A. J. Sessions,

Caster.

No. 108,300. Patented Oct. 11. 1870.

Fig. 1.

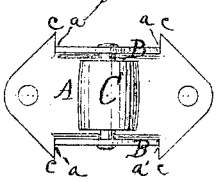


Fig. 2.

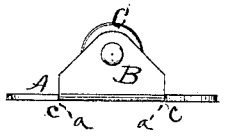
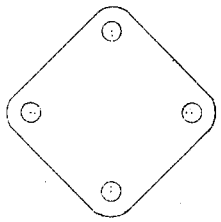


Fig. 3.



Witnesses.

S. C. Dunhams.

C. A. Shepard.

Inventor.

Albert L. Sessions

By James Shepard. Atty.

United States Patent Office.

ALBERT J. SESSIONS, DECEASED, OF BRISTOL, CONNECTICUT, BY ELLEN L. SESSIONS, ADMINISTRATRIX, ASSIGNOR TO JOHN H. SESSIONS, OF SAME PLACE.

Letters Patent No. 108,300, dated October 11, 1870.

IMPROVEMENT IN CASTERS FOR TRUNK.

The Schedule referred to in these Letters Patent and making part of the same.

I, ALBERT J. SESSIONS, of Bristol, in the county of Hartford, and State of Connecticut, have invented a new and useful Improvement in Trunk-Rollers, of which the following is a specification.

My invention consists of forming a trunk-roller frame from a square sheet-metal blank, having four short diagonal incisions in the edges of the same, between which incisions two opposite corners of the blank are turned up to form the ears, as hereafter described.

In the accompanying drawing—

Figure 1 is a front elevation of a roller of my invention;

Figure 2 is a side elevation of the same; and

Figure 3, a plan or top view of the blank, from which the roller-frame is formed.

The metal is first cut into square blanks, with each corner slightly rounded, and a hole punched in each, as shown in fig. 3. The blank is then placed in the forming-dies, specially prepared for the purpose, which, as they close or meet, make four short incisions, *a a a a*, fig. 1, diagonally with the blank.

The two opposite corners of the blank between these incisions are, at the same time, bent up at right angles to the rest of the blank or plate A, thus forming the ears B B, and leaving the points *c c c c* on the main portion of the plate.

The usual cast-metal roller C is then secured between the ears B B by a pin, as in ordinary trunk-rollers.

The points *c c c c* give the plate A greater width than it would otherwise have, and also cause that portion between the ears B B to be formed less rounding than it would be if the incisions were omitted.

If desired, the points *c c c c* might be bent in an opposite direction from the ears, and be driven into the wood when fastened to the trunk.

By the above-named construction, whether the points are bent down or not, a broad surface is secured for the under side of the plate, whereby the roller can be secured to a trunk in such manner that it is not liable to rock sidewise, and thus break the nails or screws by which it is fastened to the trunk, as is the case with other sheet-metal frames having ears bent from the outside.

I claim as my invention—

The herein-described trunk-roller, the frame of which is formed from a square sheet metal blank, cut or incised at the junction of the plate A and ears B B, said ears being bent up from two opposite corners, so as to leave the points *c c c c*, substantially as described.

A. J. SESSIONS.

Witnesses:

JOHN WARD,

T. T. WILSDON.