

No. 814,596.

PATENTED MAR. 6, 1906.

W. B. ESTES.
HORSE COLLAR.

APPLICATION FILED FEB. 3, 1906.

3 SHEETS—SHEET 1.

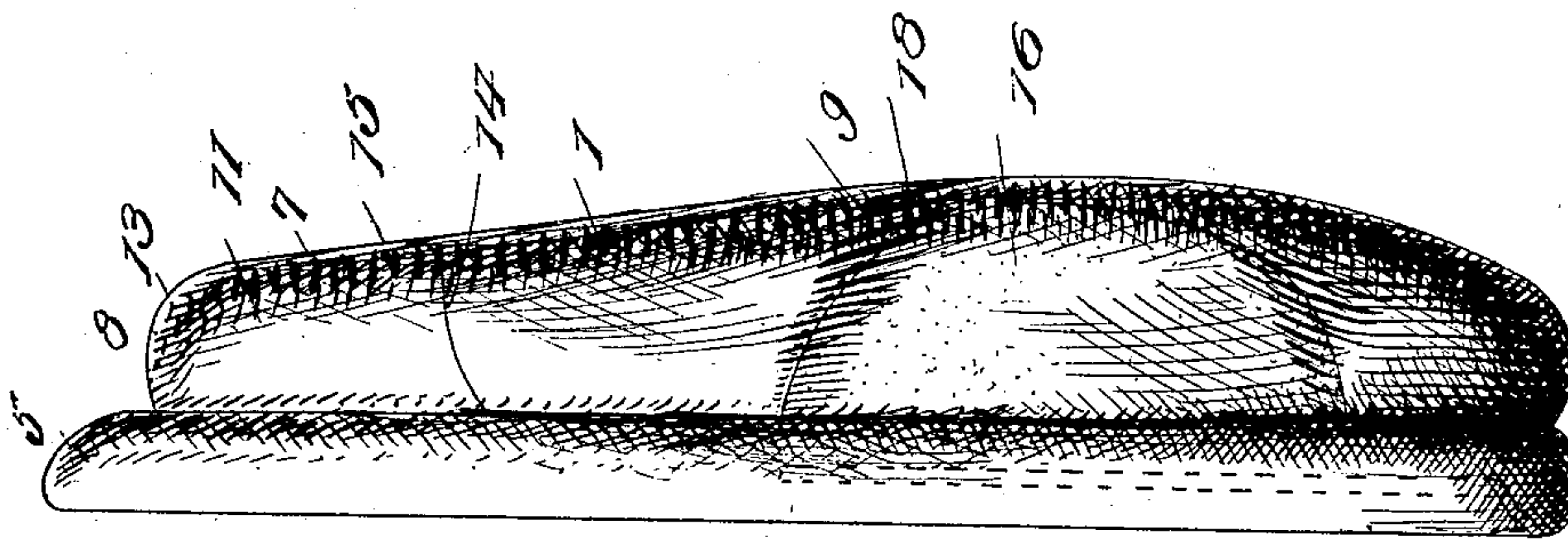


Fig. 2.

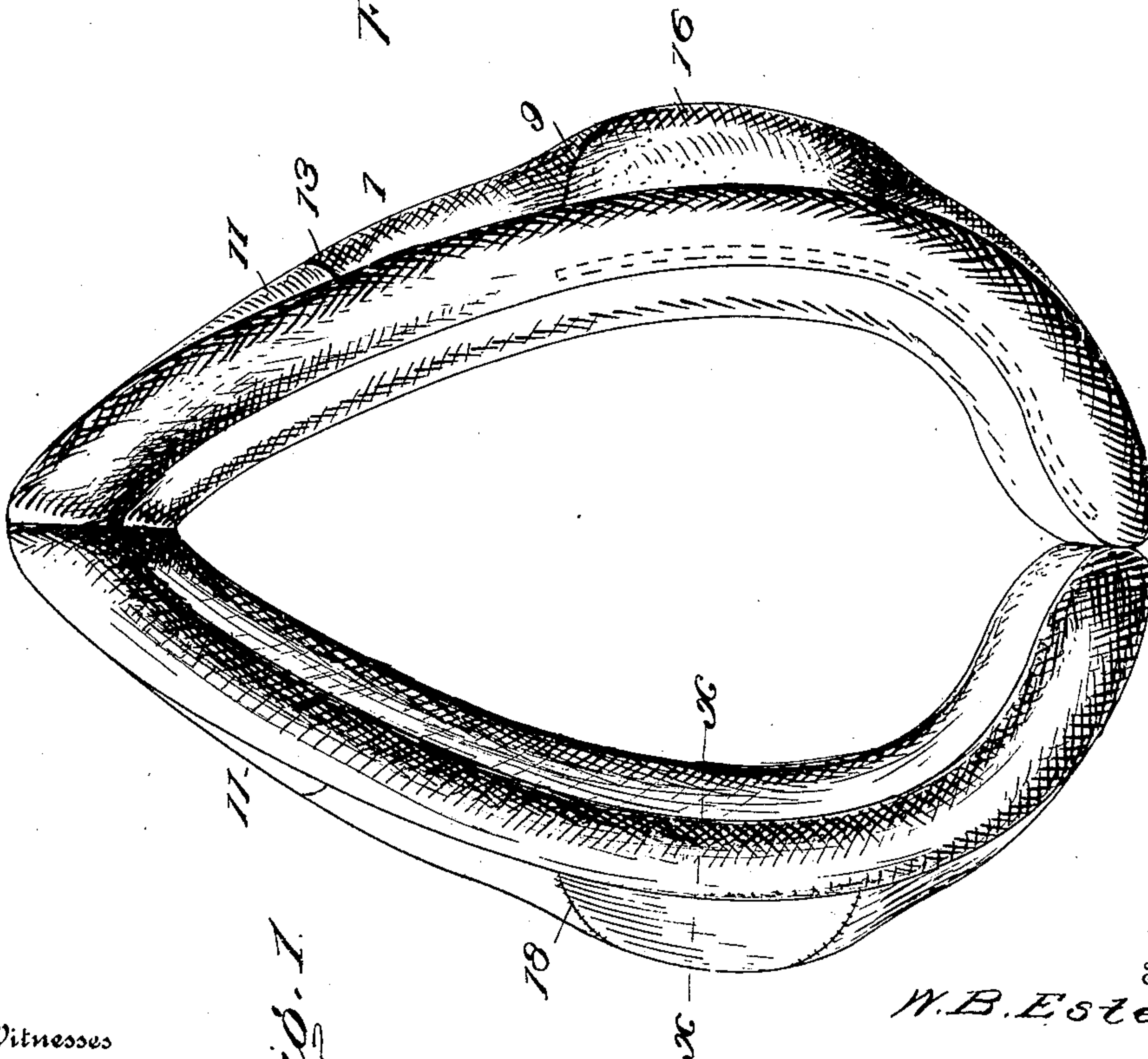


Fig. 1.

Witnesses

Louis H. Schmidt

A. P. Williams

Inventor

W. B. Estes

By

[Signature]

Attorney

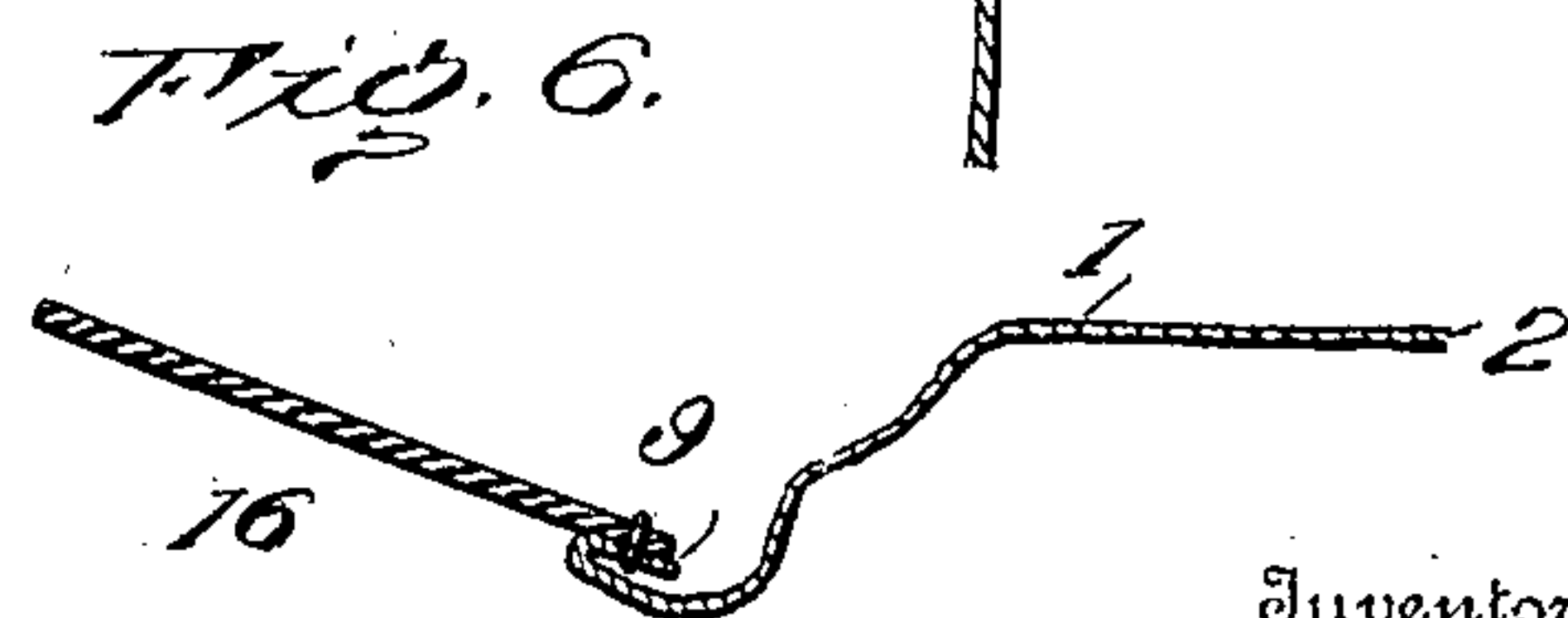
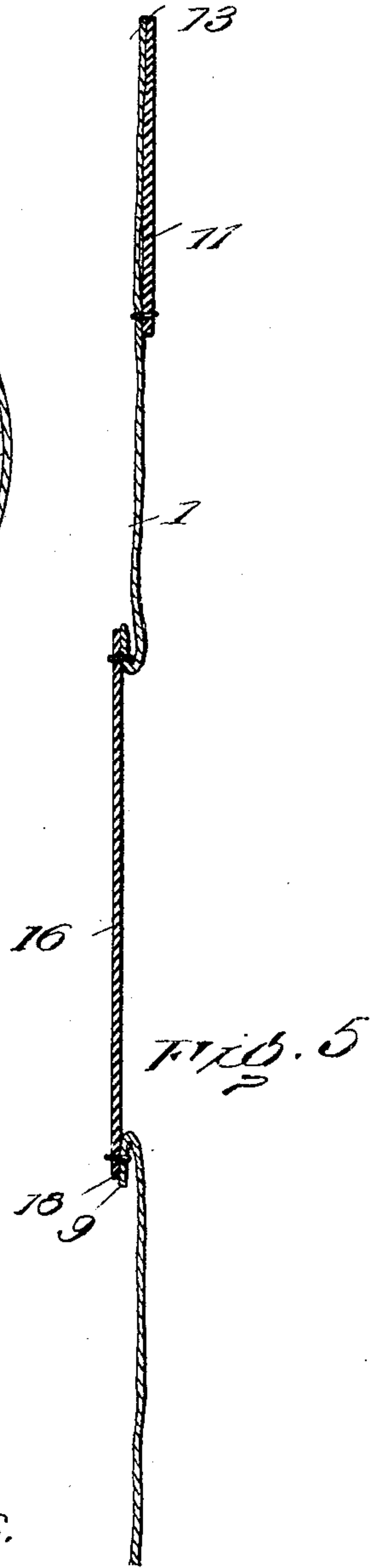
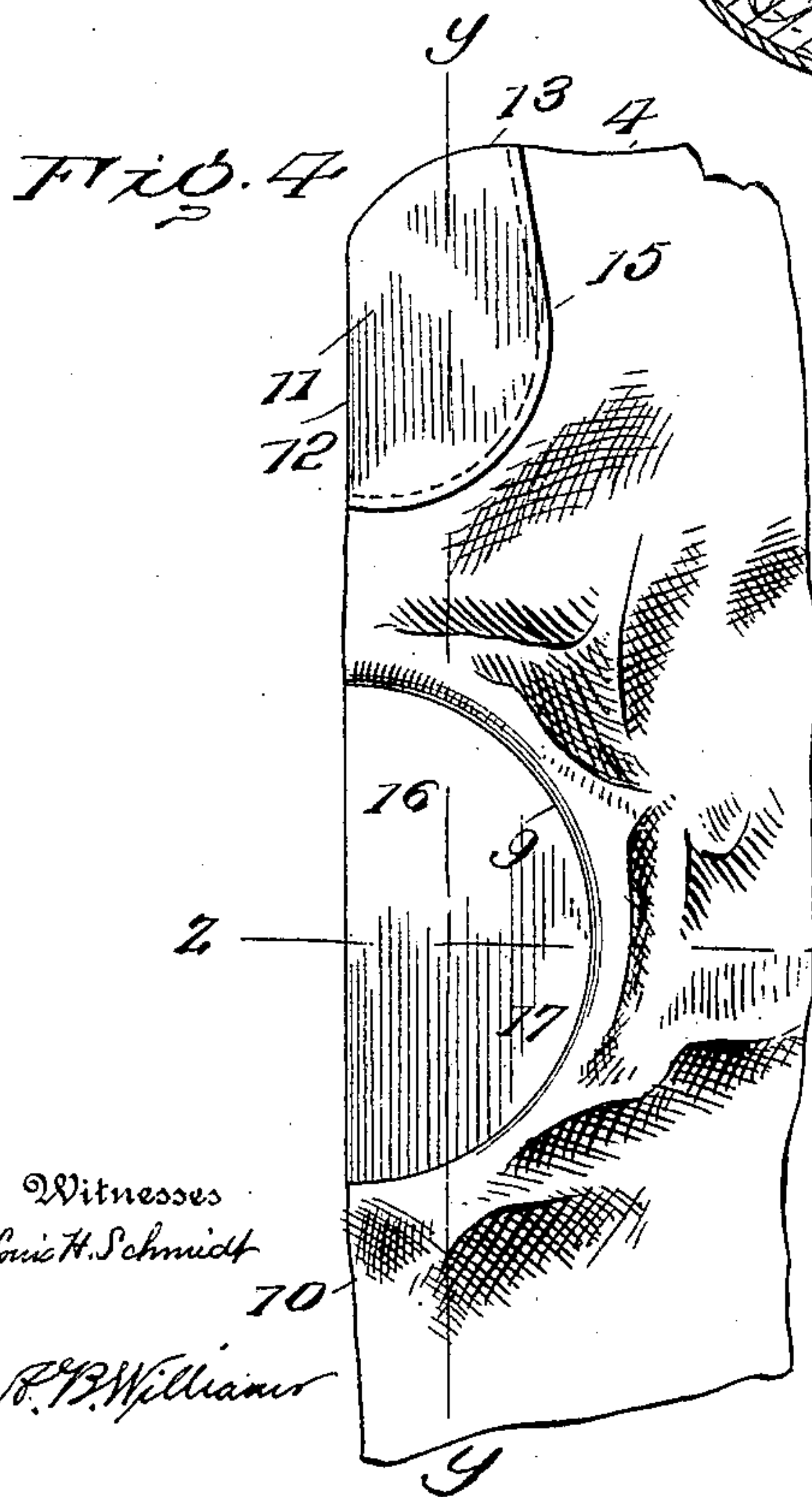
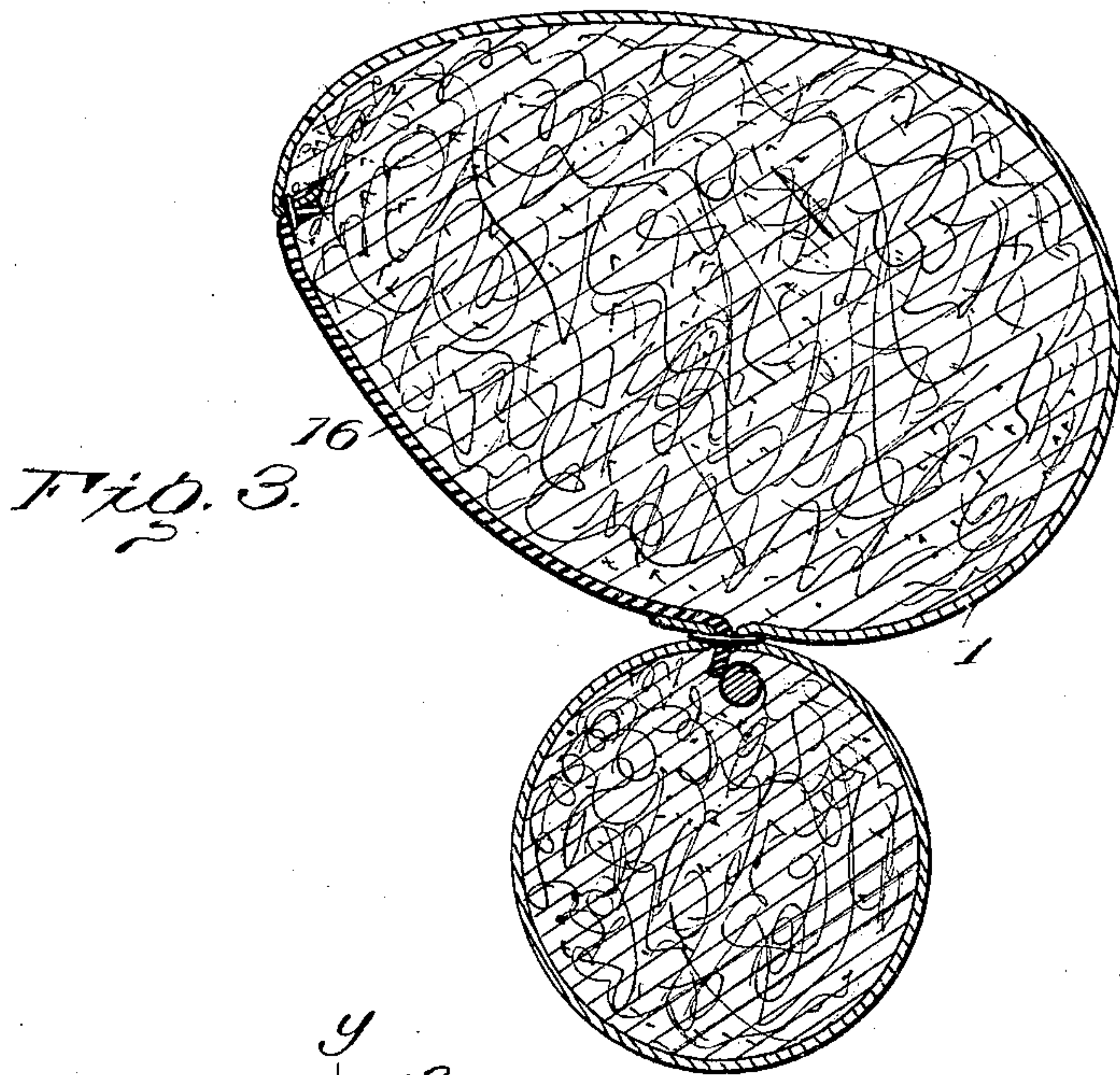
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3 SHEETS—SHEET 2.



Witnesses
Louis H. Schmidt
R. B. Williams

Inventor
W. B. Estes

per Minnie
Attorney

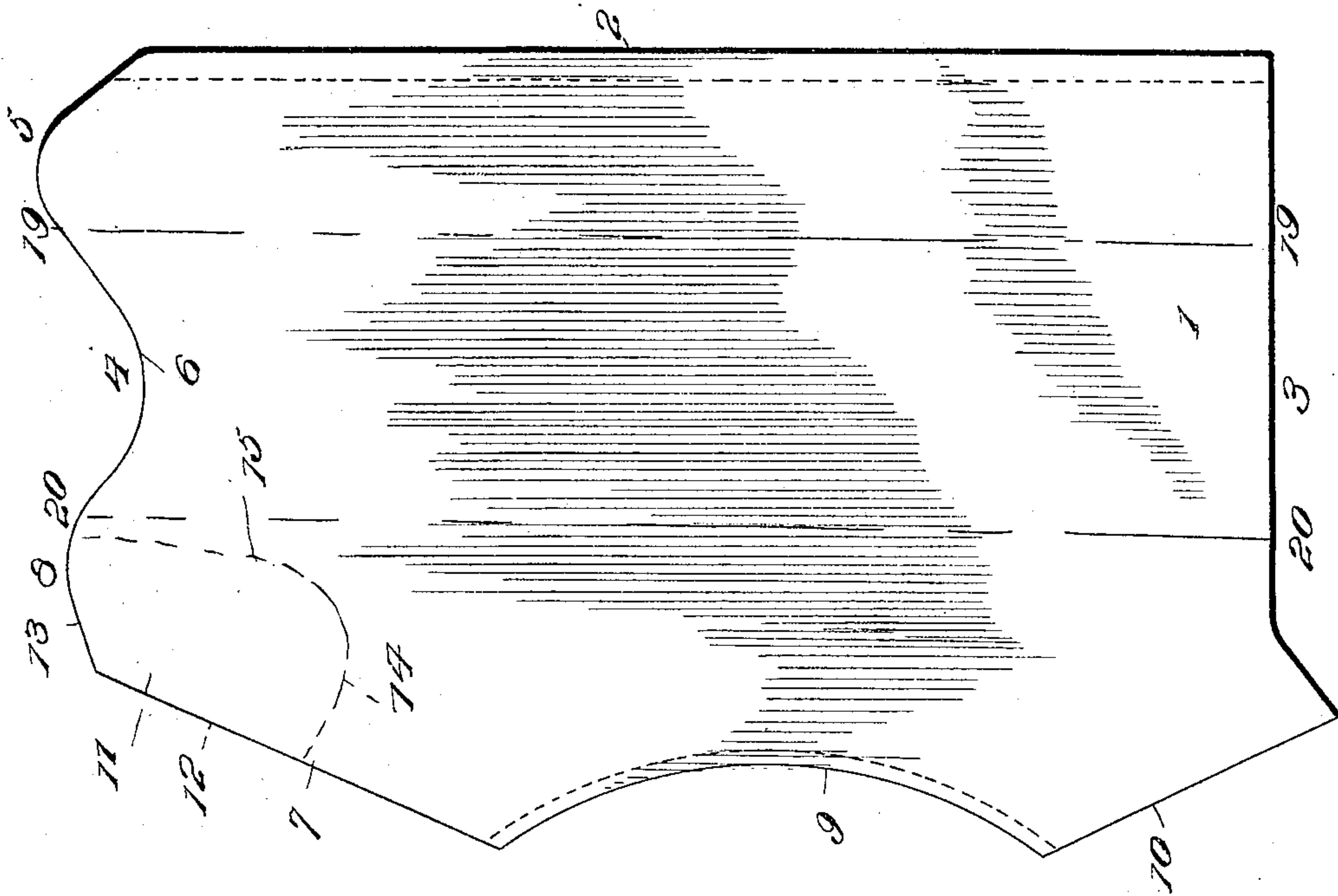
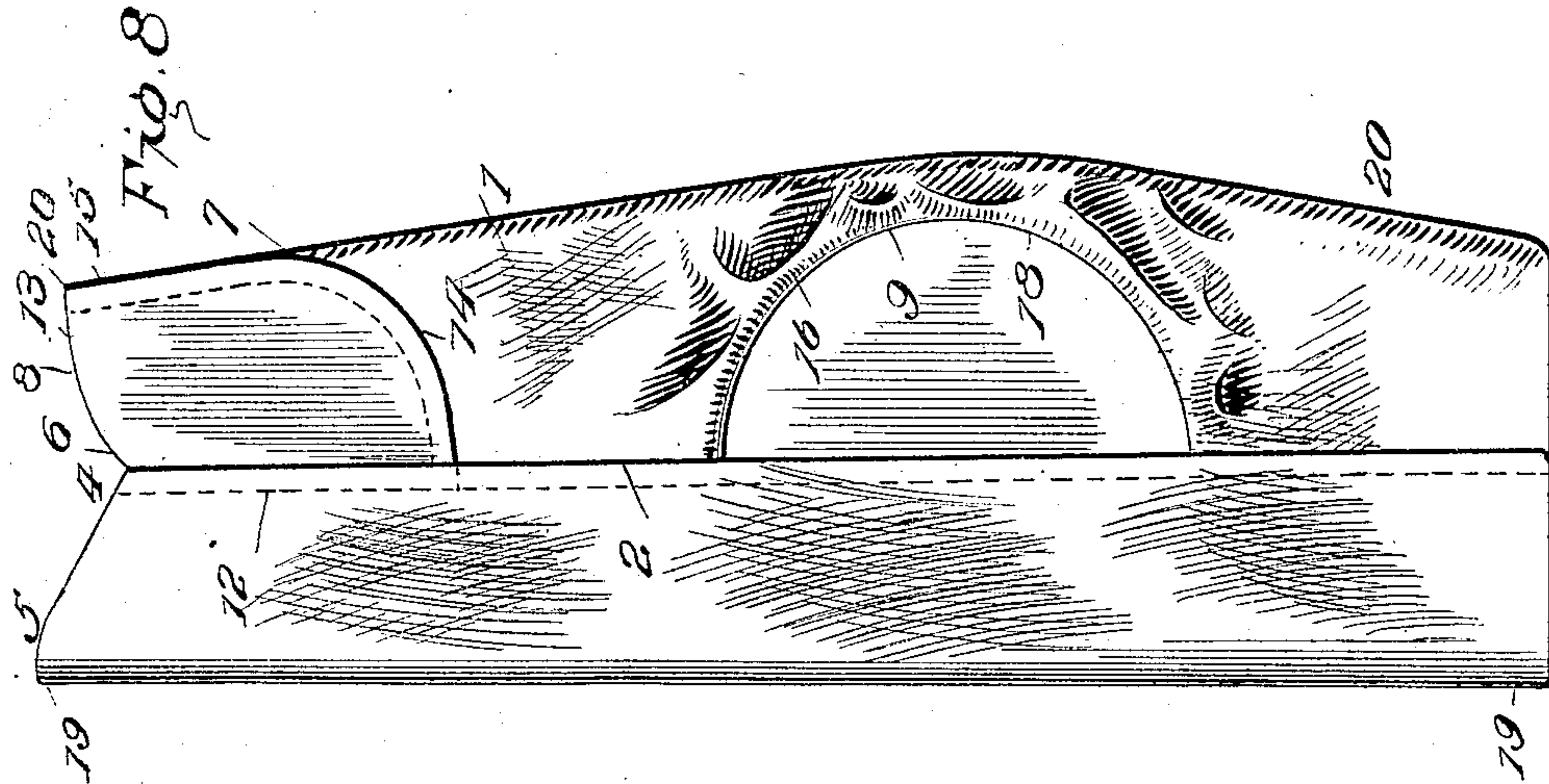
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3 SHEETS—SHEET 3.



Witnesses

Louis H. Schmidt,

R. P. Williams

Inventor

W. B. Estes

By

J. M. Munn
Attorney

UNITED STATES PATENT OFFICE.

WILLIAM B. ESTES, OF ATLANTA, GEORGIA, ASSIGNOR, BY DIRECT AND MESNE ASSIGNMENTS, TO ATLANTA HORSE COLLAR COMPANY, OF ATLANTA, GEORGIA.

HORSE-COLLAR.

No. 814,596.

Specification of Letters Patent.

Patented March 6, 1906.

Application filed February 3, 1905. Serial No. 244,002.

To all whom it may concern:

Be it known that I, WILLIAM B. ESTES, 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 Horse-Collars, of which the following is a specification.

My invention relates to an improvement in the manufacture of horse-collars.

10 The main object of the invention is to construct a substantial collar with less sewing and cutting than heretofore without in the least detracting from the strength, durability, or appearance of the resultant article.

15 A further object of the invention is to utilize certain leather portion or insets which are adapted in the finished collar to provide wearing-pieces, the assembling of said insets in the collar being such as to form the necessary bend without undue fullness or wrinkles.

20 The invention in its preferred embodiment is illustrated in the accompanying drawings, in which—

25 Figure 1 is a front elevation of my improved collar. Fig. 2 is a side view of the same. Fig. 3 is a horizontal section on line $x x$, Fig. 1. Fig. 4 is a detail view of the blank employed folded and the inset stitched in place. Fig. 5 is a section of the same on line $y y$, Fig. 4. Fig. 6 is a horizontal section on line $Z Z$, Fig. 4. Fig. 7 is a plan of the blank. Fig. 8 is a side view of the same folded and stitched to receive the stuffing material.

35 It will be noted that the collar of my construction is formed of two blanks, each when properly arranged forming one-half of a completed collar, the points of division being preferably at the top and bottom of the collar. As each blank is a duplicate of the other, a detail description of one will serve for both.

45 The blank 1, which is preferably of suitable fabric, has one straight edge 2 and a practically straight bottom edge 3. The top 4 is provided with an extended point 5 a slight distance from the edge 2, and adjacent said point the edge 4 is cut away to provide a depression 6, and intermediate this depression and the other side edge 7 is a point 8, the latter point preferably being located at the junction of the edges 4 and 7. The point 5 is preferably located a greater distance from

the transverse center of the blank to provide for the additional extension of the rim of the completed collar, as hereinafter set forth. 55

The edge 7 from its junction with the point 8 inclines outwardly and toward the bottom edge 3, terminating somewhat below the transverse center of the blank and merging 60 into an arcuate cut-out or depression 9, the line of said cut-out terminating at and merging into a straight edge 10, inclined inwardly toward and joining the bottom edge 3.

The blank constructed as described is of 65 peculiar shape, having what is termed its "front edge" 2 and "bottom edge" 3 practically straight and at right angles to each other, while the top edge is provided with an intermediate depression and two points or 70 projecting portions located, respectively, adjacent the side edges of the blank, that point adjacent the straight edge 2 extending beyond the top of the point adjacent the opposite side edge 7. The side edge 7 represents 75 practically two inclined edges, terminating at their adjacent ends in an arcuate cut-out, the location of which is somewhat below the transverse center of the blank, as will be apparent from the drawings. 80

The leather insets, which are two in number for each blank—that is, for each half the collar—are of different shape and secured to the blank in different ways. The inset 11, hereinafter termed the "housing," is a 85 leather strip having a straight edge 12 and rounded top and bottom edges 13 and 14, the latter being of greater length than the former, so that the lower end of the housing is of greater width than the upper end, 90 whereby the side edges 12 and 15 of the housing diverge, as seen from the drawings.

The housing is of a width about equal to the width of the body of the collar at the upper end, whereby said housing will completely 95 overlie the upper surface of the body of the collar when said collar is in a finished state. In connecting the housing and blank the housing is laid upon the blank with its edge 12 coincident with the edge 7 and the edge 13 100 coincident with the point 8 of the upper edge of the blank, whereby the housing rests upon the blank in the corner formed by the function of the side edge 7 and the top edge 4. The housing is secured in place by a line of 105 stitching extending from the junction of edges

13 and 15 and extending down parallel with the edge 15 and laterally adjacent the edge 14 and terminating at the edge 7 of the blank.

The remaining inset, hereinafter termed the "lug," is a semicircular strip of leather 16, having a straight edge 17 and a curved edge 18 of regular contour. In securing this lug in place the edge 18 is stitched to the edge of the cut-out 9 with the straight edge 17 projecting toward the longitudinal center of the blank, as illustrated in Fig. 8. In order, however, to provide a fullness at this point which will produce the desired cushion without unnecessary bulging or wrinkles, I form the cut-out 9 of greater length than the length of the lug and yet maintain the distances of the secured portions of the lug and blank the same by providing the curvature of the cut-out of greater radius than the curvature of the edge 18 of the lug, making the former an arc of a circle and the latter practically a semicircle. These specific details are not absolutely essential in this particular, the main point being that the line of sewing should extend throughout the curved edges of both the lug and cut-out and that the curvature of the latter should be on a greater radius than that of the former, whereby to provide a fullness at the point of insertion of the lug. The lug is now reversed, so that its straight edge 17 is practically in alinement with the edge 7 of the blank, the blank being folded adjacent the stitching of the lug to permit the reversal or outward turning of the lug.

The two blanks with the leather insets in place are now secured together along their upper edge 4 by a line of stitching following said edge and, as will be seen, including the edge 13 of both of the housings 11.

In folding the connected blanks to form the completed collar I turn or fold the edge 2 over upon the body of the blank, approximately on the line 19 19, which line of fold extends practically from the apex of the point 5 lengthwise the blank and parallel with the straight edge 2 of said blanks. I next fold the connected blanks on the line 20 20, which extends practically coincident with the inner edge 15 of the housings 11, and passing the free edge 7 of the blanks under the edge 2, which has previously been folded inwardly, 3, secures the whole together by a line of stitching extending lengthwise the blank and passing through the edges 2 and 7 and through the body of the blank, said stitching of course passing through the edges 12 of the housing and 17 of the lugs.

It will thus be seen that I have completely formed the collar by one single line of stitching, forming complete the body and rim. The points 5 when reversed after stitching the blanks together at the upper edge forms a projection at the extreme upper end of the collar, while the fullness secured by the peculiar manner of affixing the lugs in place pro-

vides the necessary cushion at the point desired.

In the finished structure it will be noted that the housings 11, overlying the material of tie-blank, completely reinforce the same at the upper portion of the collar and extends some distance down the body of the collar to provide a wearing-piece for the hame and hame-strings, and by virtue of the edge 12 being shorter than the edge 15 the bend at the upper point of the collar is formed without fullness or wrinkles.

What I claim as new is—

1. A horse-collar blank having one side edge and one end edge at approximately right angles to each other, the opposite end edge being of a double irregular curve, and the opposite side edge being inclined in reverse directions from the respective ends toward the center.

2. A horse-collar having an arcuate depression in one edge and a leather inset having a curved edge of less radius than the curvature of said depression, said curved edges of the inset and depression being secured together, whereby to provide a fullness at the point of the inset.

3. In a horse-collar, a blank and a housing designed to be secured to said blank with two edges in alinement with the edges of the blank and a third edge of greater length than either of said edges overlying the body of the blank adjacent the rim, whereby the bend at the upper portion of the collar is without fullness or wrinkles.

4. In a horse-collar, a blank having an arcuate depression in one edge, and a lug having a curved edge to be secured to the curved edge of said depression.

5. In a horse-collar, a blank, having a depression in one edge and an inset having a straight edge and a curved edge and secured to the blank with its curved edge coincident with the edge of the depression.

6. In a horse-collar, a blank having a housing secured thereto, said housing having opposite edges of different lengths and secured to the blank with two edges in alinement with and approximately of the same contour as the edges of the blank.

7. A horse-collar blank having one side edge and one end edge at approximately right angles to each other, the opposite end edge being of a double irregular curve, and the opposite side edge being inclined in reverse directions from the respective ends toward the center, said latter edge being cut out on an arc between the inclined portions thereof.

In testimony whereof I affix my signature in presence of two subscribing witnesses.

WILLIAM B. ESTES.

Witnesses:

C. W. ANSLEY,
SCOTIA MACDONALD.