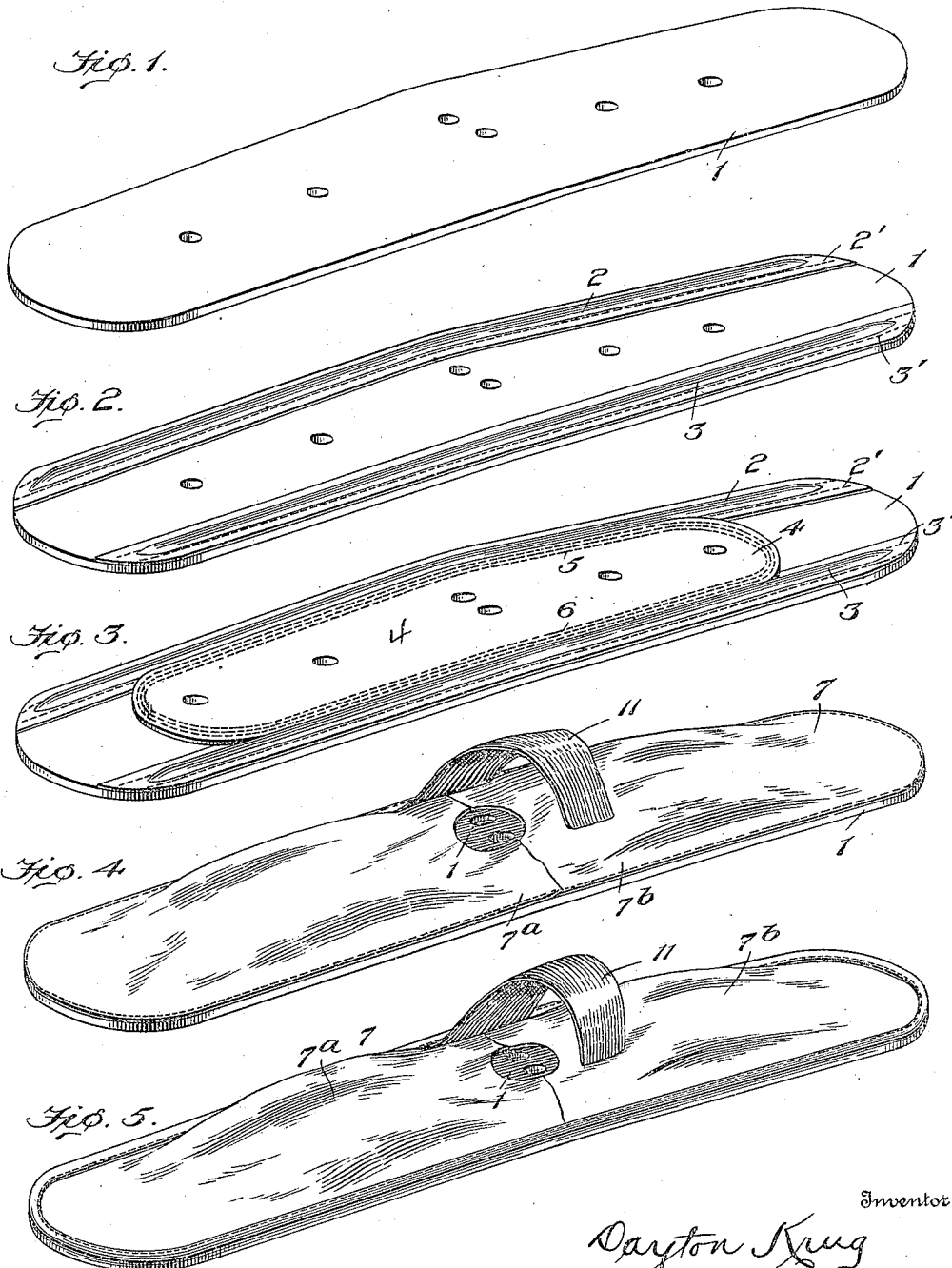


D. KRUG.
ART OF MAKING HARNESS SADDLES OR PADS.
APPLICATION FILED MAR. 15, 1909.

952,449.

Patented Mar. 22, 1910.

2 SHEETS—SHEET 1.



Witnesses

Edmund L. Bradford
L. C. Brady

By

Inventor
Dayton Krug

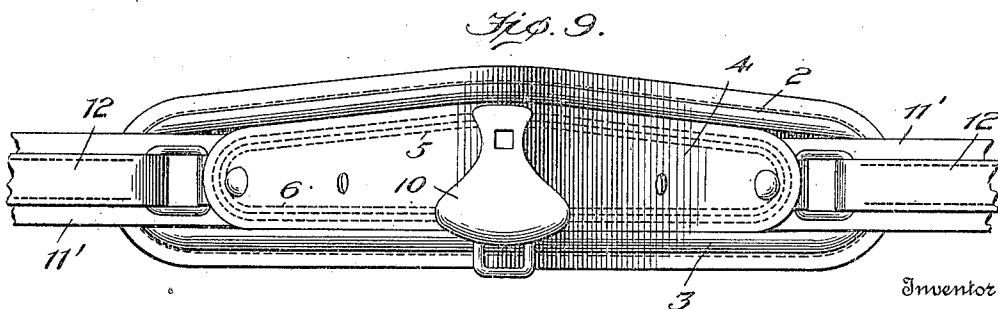
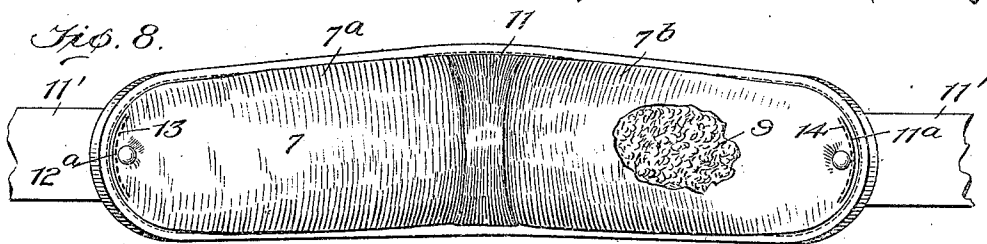
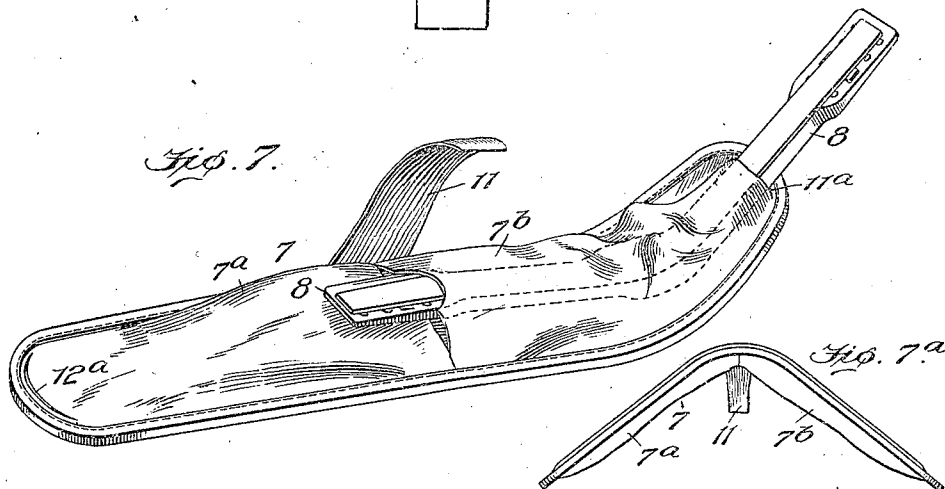
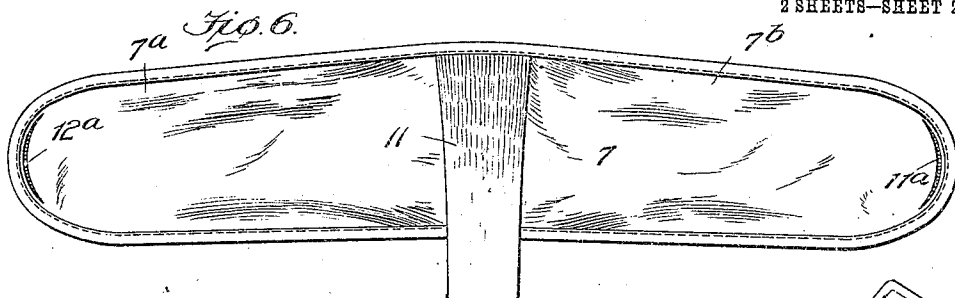
Edward P. Alexander
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2 SHEETS—SHEET 2.



Witnesses
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UNITED STATES PATENT OFFICE.

DAYTON KRUG, OF CANTON, OHIO, ASSIGNOR TO THE GILLIAM MANUFACTURING COMPANY, OF CANTON, OHIO, A CORPORATION OF OHIO.

ART OF MAKING HARNESS SADDLES OR PADS.

952,449.

Specification of Letters Patent.

Patented Mar. 22, 1910.

Application filed March 15, 1909. Serial No. 483,529.

To all whom it may concern:

Be it known that I, DAYTON KRUG, a citizen of the United States, residing at Canton, in the county of Stark and State of Ohio, have invented certain new and useful Improvements in the Art of Making Harness Saddles or Pads, of which the following is a specification, reference being had therein to the accompanying drawings.

This invention relates to an improvement in the art of making harness saddles or pads, and more particularly to the art of making saddles or harness pads having the pad bottoms stitched or sewed to the housings, and arched or bent saddle trees arranged between the housings and the bottoms.

One of the objects of my invention is to improve the art of saddle or harness pad making by simplifying and cheapening the cost of the various operations which heretofore have been required to produce a saddle of the aforementioned class, and at the same time to insure that a saddle or harness pad of much neater appearance and more uniform workmanship will result.

Another object of my invention is to provide a process of making saddle or harness pads of the above mentioned class in which all of the sewing or stitching on the housings and between the housings and the bottoms may be done while these parts lie flat upon the bed of the sewing machine, or, in other words, while they lie in substantially the same plane from end to end.

Another object of my invention is to provide a process of making saddle or harness pads of the aforementioned class, in which all the sewing or stitching on the housings and between the housings and the bottoms may be done while these parts lie substantially flat from end to end on the bed of the sewing machine, or, in other words, in substantially a common plane, and inserting formed or arched saddle trees between the housings and the stitched-on bottoms, after the bottom has been sewed to the housing, simultaneously causing the housing to assume substantially the form of the formed or ready arched tree.

In the drawing: Figure 1 is a perspective view of one form of housing used in carrying out my process. Fig. 2 is a perspective

view illustrating the said housing with a suitable bead stitched thereto. Fig. 3 illustrates, in addition to the parts shown in Fig. 2, a jockey sewed or stitched to the said housing. Fig. 4 is a perspective view illustrating, in addition to the parts illustrated in Fig. 3, a bottom stitched to the housing. Fig. 5 illustrates all the parts shown in Fig. 4, with the addition of a binding sewed or stitched to the housing to conceal the stitching or sewing of the bottom to the housing and the edges of the housing and bottom. Fig. 6 is a bottom plan view illustrating the manner in which the bottom is cut or slit to facilitate the insertion of a ready formed saddle tree. Fig. 7 is a perspective view illustrating the method of inserting the formed saddle tree. Fig. 7^a is a front elevation of a formed harness saddle or pad constructed in accordance with my process. Fig. 8 is a bottom plan view of the saddle complete. Fig. 9 is a top plan view of the same.

For the purpose of illustrating my process I will describe the process of making one style of saddle or harness pad, and have shown certain steps of the same in the drawing, but it will be understood that the process is equally adaptable for making many different styles of pads and lends itself readily to the making of artistically designed saddles and pads, variously embellished and having sewed-on bottoms.

In the drawing 1 represents a housing of any suitable material.

2, 3, are beads formed in a suitable material which may be stitched or sewed, as illustrated at 2', 3', to the housing.

4 is a jockey formed in any well-known manner, and which may be suitably secured to the housing. I have illustrated it as stitched or sewn to the housing along the lines 5, 6.

7 indicates the bottom of the saddle. It is preferably formed in two pieces, 7^a, 7^b, each of which is sewn or stitched adjacent to its edges to housing 1.

8 is a saddle tree bent in arched form and made of any suitable and well-known arched saddle tree construction, which is adapted to be inserted ready formed between the housing and bottom of a saddle.

9 indicates the stuffing or padding which

is inserted between the housing 1 and bottom 7 in order to form suitable pads or cushions.

10 indicates a suitable seat, and 11 a center arranged to conceal the adjacent edges of the bottom piece 7^a, 7^b.

11' represents the saddle skirts, and 12 the back-bands, which may be suitably made and secured to the housing 1 and saddle tree 8 in any well-known manner.

The process or art of making saddle or harness pads which embodies my invention is carried out as follows: The housing, which may be formed as desired, first has sewed to it any beads or equivalent parts which are desired on the particular style of saddle to be made, and then if the jockey is to be stitched to the housing it is at this time sewed or stiched in place. It will be understood that the steps of sewing any beads or equivalent parts, also the jockey, are not necessary steps in the carrying out of my process, unless such beads or jockeys sewed to the housing are desired. It will also be understood that the beads or their equivalent and the jockey are sewed directly to the housing while the housing lies in substantially a single horizontal plane from end to end, or flat on the bed of the sewing machine, and readily accessible for the purpose.

Whether or not beads or their equivalent, and a jockey, either or both, are sewed to the housing, the bottom or parts thereof—7^a, 7^b—are not stitched or sewed to the housing until all of the desired beads or embellishing parts and jockey to be stitched to the housing are stitched thereto.

The parts 7^a, 7^b, of the bottom are preferably stitched to the housing all around their edges adjacent to the edges of the housings, including across the extreme opposite ends of the housings, but their inner ends are left unstitched. Next the material, of which the bottom pieces 7^a, 7^b are formed, is preferably slitted transversely on lines 11^a, 12^a, closely adjacent to the opposite ends of the housing, respectively. This slitting of the bottom piece is done for the purpose of facilitating the insertion of the already formed arched saddle tree, as well as for facilitating the stuffing or padding of the saddle. Next after the cuts or slits 11^a, 12^a, have been made, an arch formed saddle tree 8 is inserted between the bottom 7 and the housing 1. This is preferably accomplished by introducing the free end of one leg of the formed saddle tree between one of the parts 7^a or 7^b of the bottom at its inner open or unstitched end and the housing, and pressing the inserted leg of the tree toward the end of the housing toward which it is directed and out through the slit 11^a, as indicated in Fig. 7. The end of the leg of the tree exposed through slit 11^a is then grasped and drawn out until the free end of the other leg of the

tree may be easily directed beneath the part 7^b of the bottom. Thereupon the part of the tree exposed through the slit 11^a is pressed back between the bottom part 7^a and the housing 1 until the tree is in proper position, the housing simultaneously assuming or taking substantially the arched form of the tree. Next suitable stuffing or packing material is inserted between the bottom parts 7^a, 7^b, and the housing. This is preferably accomplished by directing the packing material for the two pads of the saddle through the slits or openings 11^a, 12^a. Next these openings or slits are closed in any suitable manner, preferably by transverse stitching, as indicated at 13, 14, respectively. This concludes the method proper of making the saddle; thereafter the various attachments and fittings desired may be put in place in any preferred sequence.

Heretofore, so far as I am aware, no successful or commercially practical process or method of making harness saddles or pads has been known or used in which a ready-formed arched tree has been employed in a saddle having the bottom sewed or stitched to the housing.

I am aware of the fact that numerous efforts have been made to sew the bottom to the housing after the housing has been arched and made to conform to the shape of the tree, and to sew the binding onto the housing and bottom while these parts are in arched form, but none of these efforts, to the best of my knowledge, have been at all satisfactory, either commercially or as a manufacturing proposition.

It will be noted that with my improved process of making harness saddles or pads, with the bottoms sewed to the housings, all stitching or sewing to the housing becomes a simple matter, readily accomplished on ordinary sewing machines of every day factory and commercial use, and, furthermore, that my process lends itself admirably to the developing and using of practically innumerable artistic designs and embellishments, such as beads, special jockeys, and the like, sewed directly to the housing, and neatly and uniformly set off by a substantially perfectly sewed-on binding, which conceals the rough edges of the housing and bottom and the stitches which connect these parts together.

It will also be noted that my improved process may be carried out in a very economical and rapid manner, and that the embellishments or beautifying parts, as well as the bottom and binding, to be sewed to the housing, which is ultimately to assume an arched form, may be sewed or stitched in place prior to the insertion of the ready-formed arched tree.

It will also be noted that I have devised an exceptionally simple and quick method of

inserting a ready-formed arched tree, and the substantially simultaneous arching of the housing.

What I claim is:

5 1. The process of making harness saddles, which consists in stitching the bottom to the housing, then transversely slitting the bottom, then inserting a ready arched saddle tree between the bottom and the housing, 10 using said slit in the bottom for this purpose, and causing the housing to simultaneously assume substantially the arched form of the tree, inserting stuffing between the bottom and the housing, and then closing 15 the aforementioned slit in the bottom.

2. The process of making saddles, which consists first in stitching to the housing a bottom formed in two parts, each of which is left unstitched across the center of the 20 housing, then stitching to the bottom and housing a suitable binding, all of the aforesaid stitching being done before the housing is caused to assume its final arched form, then slitting a bottom piece adjacent to the 25 outer end thereof, then inserting a saddle tree of ready arched form by directing the free end of one leg of the ready arched tree underneath the inner end of a bottom piece and out through the aforesaid slit a distance 30 sufficient to permit the free end of the other leg of the said saddle tree to be directed under the other bottom piece, then sliding the arched tree into position between the housing and bottom, simultaneously causing 35 the housing to assume an arched form, then inserting the stuffing between the bottom and housing, and then closing the said slit in the bottom.

3. The process of making saddles, which 40 consists first in stitching to a suitable housing a bead or beads, then stitching to the housing a bottom formed in two parts, each of which is left unstitched across the center of the housing, then stitching to the bot- 45 tom and housing a suitable binding, all of

the aforesaid stitching being done before the housing is caused to assume its final arched form, then slitting a bottom piece adjacent to the outer end thereof, then inserting a saddle tree of ready arched form 50 by directing the free end of one leg of the ready arched tree underneath the inner end of a bottom piece and out through the aforesaid slit a distance sufficient to permit the free end of the other leg of the said saddle 55 tree to be directed under the other bottom piece, then sliding the arched tree into position between the housing and bottom, simultaneously causing the housing to assume an arched form, then inserting the stuffing be- 60 tween the bottom and housing, and then closing the said slit in the bottom.

4. The process of making harness saddles which consists first in stitching to a suitable housing a bottom, openings being arranged 65 near the center of and one end of the bottom to permit the insertion of a ready arched tree, then inserting a saddle tree of ready arched form by directing one leg of said 70 arched tree through the said opening near the center of the bottom piece and out through the said opening near the end of the bottom piece a distance sufficient to permit the free end of the other leg of the saddle tree to enter the first said opening and 75 be directed between the bottom piece and the housing, then sliding the arched tree into position between the housing and the bottom simultaneously causing the housing to assume an arched form, then inserting 80 stuffing between the bottom and housing, and then closing the said opening at one end of the bottom.

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

DAYTON KRUG.

Witnesses:

BERTHA OBRINGER,
CHAS. M. BALL.