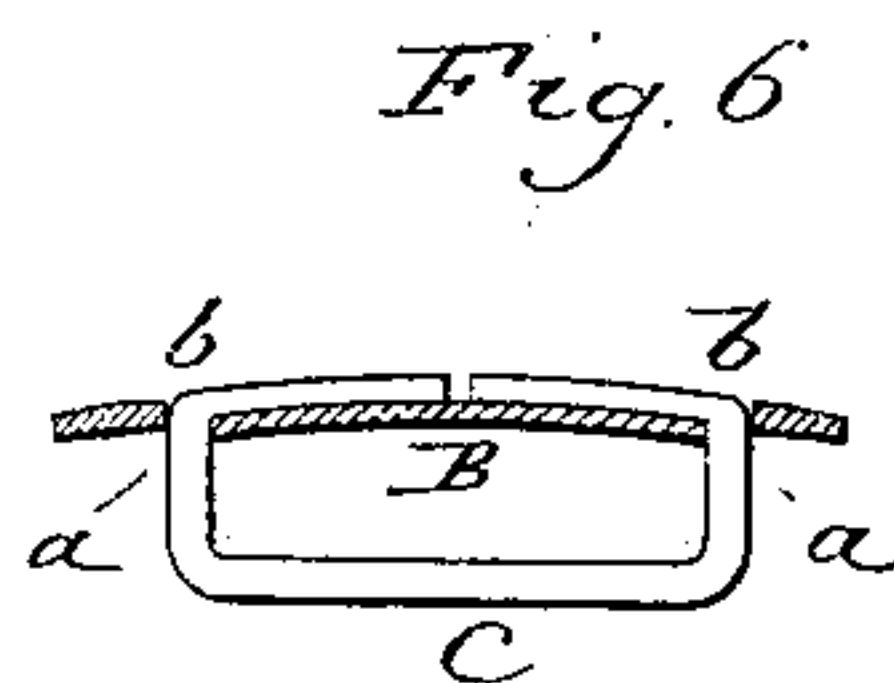
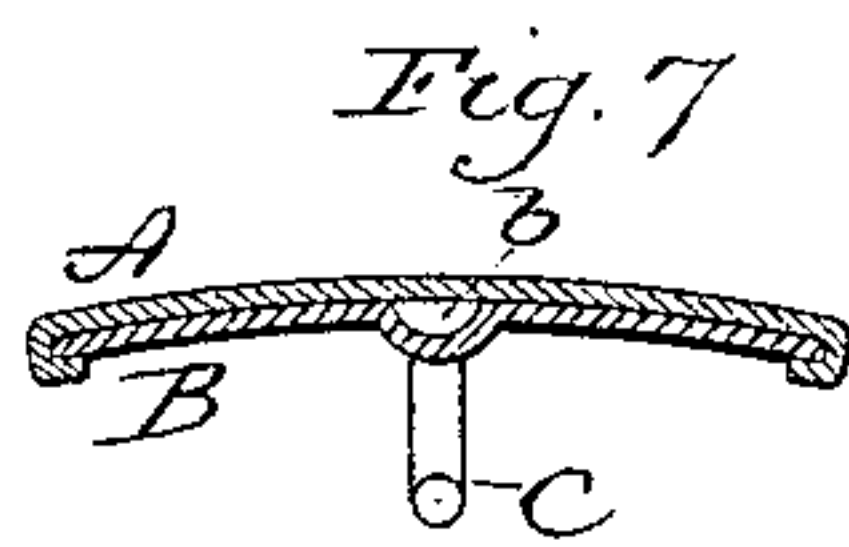
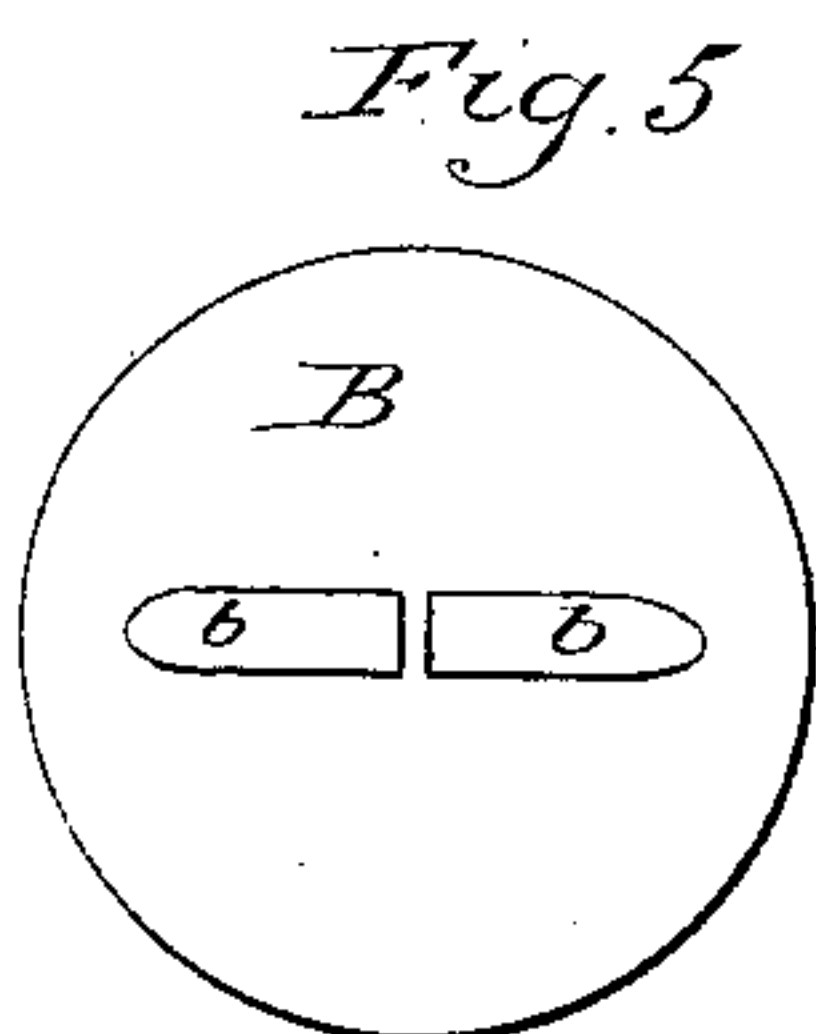
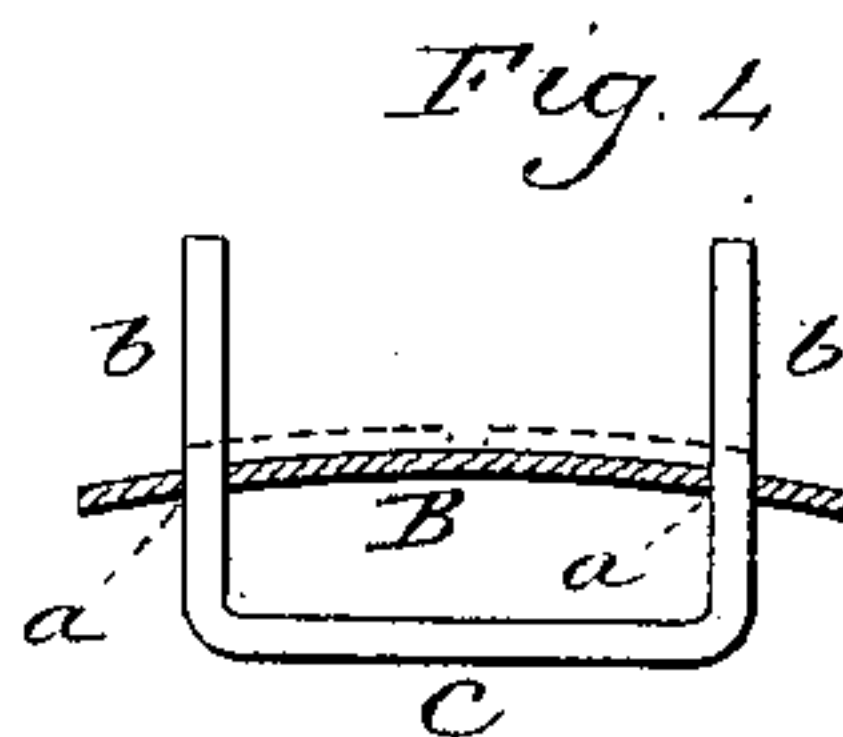
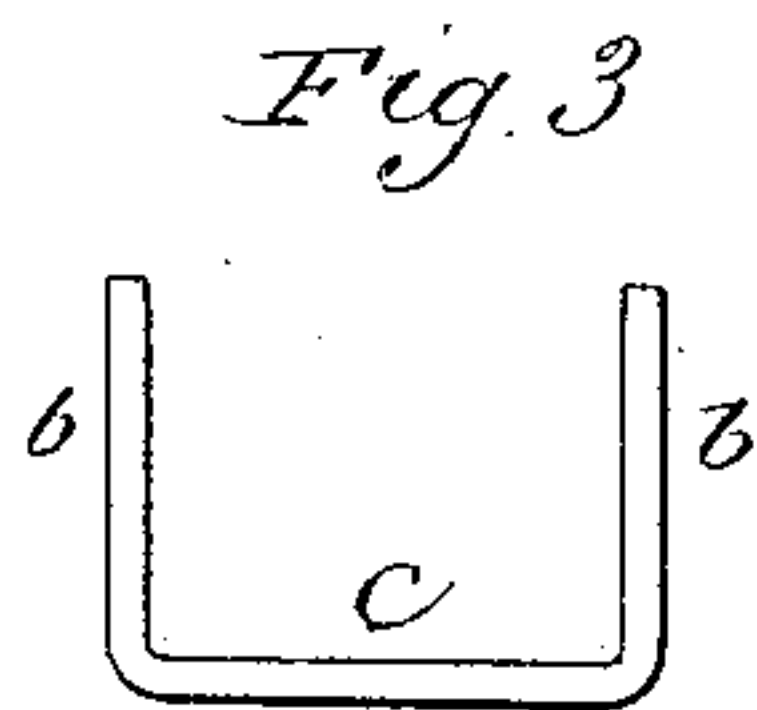
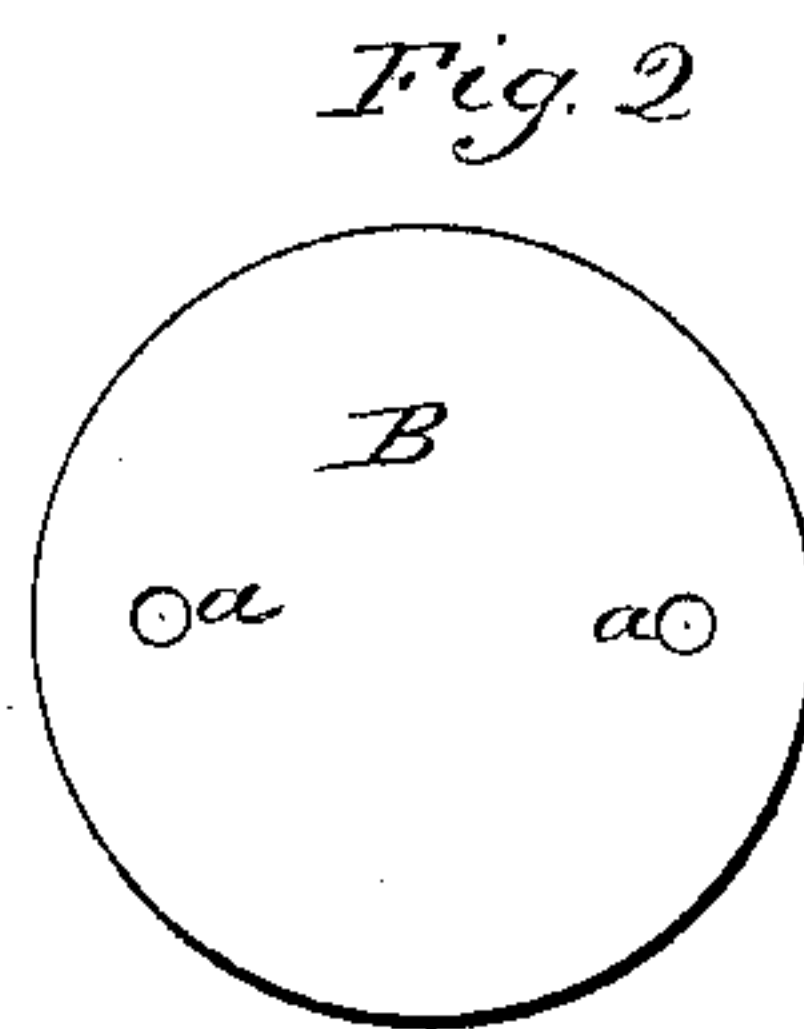
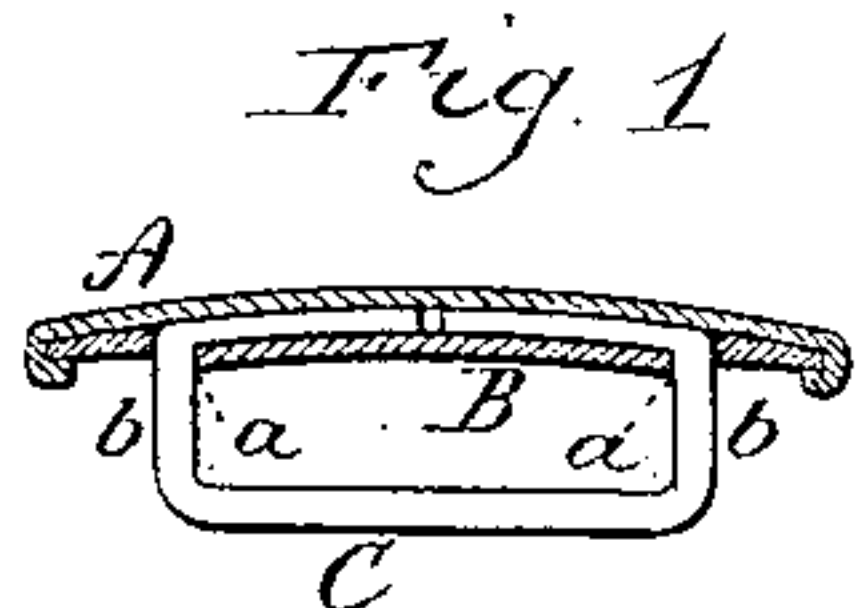
(No Model.)

D. M. IRELAND.

HARNESS ROSETTE.

No. 389,387.

Patented Sept. 11, 1888.



Witnesses:
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Fred C. Eare

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UNITED STATES PATENT OFFICE.

DAVID M. IRELAND, OF WATERBURY, CONNECTICUT.

HARNESS-ROSETTE.

SPECIFICATION forming part of Letters Patent No. 389,387, dated September 11, 1888.

Application filed May 28, 1888. Serial No. 275,259. (No model.)

To all whom it may concern:

Be it known that I, DAVID M. IRELAND, of Waterbury, in the county of New Haven and State of Connecticut, have invented a new Improvement in Harness-Rosettes; and I do hereby declare the following, when taken in connection with 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 section through the rosette in the plane of the loop; Fig. 2, the back detached; Fig. 3, the loop detached; Fig. 4, the loop and back, showing the legs of the loop through the perforations in the back; Fig. 5, the inner surface of the back, showing the legs turned down thereon and flattened; Fig. 6, a longitudinal section through the loop and back after flattening and preparatory to applying the face; Fig. 7, a transverse section.

This invention relates to an improvement in rosettes for harnesses and like purposes, and which are constructed to present an ornamental metal face, and which are provided with a loop on the reverse side, through which the attaching-strap may pass. It is desirable that this loop shall be secured to the back, so as to be rigid and stand in a plane at substantially right angles to the plane of the rosette.

Rosettes have been constructed from two disks of metal, secured together at their edges, the loop made from wire in U shape, the two legs of the U inserted through perforations in the back prior to applying the face thereto, and the legs bent down upon the inner surface of the back and there secured by solder, and then the face applied. The soldering of the loop to the back adds materially to the cost of manufacture; but, as usually constructed soldering is necessary in order to prevent the loop from rocking or swinging out of its proper plane. The wire being round, the turned ends of the legs between the face and back form a hinge, upon which the loop will naturally swing unless held by solder.

The object of my invention is to preserve the round wire loop on the back of the rosette, but yet to so secure the loop between the back and front that it will be firmly held in place, and its rocking prevented.

To this end the invention consists in a rosette composed of a metal disk back and a metal disk front, one closed upon the other around the edge, so as to secure the two together, combined with a metal loop of round wire made of U shape, two legs of the U introduced through perforations in the back prior to placing the front upon the back, the ends of the legs turned down upon the inside of the back and there struck to produce a flattened surface, and then the front closed upon the back and upon the said flattened ends of the legs and so that the said flattened ends take a bearing upon the inside of the front and back, the said flattened surface of the legs thus supported preventing the loop from rocking, as more fully hereinafter described.

A represents the front and B the back; C, the loop. The rosette is preferably made so as to present a convex surface, but may be flat, concave, or any desirable shape. To form the back B a disk is cut from sheet metal of the required size and pierced at two points, *a a*, distant from each other, according to the length of the loop, as seen in Fig. 2. The loop, as seen in Fig. 3, is made from round wire bent into U shape, the two legs *b b* being longer than the projection required for the loop and distant from each other corresponding to the perforations *a a* in the back. The loop is set into the back, the legs through the perforations, as seen in Fig. 4, leaving the loop projecting the required distance from the rear surface of the back. The portions of the legs which project upon the inside of the back are then turned, preferably, toward each other, as indicated in broken lines, Fig. 4. Then the said turned-in ends of the legs are struck so as to flatten their upper surface, as seen in Figs. 5 and 7. In thus striking the turned-in ends of the legs upon the back a depression is produced in the back, preferably so as to bring the flat surface of the legs flush with the surrounding surface of the back, as seen in Figs. 6 and 7. This striking of the legs into the back produces a rib across the back between the legs. The face A is also made from a disk of metal somewhat larger than the back, but so as to lie in substantial contact with the back. The face is then placed upon the back and the edge of the face closed over the edge of the back, as represented

in Fig. 1, which secures the face to the back, and the face lying upon the flat surface of the turned-in portion of the legs clamps that portion of the legs between the face and back, and
5 because of the flat surface of the legs so produced the loop is held firm and rigid and without the employment of solder.

It will be understood that in this case, as in the usual construction of this class of rosettes,
10 the face may be closed over the edge of the back, as I have described, or the edge of the back over the edge of the face, this being too well known a mechanical expedient to require illustration. By this construction the whole
15 manufacture of the rosette may be performed by dies, as the soldering of the parts is avoided, and not only is the solder avoided, but the loop is more firmly held than can be by solder, for the reason that solder is liable to give way, in
20 which case the loop will be loose and free to rock.

From the foregoing it will be understood

that I do not claim, broadly, a rosette composed of two disks of metal with a loop made from wire, the legs of the loop extending
25 through perforations in the back and turned between the two disks; but

What I do claim as my invention is—

A rosette consisting of the metal face A and the metal back B, the back constructed with
30 two perforations, *a a*, combined with a round wire loop, C, of U shape, the legs of the U extending through the perforations in the back and turned down upon the inner surface of the
35 back, the turned-down portions of the legs flattened and the face and back closed one upon the other and so as to bring the face to bear upon the flattened surface of the turned-in portion of the legs, substantially as and for the purpose described.

DAVID M. IRELAND.

Witnesses:

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