(No Model.)

F. H. RICHARDS.

METHOD OF MAKING PLATES FOR SUSPENDER BUCKLES.

No. 436,263. Patented Sept. 9, 1890.

Fig. 1

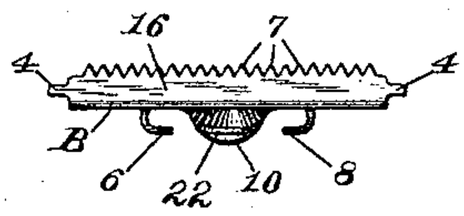


Fig. 2

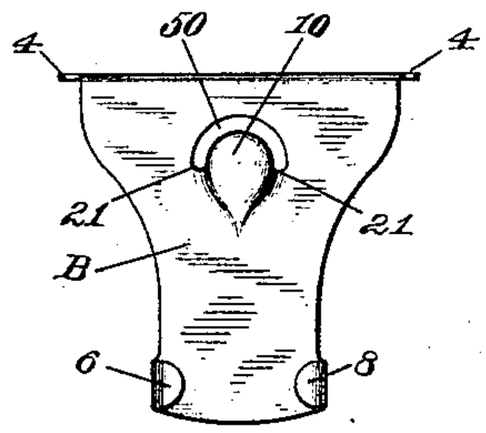


Fig. 3

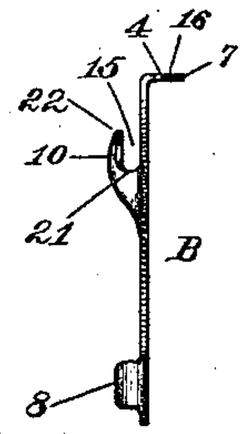
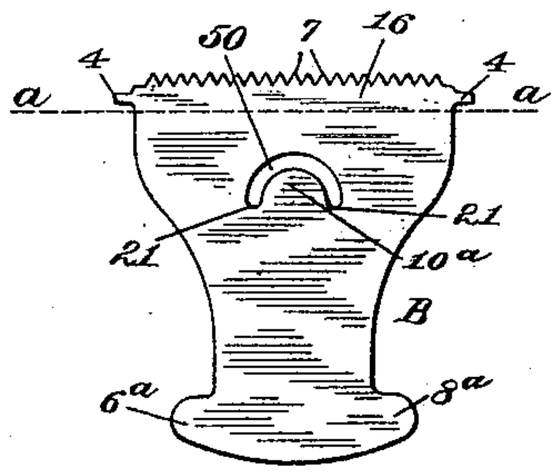


Fig. 4



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UNITED STATES PATENT OFFICE.

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METHOD OF MAKING PLATES FOR SUSPENDER-BUCKLES.

SPECIFICATION forming part of Letters Patent No. 436,263, dated September 9, 1890.

Original application filed May 1, 1890, Serial No. 350,232. Divided and this application filed June 16, 1890. Serial No. 355,675.

(No model.)

To all whom it may concern:

Be it known that I, FRANCIS H. RICHARDS, a citizen of the United States, residing at Hartford, in the county of Hartford and State of Connecticut, have invented certain new and useful Improvements in the Method of Making Plates for Suspender-Buckles, of which the following is a specification.

This invention relates to buckle-plates for suspender-buckles of the class described in my prior application, Serial No. 350,232, filed May 1, 1890, of which this application is a division, the object being to furnish a method whereby hook-provided buckle-plates may be formed out of sheet metal, as hereinafter more fully set forth.

In the drawings accompanying and forming a part of this specification, Figure 1 is a top view of the finished buckle-plate. Fig. 2 is a front or plan view of the finished plate. Fig. 3 is an edge view of the same. Fig. 4 is a plan view of the blank for said plate with the curved slot therein.

Similar characters designate like parts in all the figures.

In the finished buckle-plate B there may be any suitable means for attachment of said plate to the suspender-web—as, for instance, pivots 4 4 for carrying the lever and the narrow portion 16, having the teeth 7 for engaging said web, said portion 16 being bent on the line *a a*, Fig. 4, at right angles to the main portion of the plate B; also, at the lower end of said plate are the hanger-engaging hooks 6 and 8, which are formed by suitably bending the projecting parts 6^a and 8^a, respectively, of the blank. (See Fig. 4.)

The formation of the hanger-supporting hook 10, to which my present invention relates, is effected by first cutting through the plate and afterward stamping into proper hook shape the metal within and below said cut. The slot designated by 50 in Figs. 2 and 4 is curved and has its convex side toward the aforesaid line *a a*. The metal 10^a, Fig. 4, lying below said slot, constitutes the hook-forming portion of the plate. In forming the hook said hook-forming portion 10^a is swaged into shape to stand forward of the plate, as indicated in Figs. 1 and 2, where is the hanger-receiving space 15, between the edge 22 of the hook and the plate B. The ends 21 of said slot 50, being curved, as shown in Fig. 4, form, when the hook is thrown forward, as in Fig. 3, curved seats for the buckle-hanger, as shown in said Fig. 3. The proper curvature of said seat 21 depends of course upon the width and the curvature of the ends of said slot 50, and when said hook-forming portion is swaged to form the hook 10 the form of said slot ends naturally is given to the corresponding portions of the finished buckle-plate.

Having thus described my invention, I claim—

1. The method of forming hook-provided buckle-plates, herein described, consisting in making in the plate a curved cut bordering the upper side of the hook and forming the hook by throwing forward that part of the metal lying below and within said cut, whereby there is also formed the space 15 for receiving the buckle-hanger.

2. The method of forming hook-provided buckle-plates having the space 15 between the planes of the plate and of the hook thereof and having the curved hanger-seats, which consists in first forming in the blank the curved slot having curved ends and then forming the hook by shaping and throwing forward the hook-forming part within said slot, whereby the curved end of the slot in the blank becomes the curved hanger-seat.

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