R. MANNING.
Bridle-Front.

No. 220,162. Patented Sept. 30, 1879.

Fig. I

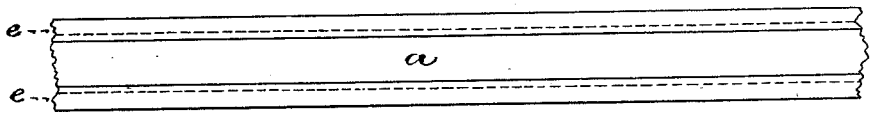
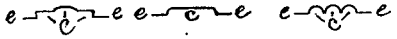


Fig. II.

Fig. IV Fig. III. Fig. V



Attest.
C. Kerr.
Charles H. Pell

Inventor.
Robt. Manning.
By O Drake, Atty.

UNITED STATES PATENT OFFICE.

ROBERT MANNING, OF NEWARK, NEW JERSEY.

IMPROVEMENT IN BRIDLE-FRONTS.

Specification forming part of Letters Patent No. **220,162**, dated September 30, 1879; application filed August 5, 1879.

To all whom it may concern:

Be it known that I, ROBERT MANNING, of the city of Newark, in the county of Essex and State of New Jersey, have invented certain new and useful Improvements in Bridle-Fronts; and I do hereby declare the following to be a full, clear, and exact description of the invention, such as will enable others skilled in the art to which it appertains to make and use the same, reference being had to the accompanying drawings, and to letters of reference marked thereon, which form a part of this specification.

This invention relates to bridle-fronts having a strip or facing of metal secured thereto, the object of which is to fasten the leather more securely and perfectly to the said metallic strips, which are sometimes used for stiffening or ornamenting said bridle-fronts, to impart increased beauty and strength thereto, and also to render said goods capable of being bent and retained in any desired form without marring or breaking the said metallic strips.

The invention consists in creasing the metal strips, so as to form a channel or channels therein, which channels are subsequently filled with other soft metal or solder in the usual way, leaving a margin of the thin metal on each side of the filled space, over which the leather is folded and sewed by a machine through both leather and metal along the entire edges of said metal strips, leaving the raised portions formed by the channels exposed between the edges of the leather, all as hereinafter more fully set forth.

The accompanying drawings illustrate the nature of the invention, in which Figure 1 is a plan view of a portion of a bridle-front embodying my improvement. Fig. 2 is a cross-section of the same; and Figs. 3, 4, and 5 are end views of the metal strips with the channels unfilled.

Similar letters indicate like parts in each of the several figures.

In carrying out my invention, I take a thin strip, *a*, of sheet-brass, nickel, or other suitable metal, of whatever length and width may be required, and by means of a suitable die reduce it to the form shown in Figs. 3, 4, and 5, or to any other desirable form, and fill the grooves or channels *c* with soft metal or solder, as indicated in Fig. 2, melted and flowed in in the usual manner, leaving a narrow margin, *e*, of the thin sheet metal on each side, as indicated in Figs. 3, 4, and 5. The strip or strips so prepared are then applied to the surface of the bridle-front or other article, the leather folded down over the edges aforesaid, and sewed in an ordinary sewing-machine, strong enough, of course, to meet the requirements of the case, along the entire edges through both leather and metal, as indicated in Figs. 1 and 2, thereby securing the advantages hereinbefore enumerated.

In bending the article or changing its form, it should be done by pressing it over a convex surface, so as to obtain a uniform curve and avoid short bends or kinks.

The same construction is adapted for analogous articles.

Having thus described my invention, what I claim, and desire to secure by Letters Patent, is—

An improved bridle-front having a strip of metal provided with a channel or channels forming raised portions on the outside, filled with soft metal or solder, and secured thereto, as specified, so as to expose the said raised portions between the edges of the leather, all as shown and described.

In testimony that I claim the foregoing I have hereunto set my hand this 2d day of August, 1879.

ROBERT MANNING.

Witnesses:
OLIVER DRAKE,
CHARLES H. PELL.