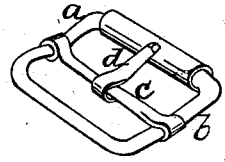
G. R. Kelsey,

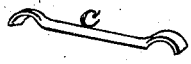
Buckle,

No. 34,429, Patented Feb. 18, 1862.

Fig; 1.

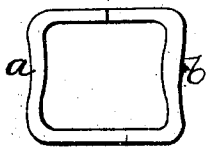


Fig; 3.



Fig; 4.

Fig; 2.



Witnesses;
William H. Ward
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Geo R. Kelsey

UNITED STATES PATENT OFFICE.

GEORGE R. KELSEY, OF WEST HAVEN, CONNECTICUT.

IMPROVEMENT IN THE MANUFACTURE OF BUCKLES.

Specification forming part of Letters Patent No. **34,429**, dated February 18, 1862.

To all whom it may concern:

Be it known that I, GEORGE R. KELSEY, of West Haven, in the county of New Haven and State of Connecticut, have invented a new and useful Improvement in Buckles, as a new article of manufacture; and I do hereby declare that the following is a full, clear, and exact description of the construction, character, and operation of the same, reference being had to the accompanying drawings, which make part of this specification, in which—

Figure 1 is a perspective view of the buckle complete and ready to be attached to the strap for use. Fig. 2 is a perspective view of the main or body part of the buckle ready to receive the cross-bar. Fig. 3 is a perspective view of the cross-bar as ready to be secured in its position in the buckle. Fig. 4 is a perspective view of the tongue as ready to be secured to the cross-bar.

My improvement consists in making the buckle of three pieces of wire by forming the bow and loop of one piece by simply swaging it into its proper shape, (nearly square,) and the cross-bar of one piece by simply flattening the ends and lapping and securing them around the end bars of the bow and loop, and in making the tongue and attaching it to the cross-bar by lapping it round and setting it down by any convenient means, so as to be secure and yet freely movable.

I make the bow and loop of the buckle together of one piece of iron wire of a thickness suited to the size of the buckle by swaging it into its proper shape, (nearly square,) as represented in Fig. 2, with its two end bars or parts bent or sprung inward, as represented at *a* and *b*, Figs. 1 and 2, so that the thickness of the ends of the cross-bar will not project. I make the cross-bar *c* of a piece of iron wire by simply flattening and bending the two ends, as represented in Fig. 3. I make the tongue *d* of a piece of iron wire by sharpening one end and flattening and bending the other, as represented in Fig. 4.

Each of the parts may be formed by the use of suitable dies or swages, and they may be made of any kind of metal desired.

Having made the three parts, as before described, I lay the two end parts, as *a* and *b*, of the main part or bow and loop of the buckle into the two bent ends of the cross-bar, and by suitable dies swage down or clinch the bent parts, so as to firmly secure or attach the cross-bar *c* to the parts *a* and *b* of the bow and loop, and I place the flattened and bent end of the tongue *d* onto the cross-bar *c* and swage down the bent part, so that it will move freely on the cross-bar, when the buckle will be complete, as represented in Fig. 1.

The advantages of my improvement consist in that a much stronger buckle can be made from the same weight of metal than any heretofore used, and in that the buckle can be made at much less expense than any heretofore made of equal strength and usefulness. These buckles are peculiarly well suited for knapsacks, haversacks, &c., where strength, durability, and plainness are desirable.

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

A buckle in which the bow and loop is made of one piece of wire, when the ends of the cross-bar *c* are clinched around the opposite parts *a* and *b* of the bow and loop to strengthen the buckle, as herein described.

GEO. R. KELSEY.

Witnesses:
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