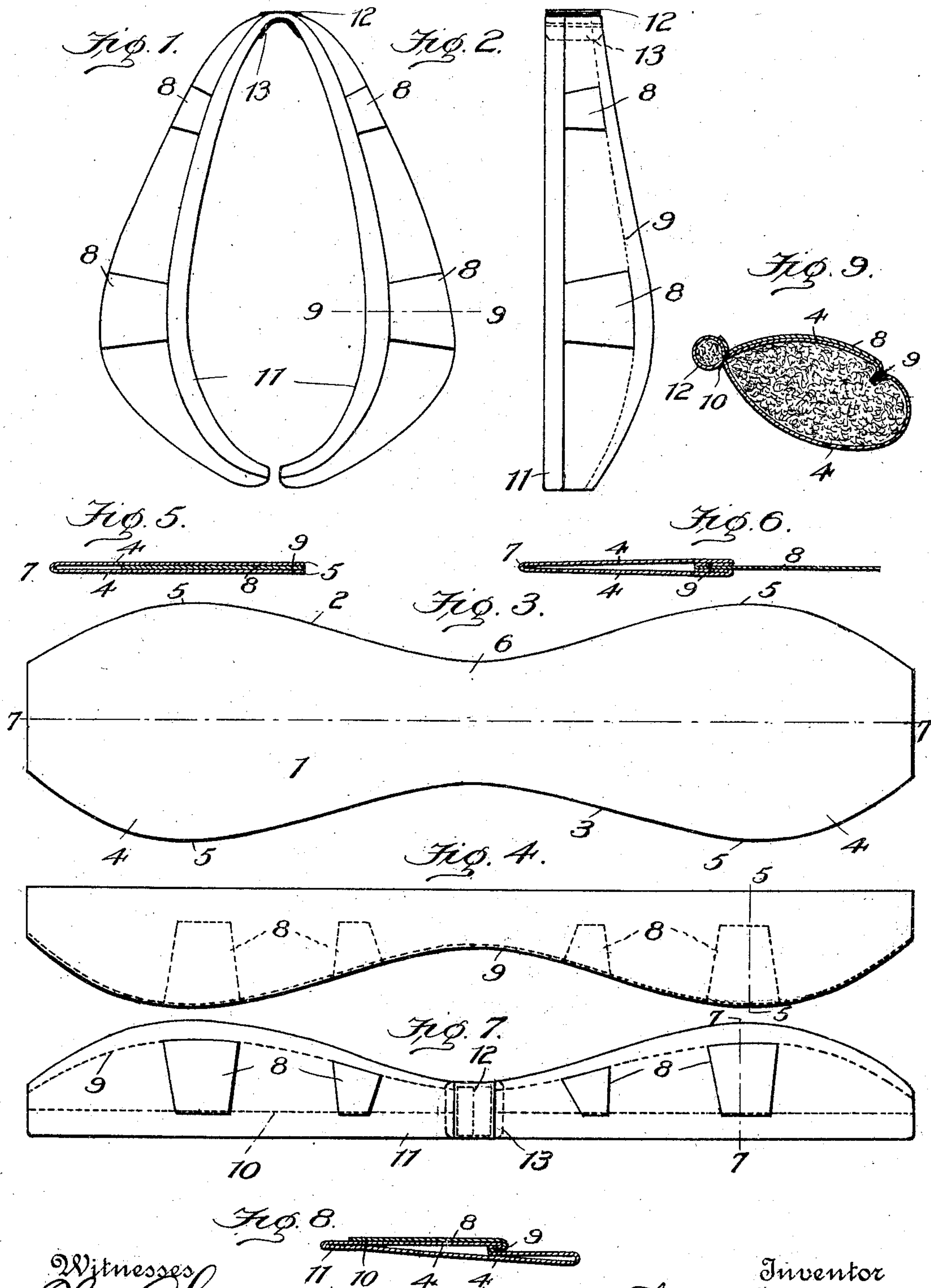


No. 788,412.

PATENTED APR. 25, 1905.

T. R. MASSEY.
METHOD OF MAKING HORSE COLLARS.
APPLICATION FILED AUG. 8, 1904.



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UNITED STATES PATENT OFFICE.

THOMAS RILEY MASSEY, OF ATLANTA, GEORGIA.

METHOD OF MAKING HORSE-COLLARS.

SPECIFICATION forming part of Letters Patent No. 788,412, dated April 25, 1905.

Application filed August 8, 1904. Serial No. 219,893.

To all whom it may concern:

Be it known that I, THOMAS RILEY MASSEY, a citizen of the United States, residing at Atlanta, in the county of Fulton and State of Georgia, have invented new and useful Improvements in Methods of Making Horse-Collars, of which the following is a specification.

My invention relates to new and useful improvements in the method of making horse-collars; and the objects are, first, to produce a collar manufactured of leather or fabric which will be extremely simple in construction and which may be produced at less expense than those now generally in use; second, to produce a collar the body or casing of which may be made from a single piece of material; third, to manufacture the collar by a method embodying a minimum of necessary steps which will permit the collar to be made at a reduction of expense, labor, and waste of material.

In the drawings forming a part of this specification I have fully and clearly illustrated the completed article embodying my invention and also indicated the steps by which it is produced.

In said drawings, Figure 1 is a view in front elevation of a collar constructed in accordance with my invention and ready for use. Fig. 2 is a view in side elevation of the shell or casing of the collar previously to stuffing the same. Fig. 3 is a plan view of the blank from which the shell or casing of the collar is formed. Fig. 4 is a plan view of the shell as formed and stitched previously to turning the same and also showing the wear-pieces in dotted lines. Fig. 5 is a section on the line 5 5 of Fig. 4. Fig. 6 is a section on the line 5 5 of Fig. 4 after the shell has been turned. Fig. 7 is a plan view of the shell or casing as completed and ready to be stuffed with the desired packing material. Fig. 8 is a section on the line 7 7 of Fig. 7, showing the manner in which the shell is rolled to present enlarged wear-surface to the neck of the animal and of stitching the wear-pieces in place; and Fig. 9 is a section on the line 9 9 of Fig. 1.

Referring to the drawings, 1 designates a blank of any desired flexible material, from which the casing of the collar is made, said

blank being cut on its longitudinal side edges to form the compound-curved lines 2 3, said blank being thus made to constitute oppositely-disposed enlarged end portions 4 4, having opposite convex-curved sides, as shown at 5, which taper gradually from a point substantially at the center of said enlarged portions toward the center of the blank, where said portions join each other in a reduced or narrow central section 6, said convex curves also tapering from their central points toward the extreme ends of the blank, as clearly shown in Fig. 3.

The blank having been cut, as above described, is then folded on its central longitudinal axis, as at 7, the parts of the blank on opposite sides of the line of fold being brought face to face with the outer curved edges of the respective wings 4 4 on the opposite sides of the fold-line in coincidence with each other. Suitable leather wear-pieces or strengthening-strips 8 of any desired shape are then inserted between the flaps of the blank, one end of each of said strips being laid closely adjacent the curved edges of the wings 4, and a line of stitches 9 is then run down the meeting curved edges to secure the folds together, said stitches being also carried across the ends of the wear pieces or strips 7, whereby said pieces are secured in position between the meeting curved edges of the blank. Two of these wear-pieces are shown as located between the curved edges of each wing, said pieces being so placed as to come under the loggerheads of the hames when the latter are arranged in position on the collar. It is obvious, however, that a greater or less number of these wear-pieces may be employed, as may be required.

By folding the blank as shown and described a tubular body is formed, constituting the casing or shell of the collar and consisting of two enlarged end or belly portions, each of which is bounded on one side by a convex-curved edge, which edges taper toward the center of the body to form a central reduced portion, which constitutes the crown of the collar, and the opposite sides of said enlarged or belly portions are formed on one continuous straight line coinciding with

the fold-line 7, heretofore mentioned, all substantially as shown in Fig. 4. The tubular body, as just described, is then turned inside out and this step, it will be seen, brings the seams and exposed edges of the blank on the inside of the collar and the wear-pieces 8 on the outside of said body, one end of each of said pieces being held in place by the stitch-line 9 and the other ends thereof being free and projecting outwardly from the body, as shown in Fig. 6. The wear-pieces are then turned over and down onto the surface of the belly portions, so that they extend across said portions and reinforce the same at the points desired. Then in order to have a broad smooth surface on the face of the collar, which protects the horse's neck, and to give the collar the proper contour to be of a good fit the tubular body is rolled transversely of its longitudinal axis until the under face of the collar, or that face which contacts the neck of the animal, becomes of greater width than the front face of the collar, as shown in Fig. 8, and a line of stitching 10 is then run down the straight edge of the collar-body, said line of stitching uniting the side of the belly portions, thus forming the edge rim of the collar and maintaining the same in its rolled position, also traversing the free ends of the wear-pieces 7 to securely fasten them in position on the collar. Leather protective pads 12 13 are then stitched on the opposite faces of the reduced portion of the collar-body, and said body is then stuffed with any of the well-known materials utilized for this purpose and having been stuffed is then bent at the reduced portion to assume the completed form, as shown in elevation in Fig. 1 and in cross-section in Fig. 9.

40 What I claim is—

1. The process of manufacturing a horse-collar, which consists in first taking a blank having its longitudinal edges cut on similar compound-curved lines to provide a blank having enlarged end portions united by a reduced intermediate portion, then folding the blank to bring the curved edges into coincidence, inserting wear-pieces between the folds, running a line of stitches along said curved edges and across the wear-pieces, turning the tubular body thus formed to bring the wear-pieces outside thereof, and running a line of stitches lengthwise of the collar and across the free ends of the wear-pieces to form the rim and secure said wear-pieces in place, and finally filling the tubular body.

2. The process of manufacturing a horse-collar, which consists in first taking a blank

having its longitudinal edges cut on proper curves, to provide a blank having enlarged end portions united by a central reduced portion, folding said blank to bring the curved edges together, inserting wear-pieces between the folds, running a line of stitches along said curved edges and across one end of the wear-pieces, turning the tubular body thus formed to bring the wear-pieces outside thereof, running a line of stitches down the body parallel to the straight side thereof to form the rim portion, stitching the free ends of the wear-pieces in place, and finally filling the body.

3. The process of manufacturing a horse-collar, which consists in first taking a blank having its longitudinal edges cut on proper curves to provide a blank having enlarged end portions united by a central reduced portion, folding said blank to bring the curved edges together, inserting wear-pieces between the folds, running a line of stitches along said curved edges and across one end of the wear-pieces, turning the tubular body thus formed to bring the wear-pieces outside thereof, rolling the body to provide an enlarged bearing-surface, running a line of stitches down the body parallel to the straight edge thereof to maintain the body in rolled position and to form the rim portion, stitching the free ends of the wear-pieces in place and finally filling the body.

4. The process of manufacturing a horse-collar, which consists in first taking a blank having its longitudinal edges cut on proper curves to provide a blank having enlarged end portions united by a central reduced portion, folding said blank to bring the curved edges together, inserting wear-pieces between the folds, running a line of stitches along said curved edges and across one end of the wear-pieces, turning the tubular body thus formed to bring the wear-pieces outside thereof, rolling the body to provide an enlarged bearing-surface, running a line of stitches down the body parallel to the straight edge thereof and across the free ends of the wear-pieces to maintain the body in its rolled position to form the rim and to secure the free ends of the wear-pieces in place, and finally filling the body.

In testimony whereof I have signed my name to this specification in the presence of two subscribing witnesses.

THOMAS RILEY MASSEY.

Witnesses:

BEN. A. MASSEY,
J. P. MINER.