

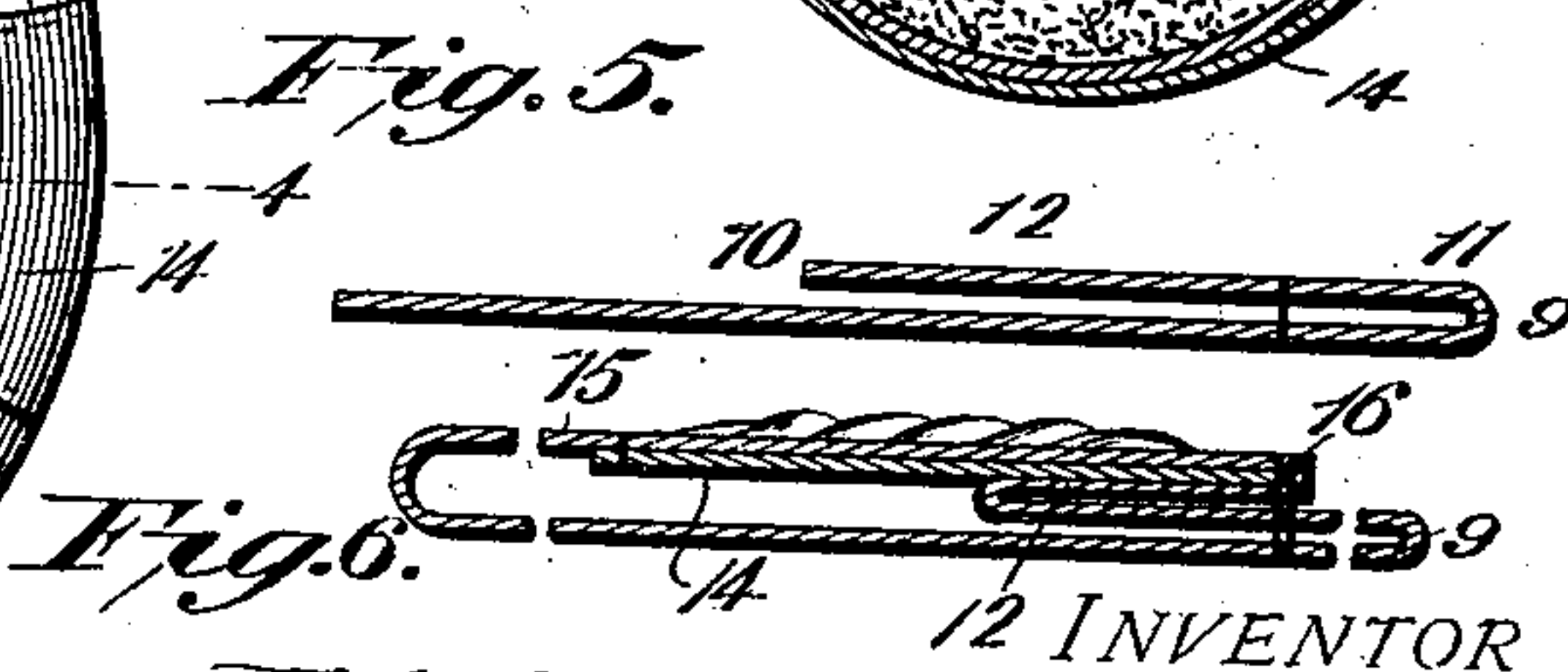
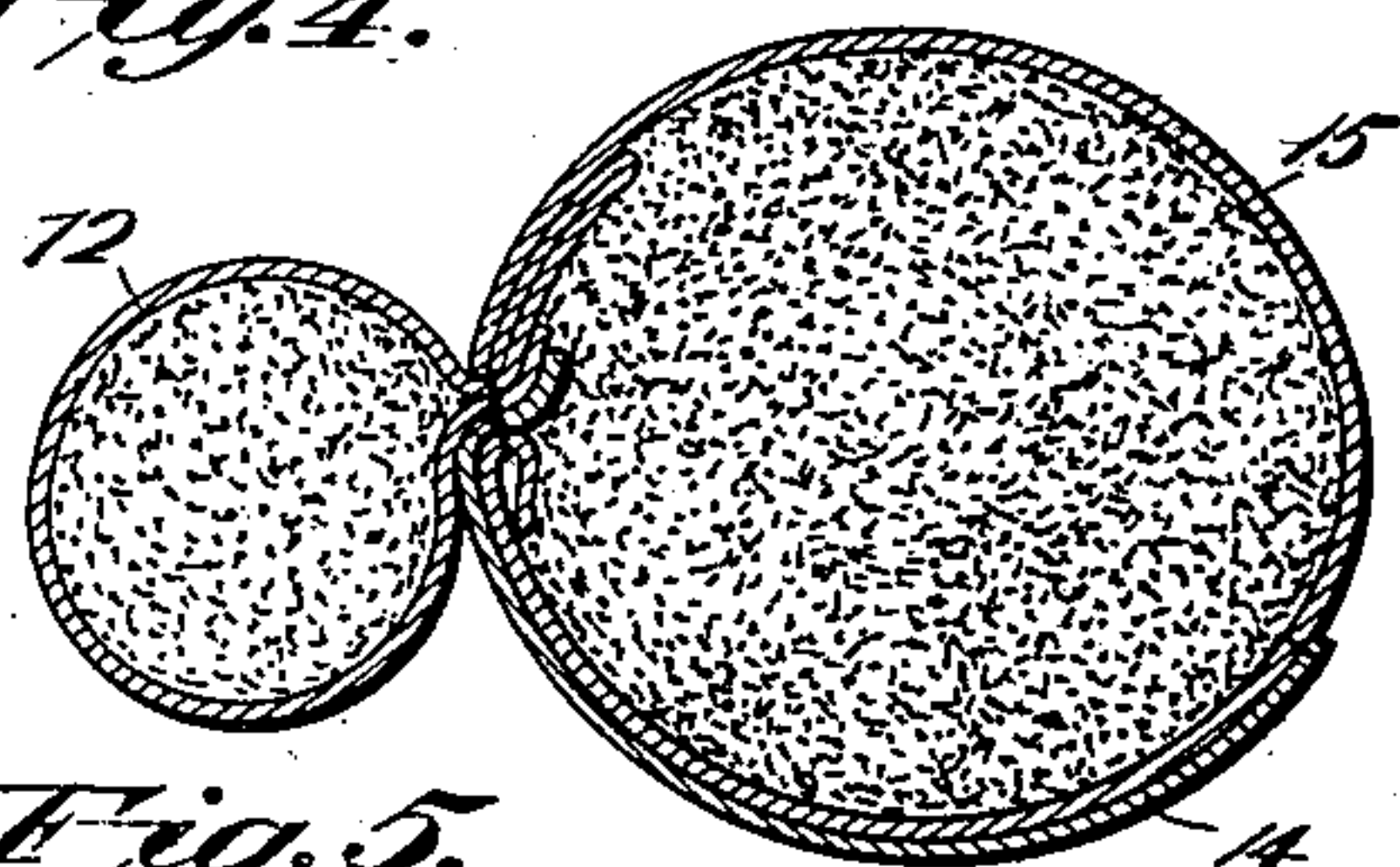
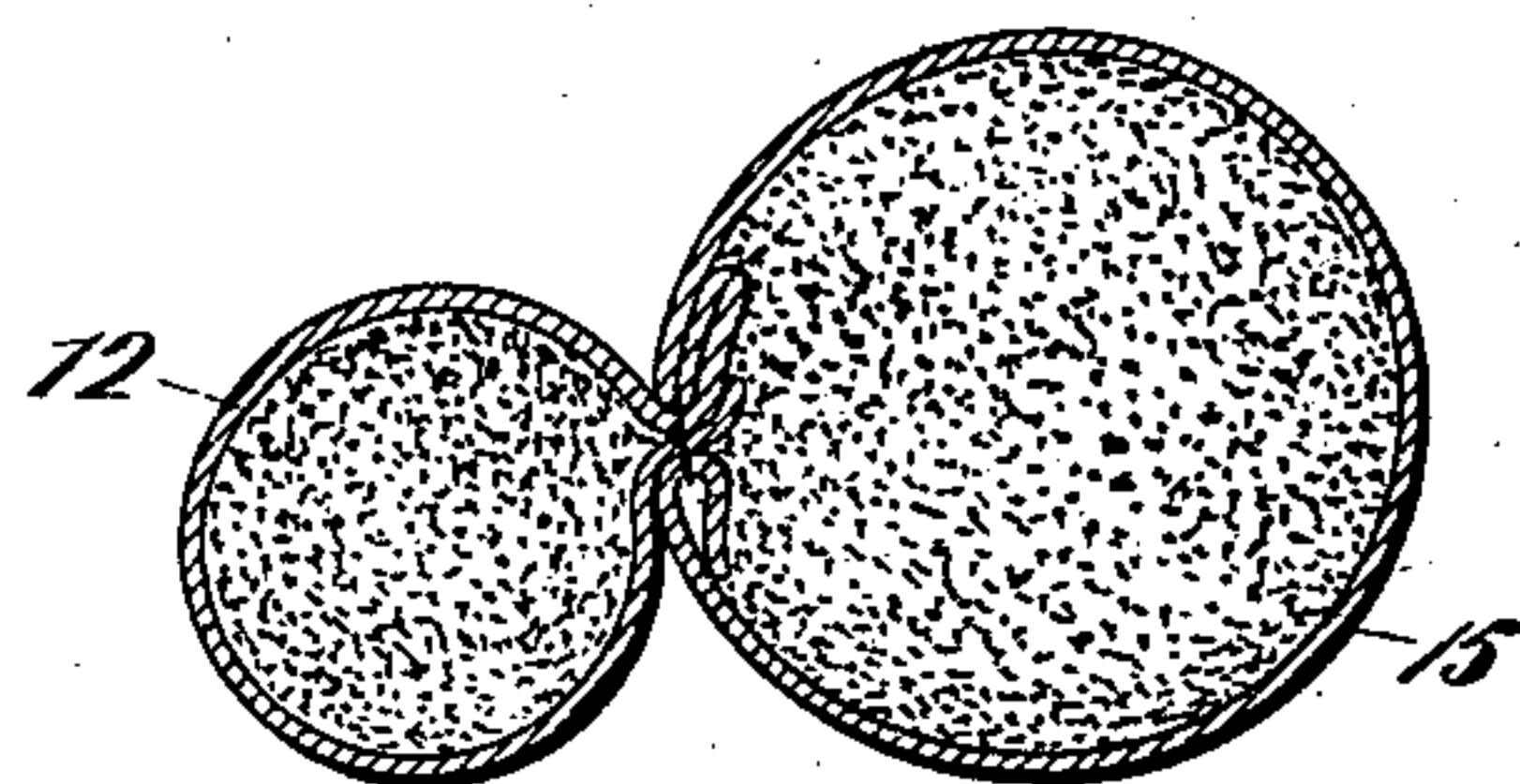
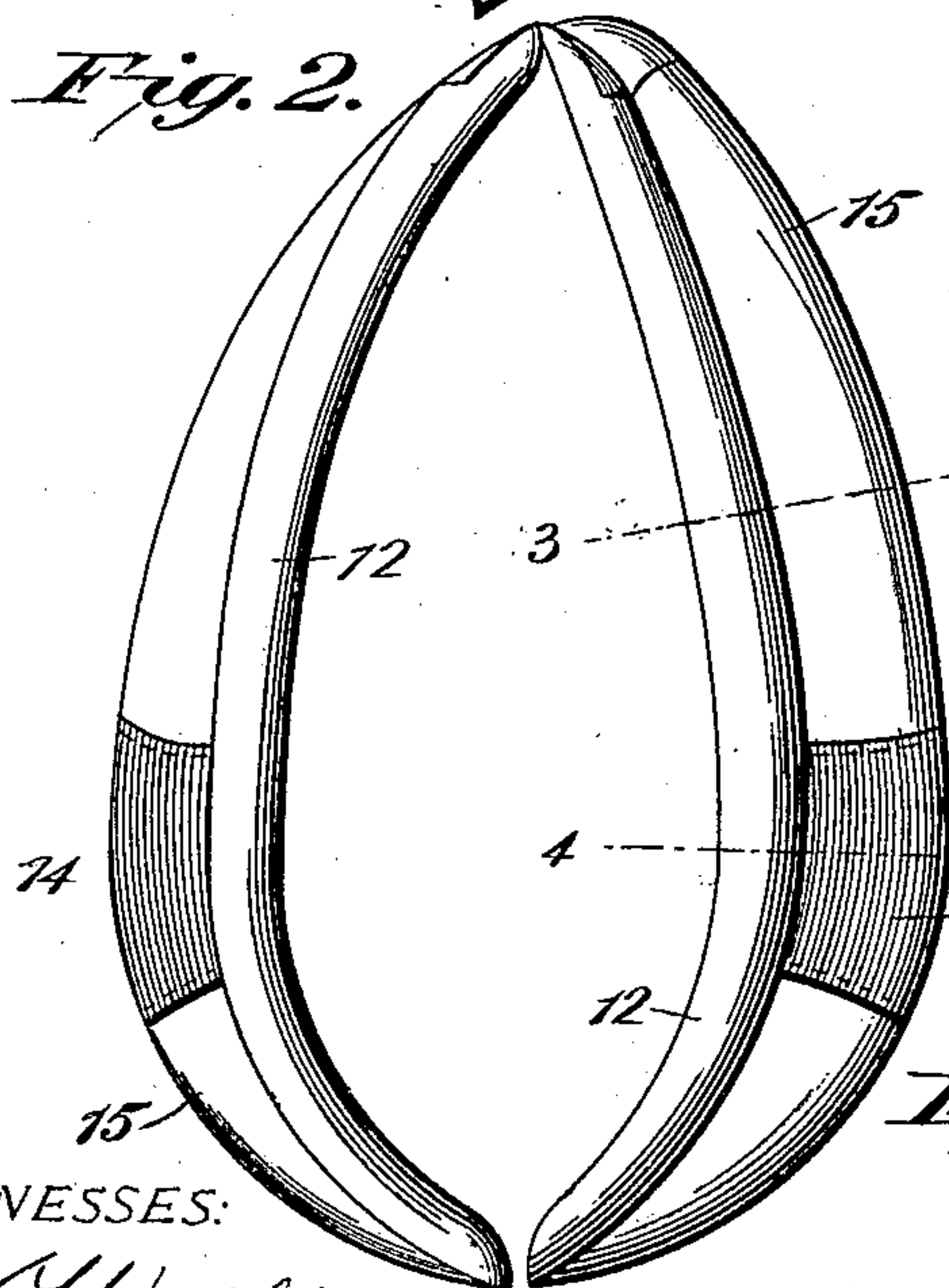
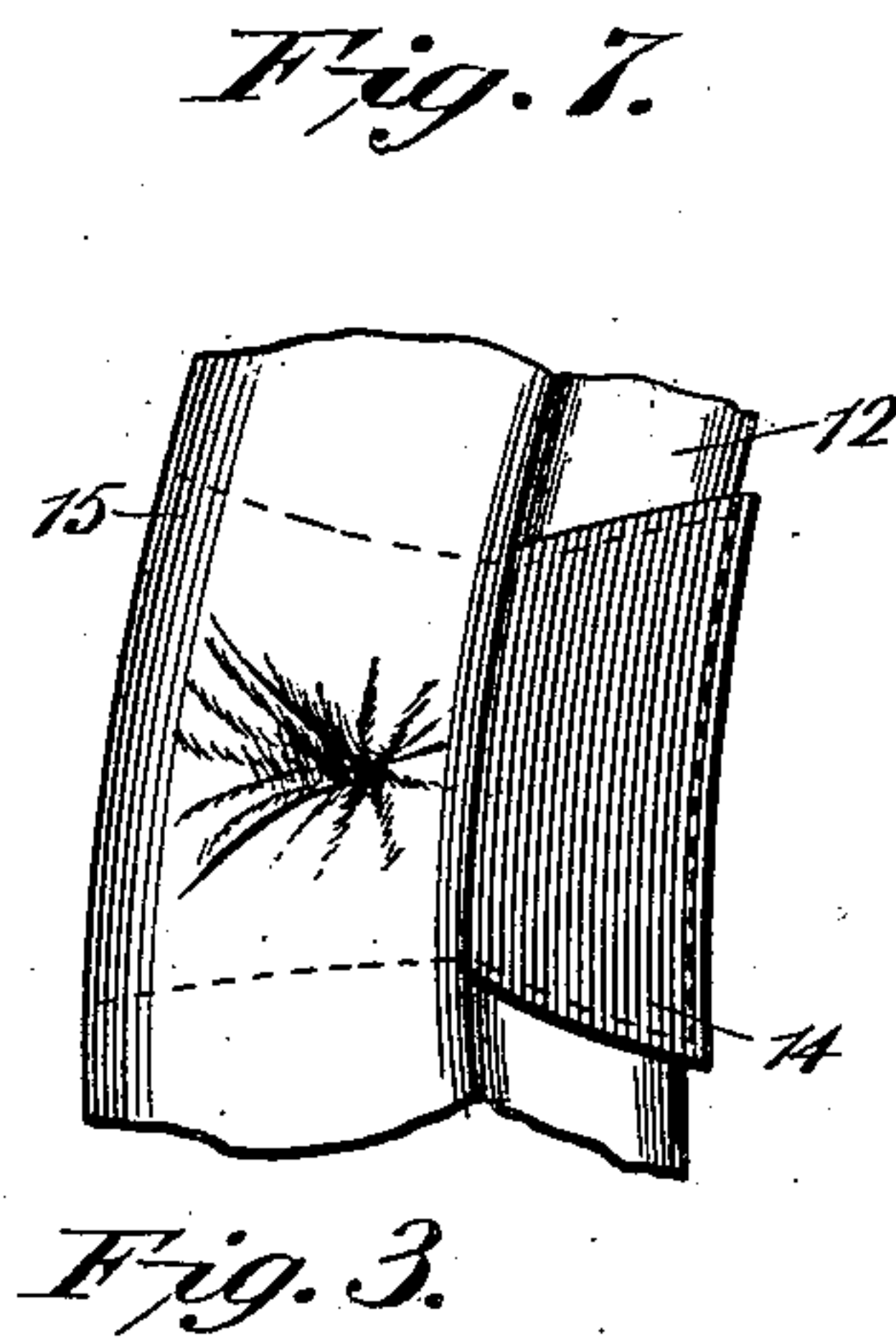
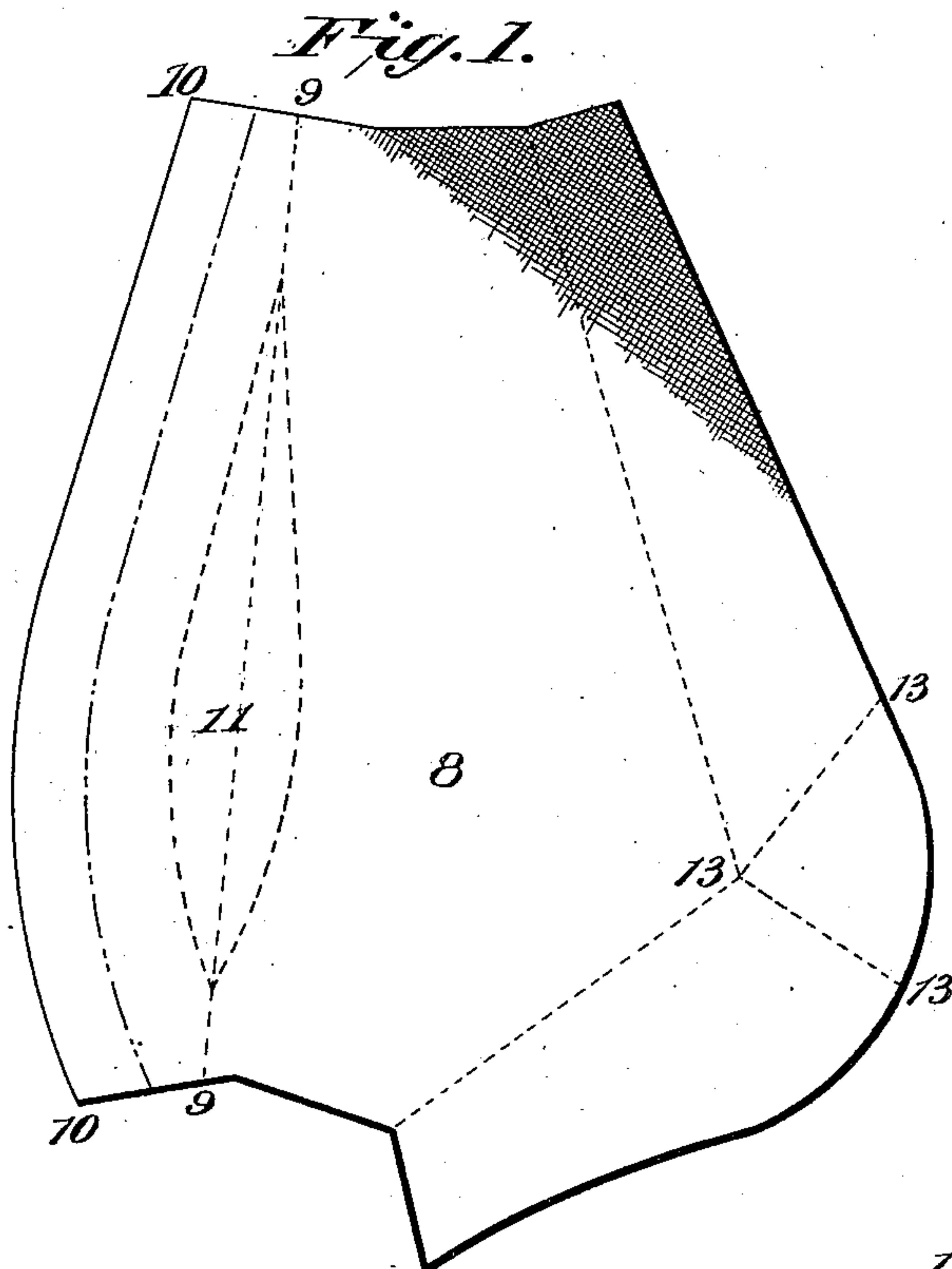
No. 689,273.

W. O. BARNETT.
HORSE COLLAR.

Patented Dec. 17, 1901.

(Application filed Aug. 8, 1901.)

(No Model.)



WITNESSES:

C. C. Walker,
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UNITED STATES PATENT OFFICE.

WILLIAM OSBORNE BARNETT, OF AMERICUS, GEORGIA.

HORSE-COLLAR.

SPECIFICATION forming part of Letters Patent No. 689,273, dated December 17, 1901.

Original application filed May 17, 1900, Serial No. 17,005. Divided and this application filed August 8, 1901. Serial No. 71,330. (No model.)

To all whom it may concern:

Be it known that I, WILLIAM OSBORNE BARNETT, a citizen of the United States, residing at Americus, in the county of Sumter and State of Georgia, have invented new and useful Improvements in Horse-Collars, of which the following is a specification.

This invention is a division of the application for patent filed by me on May 17, 1900, and the same relates to certain new and useful improvements in horse-collars, the object of the invention being to provide a horse-collar in which each section or side of the collar can be manufactured from a single piece of properly-shaped material, the edges of each section being connected by a single invisible and protected seam located within the after-wale, said seam with the material forming the fore and after wales, as will hereinafter more fully appear.

In the accompanying drawings, which illustrate one embodiment of my invention, Figure 1 is a view of a blank or piece of material from which one of the side sections of the collar is made. Fig. 2 is a perspective view of a collar made in accord with my improvements. Figs. 3 and 4 are sectional views taken on the line 3 3 and 4 4 of Fig. 2. Fig. 5 is a diagram or sectional view showing the manner of folding the blank to stitch or indicate a dart. Fig. 6 is a similar view showing the blank folded and connected by a line of stitching, and Fig. 7 is a detail view showing the wear-piece of the collar partially ripped or separated from the after-wale.

In the manufacture of a horse-collar in accord with my invention two pieces of flexible material of like shape are used, and in making a complete collar it is only necessary for the cutter to have one pattern to form the blank. The pattern may be of cardboard, sheet metal, or other material, having a margin of the requisite shape and perforations through which the material can be marked to indicate where the blank should be folded and stitched.

In Fig. 1 of the drawings I have shown a piece of material or blank, which may be leather, canvas, duck, or other textile fabric, and when fabric is used I prefer to cut the same so that the weft and warp will be

bias to the length of the collar, which prevents to a great extent the completed collar stretching besides rendering the same more easily manipulated at the points where the fabric is puckered or gathered in.

A piece of flexible material or blank 8 (shown by Fig. 1) is folded on the dotted line 9 9, and after being folded, as shown in Fig. 5, it may be basted or stitched parallel with the edge 10 10, which forms in the blank a dart 11. The material on one side of the dart will eventually form the fore-wale 12. From the opposite side of the blank 8 there is removed an angular piece of material, the line of severance being indicated by the dotted lines 13 13, and when the edges formed by the cutting out of the angular piece are overlapped the length of the edge on one side of the blank will be approximately the same as on the other side. To one side of the blank, so as to cover the portion which is gathered or puckered, there is stitched a wear-piece 14, which wear-piece in the completed collar will be opposite or beneath the hame-eye. By this construction all the gathered portions of the fabric in the after-wale are at the front and beneath the leather wear-piece. The narrow edge of said wear-piece being on a line with the margin of the blank holds the folded and puckered portion in place for final stitching.

Fig. 6 of the drawings shows the manner in which the blank, with the wear-piece attached thereto, is folded prior to being connected by a line of stitching. In this figure the part which forms the fore-wale 12 is folded so that its edge will lie along the marks or line of stitching which indicates or forms the dart 11, the fabric being folded on the line 9 9. This provides a fore-wale which is substantially the same diameter throughout its length, though slightly reduced at its ends. The edge of the blank or fabric when formed into a collar lies within the after-wale, as shown in Figs. 3 and 4, and all the puckers are on the front side of the wale, where they are engaged by the hame, so that only the smooth portions of the collar will engage with the neck or shoulders of the horse. Again, referring to Fig. 6, it will be observed that the fore-wale or the pouch

which eventually forms the same lies within the pouch which forms the after-wale 15 and to which pouch the wear-piece 14 is attached. The part which forms the after-wale extends from the fold 9 about and over the fore-wale 12, so that the edge of the wear-piece and the part to which it is attached will be on a line and immediately above the inner edge of the fore-wale, so that the parts can be connected by a single line of stitching, which may be paralleled by another line of stitching to give greater strength, if desired.

After the blank or pouches are stitched from end to end the pouch which forms the after-wale and overlies the fore-wale is turned inside out or reversed, which operation locates the parts which form the dart 11, one edge of the wear-piece 14, the edges of the material, and the folds or puckers beneath the wear-piece all within the after-wale. The outer or surface loops of the stitches will be protected by one of the edges of the fabric and by the part which is taken up to form the dart, so that in stuffing the collar there will be no liability of injuring the stitching by the packing-rod or rammer used with the stuffing-machine. Another advantage is that if the blank is of leather or fabric where one side differs from the other the finished side or face will be outward, so that both wales will have the same appearance or finish. When one end of the pouches has been closed by stitching, they are ready to be passed to the stuffing-machine.

In the manufacture of collars made up in accord with my invention they may be stuffed with any suitable material. The weft and warp of the fabric are placed diagonal to the length of the collar to obviate stretching, and the blanks for each collar-section are connected by a longitudinal seam which will be invisible and protected in the made-up collar, and such a collar as I have shown and described may be made up without the use of any new appliances and the blank may be stitched either by hand or machine.

Having thus described my invention, what I claim as new, and desire to secure by Letters Patent, is—

1. A section of a horse-collar in which a one-piece or integral blank is united by stitches to form the wales, the stitches in the completed collar being within one of the wales.

2. As an improved article of manufacture, a section of a horse-collar made up from a single one-piece blank which is connected by a line or lines of stitches the stitches being located entirely within one of the wales of the collar-section.

3. As an improved article of manufacture, a horse-collar section which is made up from a blank which is folded and stitched to form a dart and shape the wales, the edges of the dart and the wales being connected by a single line of stitches, substantially as shown.

4. As an improved article of manufacture,

a horse-collar section made up from a one-piece blank of fabric the weft and warp thereof being bias to its length, the blank being united by a single longitudinal seam located within the larger wale of the collar-section, substantially as shown and for the purpose set forth.

5. A section of a horse-collar made up from a single integral blank which is connected by a line of stitching to provide fore and after wales, the surface loops of the stitches being within one of the wales and protected by overlying parts of the blank, the same being invisible in the made-up collar-section.

6. A section of a horse-collar made up from a single integral blank from which an angular piece has been removed, the blank being gathered adjacent to the part from which the angular piece was taken, a wear-piece attached to the blank to cover the gathered-in portion thereof, a curved line of stitches which connect the longitudinal edges of the blank and also divides the blank into fore and after wales, one wale being within the other, the larger wale being turned inside out prior to stuffing, substantially as set forth.

7. A section of a horse-collar consisting of a single piece of material which is folded upon itself to provide an intumed portion, the parts being united by a curved line of stitches which connects the blank to provide fore and after wales, the material forming the after-wale being shaped and puckered adjacent to its larger portion to impart a curved form to such wale when stuffed.

8. The herein-described section of a horse-collar made from a single piece of properly-shaped material or blank which has within its margin a dart, the edges of the material being connected by a line of stitches, one of the wales being turned so that in the completed collar-section the seam will be located within said turned wale.

9. A section of a horse-collar made from a one-piece blank having curved edges, a dart formed near that portion of the blank which forms the fore-wale, an angular incision on the opposite side of the blank from the fore-wale, the material adjacent to the incision being gathered in and retained by a wear-piece which is attached thereto, the edges of the blank and sides of the dart being connected by a single line of stitching.

10. A section of a horse-collar made up from a one-piece or integral blank which is folded so that the part which subsequently forms the fore-wale will be within the part which forms the after-wale, a line of stitches which pass through the folded blank to connect the edges of the blank and form the wales, one of the wales being turned inside out prior to being filled.

11. A horse-collar section made up from a blank which is folded so that a part which forms one wale will be within a part which forms the other wale, a line of stitches uniting the blank and forming the wales, the stitches

being passed through the opposite edges of the blank and through a fold of two thicknesses of the same, the larger wale being turned inside out to locate the stitches within said larger wale, for the purpose set forth.

12. A section of a horse-collar made from a single piece of material or integral blank which presents side edges of different configurations, one of the side edges being longer than the other, the longer side edge having removed therefrom a part to render the side edges of substantially the same length, a dart formed between the ends of the blank, one

side of the dart following the contour of one side of the blank, and a wear or covering piece attached to the blank to cover the part thereof from which a portion has been removed, substantially as set forth.

In testimony whereof I have hereunto set my hand in presence of two subscribing witnesses.

WILLIAM OSBORNE BARNETT.

Witnesses:

W. T. STANFIELD,

T. F. GATEWOOD.