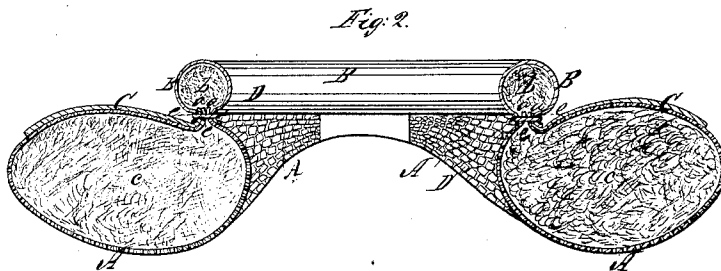
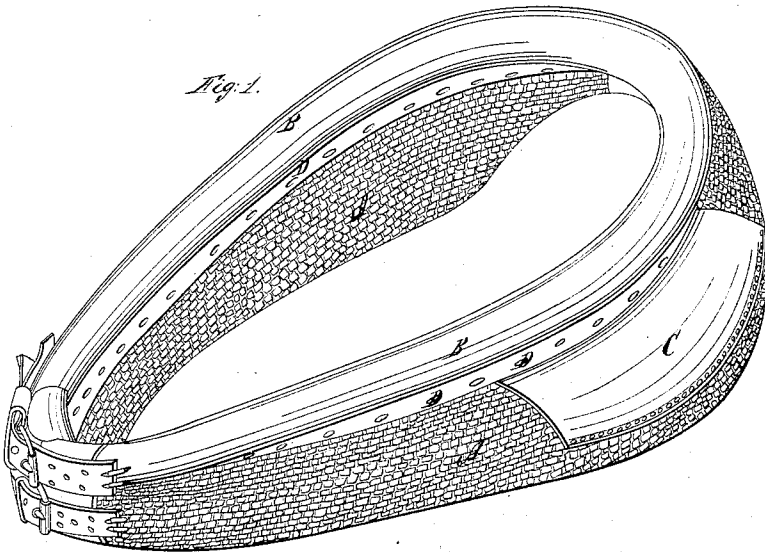


*J. Bullock,*

*Horse Collar,*

*N<sup>o</sup> 26,748.*

*Patented Jan. 10, 1860.*



*Witnesses:*

*Edmund D. Ardee*  
*E. H. Parwick*

*Inventor:*

*James Bullock*

# UNITED STATES PATENT OFFICE.

JAMES BULLOCK, OF BALTIMORE, MARYLAND.

## HORSE-COLLAR.

Specification of Letters Patent No. 26,748, dated January 10, 1860.

*To all whom it may concern:*

Be it known that I, JAMES BULLOCK, of the city of Baltimore and State of Maryland, have invented a new and useful combined Duck-Cloth and Leather Horse-Collar; and I do hereby declare that the following is a full, clear, and exact description of the same, reference being had to the accompanying drawings, forming a part of this specification, in which—

Figure 1, is a perspective view of a horse collar made after my invention. Fig. 2, is a transverse section of the same.

Similar letters of reference, in each of the several figures indicate corresponding parts.

My invention consists in a new article of manufacture, to wit: A horse collar which has its shoulder and neck relieving portion made entirely of duck-cloth and without a side seam, allows the air, heat and vapor, a chance to circulate through it, presents a soft fibrous surface to the shoulders and neck of the horse, has its front and the parts which receive the wear of the irons of the harness mounted with leather and its shoulder and neck relieving portion and its leather mountings united by means of the same thong or thread, substantially as hereinafter described.

A greater portion of the horse-collars at present in use are made of leather throughout and with a side seam in the shoulder relieving portion. These collars, owing to having a side seam, are rather difficult of construction and they of course, as they are made of leather, do not allow a circulation of air, vapor and heat through them. They also gall the horse.

To obviate the last objection, a fibrous substance, such as bed-tick has been interposed in some instances, but this fibrous substance has not been employed so as to form of itself the entire shoulder relieving portion of the collar, it only forming the back of the same, the leather being placed at the front, and therefore the circulation of the air, vapor and heat through the shoulder relieving portion of such collars is not possible. Besides this, such collars require to have a side seam in the shoulder relieving portion and consequently are rather difficult of construction, and if made on a cheap scale do not present a neat and finished appearance.

My invention obviates these difficulties,

and enables me to furnish the market with an article which is as durable and finished in appearance as the best leather collars, at less cost than the same are now offered.

To enable others, skilled in the art, to make and use my invention, I will proceed to describe its construction and operation.

A, A, designates the duck-cloth shoulder and neck relieving portion of the collar, and B, B, and C, C, the leather mountings for giving a finished appearance and saving the duck cloth from the wearing action of the irons of the harness.

The part A, A, by being made of duck cloth is sufficiently durable and at the same time is porous and allows a circulation of air, vapor or heat, and thus gives greater comfort to the horse. The duck material will also be less liable to gall at the points of contact. The duck cloth is cut or woven into the proper form and its edges *a, a*, brought together and sewed so as to confine the filling or padding *b*.

To form part B, the leather is cut to the proper shape and sewed up so as to receive the padding or filling *c*.

The parts C, C, are now sewed to the bulging part of the duck cloth sack, as represented. The padding having been introduced the ends of the parts A, and B, are closed up at the bottom, and united at the top. All is now ready to be sewed together. This is accomplished by bringing the edges *e, e*, of the wearing leathers, and those *a, a*, of the duck cloth between the edges of the leather mountings B, and then passing a leather thong D, back and forth through the edges until the whole is securely sewed together.

What I claim as my invention and desire to secure by Letters Patent, is—

A new article of manufacture, to wit; a horse collar having its shoulder and neck relieving portion A, A, made throughout of duck cloth, and without a side seam, and mounted with leather B, C, and otherwise constructed after the method herein described, for the purpose set forth.

The above specification of my improvement in horse collars signed by me this 26th day of November 1859.

JAMES BULLOCK.

Witnesses:

GOODWIN Y. AT LEE,  
R. W. FENWICK.