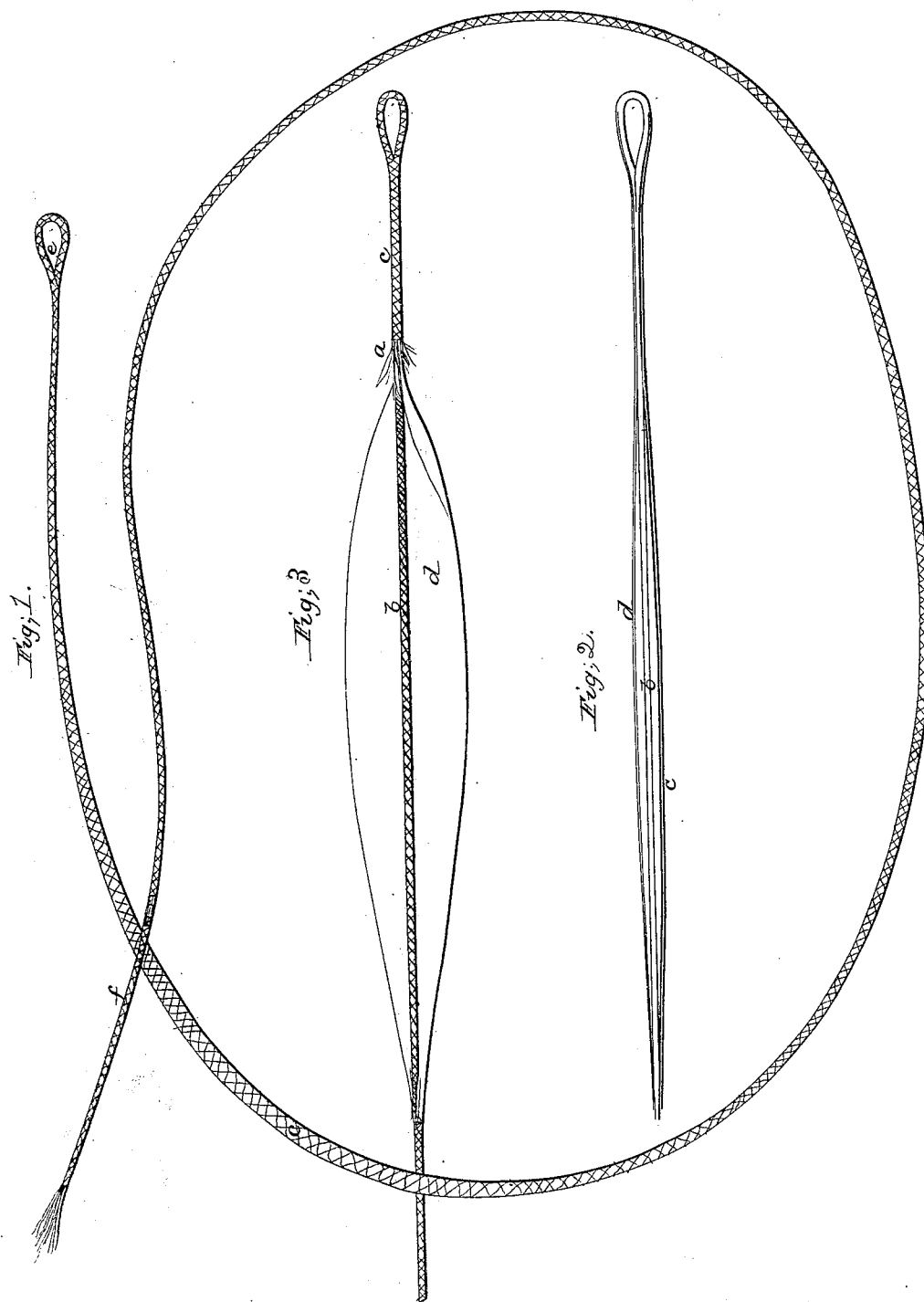


*D. N. & E. B. Day,*

*Whip.*

*N<sup>o</sup> 7068.*

*Patented Feb. 5, 1850.*



# UNITED STATES PATENT OFFICE.

D. N. DAY AND E. B. DAY, OF WESTFIELD, MASSACHUSETTS.

## WHIP-LASH.

Specification of Letters Patent No. 7,068, dated February 5, 1850.

*To all whom it may concern:*

Be it known that we, D. N. DAY and E. B. DAY, of Westfield, in the county of Hampden and State of Massachusetts, have invented new and useful Improvements in the Manufacture of Whip-Lashes, and that the following is a full, clear, and exact description of the principle, or character which distinguishes them, from all other manufactures before known and of the manner of making and constructing the same, reference being had to the accompanying drawings, making part of the specification, in which—

Figure 1, is a representation of a whip lash made on our improved plan, Fig. 2, a horizontal section thereof, and Fig. 3, a representation of the parts with the plaiting commenced.

The same letters indicate like parts in all the figures.

Whip lashes have heretofore been and are now generally made of strips or thongs of leather plaited in a circle to make the lash round, and for the purpose of forming the swell, a piece of leather is cut in an elliptical form, rolled up, and inserted within the plaiting. When thus made, whip lashes are costly, for the reason that buckskin or other kinds of leather the materials used are costly and the thongs have to be cut with great regularity, the filling for the swell consumes much leather, and the leather thongs are difficult to plait and required to be spliced. And after all whip lashes thus made are not very durable for the want of pliability, and for the reason that the whole strain comes on the plaited covering. These defects are avoided by our improvements, while at the same time, we are enabled to produce a fabric much cheaper and more durable than by any other method heretofore known. And our invention consists in making the whip lash by the combined operations of spinning, and twisting, and plaiting, that is to say, by plaiting spun and twisted threads of cotton, silk, and other fibrous substances, instead of thongs or strips which from the difficulty of obtaining of the requisite length, require to be frequently spliced in the operation of plaiting, and do not possess the same pliancy as threads; the plaiting of such lashes in the manner described being done on a core, made of a cord extending through the whole length of

the lash, that it may sustain the strain to which whip lashes are subjected, and thus protect the plaited cover from injury, by being pulled, and the swell of the core being made of any kind of cloth, which is pliant, and attached to, and combined with, the central core, the said cloth being cut in an elliptical form, and attached to the central core without rolling it up, that by plaiting around it from the pliancy of the cloth, it will be compressed into the required form to leave the outside of the lash round and smooth.

In the accompanying drawings (*a*) represents a series of threads made of cotton, silk, or any other fibrous substance, spun and twisted, and attached together around, and to the end of the central core, or cord, (*b*), which extends through the whole length of the lash, and then the threads (*a*), are plaited in the usual manner around the core (*b*) to form the covering (*c*) of the lash. The swell of the lash is formed by cutting a piece of cotton cloth (*d*), or any other soft and pliable cloth, cut in an elliptical form, and secured by one end to the central core, and as the covering is plaited around, this cloth is gathered in and compressed to the form required; the elliptical form of this cloth, of course, when gathered up will give the regular swell required to the lash and the degree, length, and amount of this swell will depend on the form given to the cloth.

The loop (*e*) at the upper end is formed by turning over the end, and plaiting it in with the cover, and when the extremity is completed the threads constituting the plaited covering are properly secured to the core and to the cracker (*f*).

A lash made in the above manner will present a more smooth and regular appearance from the fact that the threads or cords of which the plait is made are of regular size and do not require to be spliced, which is not the case when made of leather thongs, which are seldom obtained of regular size and of the required length. It will be more pliable, from the nature of the material substituted, and from the manner in which the core is worked in (instead of rolling it up as heretofore), and will be stronger, in consequence of the central core which sustains the greater part of the strain.

What we claim as our invention and desire to secure by Letters Patent, is—

A new manufacture for whip lashes by making plaited whip-lashes of spun and  
5 twisted threads, or cords, as described, instead of leather thongs, the same being plaited over a central cord or core, extending the whole length as described, and a

swell made of cotton, or other soft and pliable cloth, attached to the central core, without rolling, substantially as described.

DAVID N. DAY.

EDWARD B. DAY.

Witnesses:

CHAS. K. BINGHAM,

WM. G. BATES.