

No. 874,076.

PATENTED DEC. 17, 1907.

C. S. & A. S. HUNTINGTON.

BUCKLE.

APPLICATION FILED MAY 16, 1906.

Fig. 1.

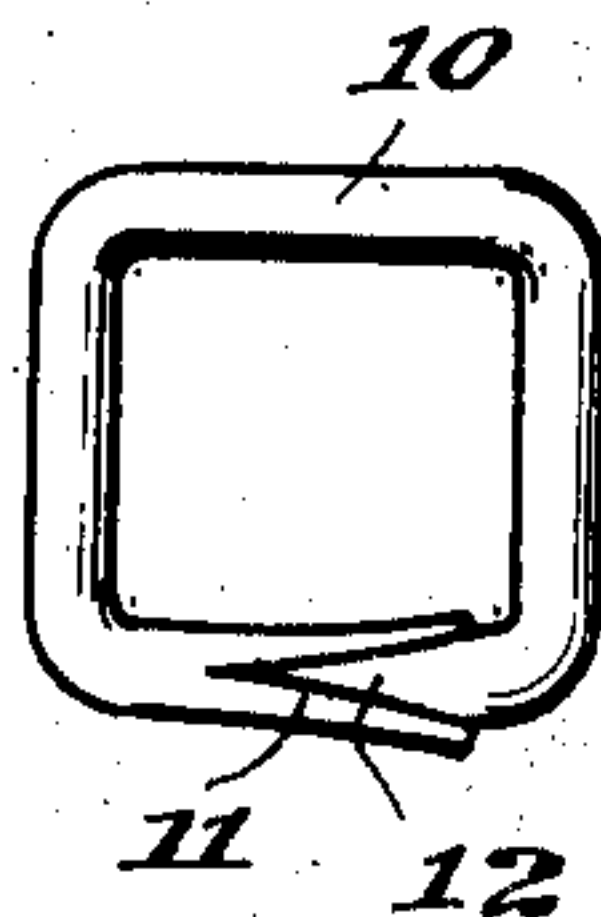


Fig. 2.

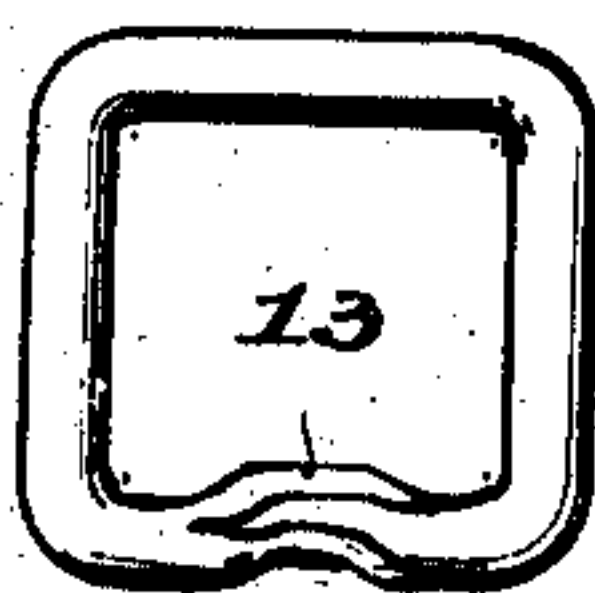


Fig. 3.

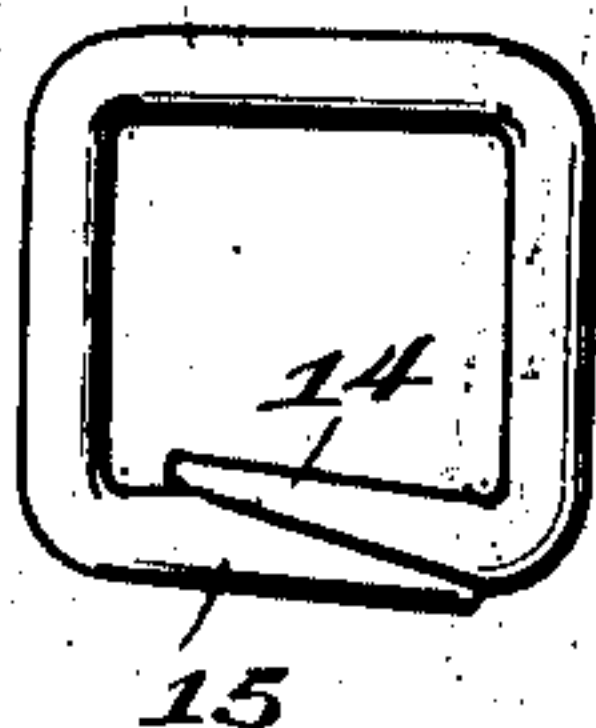


Fig. 4.

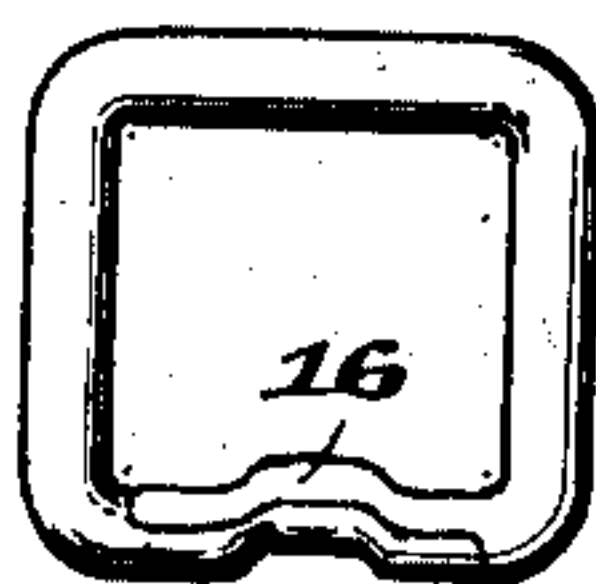
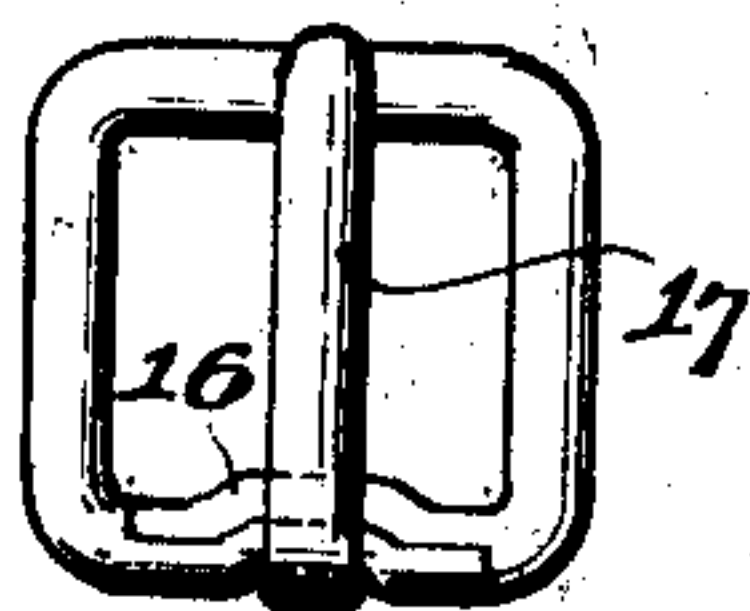


Fig. 5.



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UNITED STATES PATENT OFFICE.

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BUCKLE.

No. 874,076.

Specification of Letters Patent.

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To all whom it may concern:

Be it known that we, CHARLES S. HUNTINGTON and ARTHUR S. HUNTINGTON, citizens of the United States, residing at Omaha, in the county of Douglas and State of Nebraska, have jointly invented certain new and useful Improvements in Buckles, of which the following is a specification.

It is the object of our invention to produce a strong buckle frame from wire or other metal rod at a minimum cost of manufacture and without heating the same. To accomplish this result, after the wire has been bent to form the buckle frame or loop, the ends of the wire or rod are overlapped and then cold swaged together and crimped, bent, or dented to prevent the two ends of the wire from pulling apart and also to provide a seat for the tongue of the buckle.

In the accompanying drawings we have illustrated two embodiments of our invention wherein

Figure 1 is a view of one form of incomplete buckle frame showing the ends of the wire interfitted but not crimped; Fig. 2 is a view similar to Fig. 1 and illustrates the manner of bending or crimping the overlapped or interfitted ends of the wire to prevent them from pulling apart and to form a seat for the tongue of the buckle; Fig. 3 illustrates a modified method of manufacturing the buckle, wherein the two ends of the wire forming the buckle frame are merely overlapped but not interfitted, as shown in Fig. 1; Fig. 4 shows the buckle frame of Fig. 3 after it has been cold swaged to press the two ends of the wire together into firm contact and to crimp them; and Fig. 5 is a view of the completed buckle.

Referring first to Figs. 1 and 2 it will be apparent that a strip of wire of the proper length is trimmed or cut so that one end is provided with a V-shaped notch or socket 11, while the other end has a similarly shaped tongue 12 adapted to fit in the socket. The length of wire is then bent into the shape shown in Fig. 1 with its two ends interfitted, as shown, the tongue 12 fitting in socket 11. In order to interlock these two terminal portions of the wire together in such a manner

that they cannot be readily pulled apart the interfitted ends are cold swaged so as to bring them into firm contact and bend or crimp them at 13 thereby positively locking them together and forming a seat or depression for the buckle tongue. The joint of the buckle frame when made in this manner is almost imperceptible and if the buckle is metal coated afterwards the joint is so nicely covered that it is found only with difficulty.

In Figs. 3, 4 and 5 we have illustrated a modified form of buckle frame, and in this type of buckle the ends 14 and 15 of the wire, which is bent to form the frame, are made tapering and then overlapped when the wire is bent to shape to form the frame, as shown in Fig. 3. In order to bring these two ends into firm engagement and to prevent their separation they are cold swaged together and crimped at 16, as shown in Fig. 4. This crimping, as in the previous instance, positively locks the two ends of the wire together and forms a seat for the tongue 17, shown in Fig. 5.

It will be obvious to those skilled in the art that changes may be made in the method of manufacturing this buckle and in its construction without departing from the essential principles of the invention which are set forth in the following claims.

I claim:

1. In a buckle, the combination of a frame made of a strip of wire or the like, the ends of which are interfitted and crimped or bent to interlock them together and form a seat for a tongue, and a tongue encircling said crimped or bent interfitted portions of the wire, substantially as described.

2. In a buckle, the combination of a frame made of a strip of wire or the like, the ends of which are overlapped and crimped or bent to interlock them together and form a seat for a tongue, and a tongue encircling said crimped or bent overlapped portions of the wire, substantially as described.

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Witnesses:

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