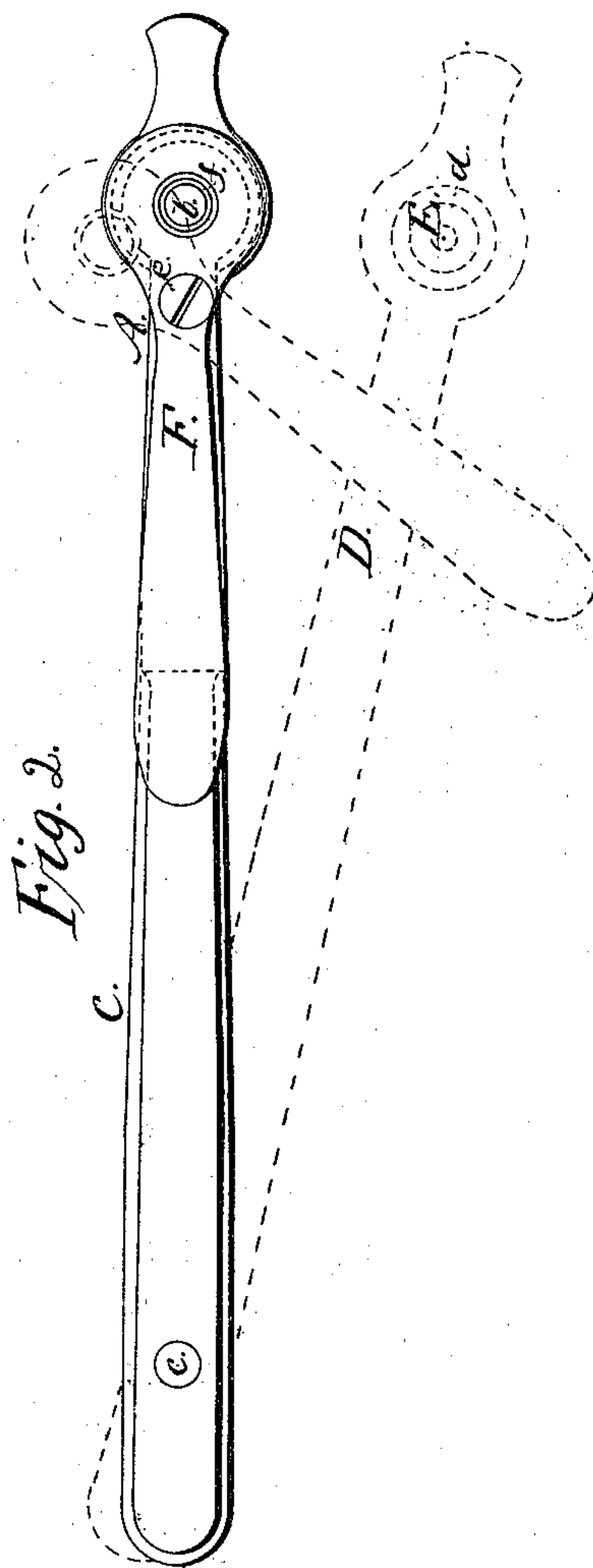
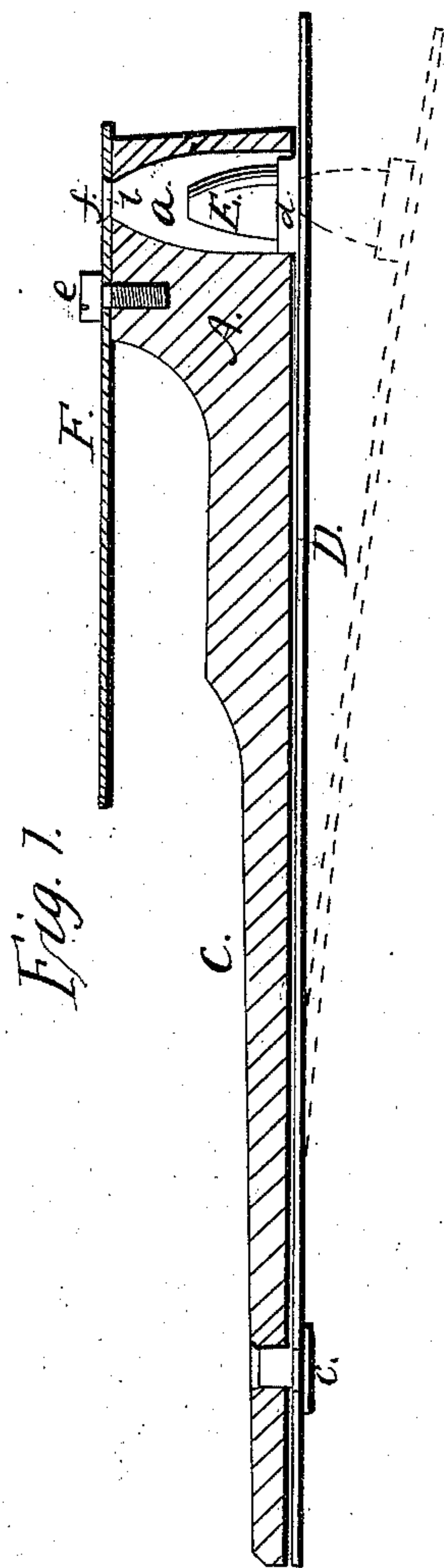


*W. Ashton,
Billet Mold.*

N^o 12,774.

Patented May 1, 1855



UNITED STATES PATENT OFFICE.

WILLIAM ASHTON, OF MIDDLETOWN, CONNECTICUT.

IMPROVED BULLET-MOLD.

Specification forming part of Letters Patent No. 12,774, dated May 1, 1855.

To all whom it may concern:

Be it known that I, WILLIAM ASHTON, of Middletown, in the county of Middlesex and State of Connecticut, have invented a new and Improved Bullet-Mold for Casting Hollow or Minié Bullets; and I do hereby declare that the following is a full, clear, and exact description of the same, reference being had to the annexed drawings, making part of this specification, in which—

Figure 1 is a longitudinal section of my improvement. Fig. 2 is a plan or top view of same.

Similar letters of reference indicate corresponding parts in the two figures.

The nature of my invention consists in forming the mold with a movable core, arranged as will be presently shown and described, whereby hollow or Minié bullets may be cast with the greatest facility and in a perfect manner.

To enable others skilled in the art to fully understand and construct my invention, I will proceed to describe it.

A represents the body of the mold, which is formed by drilling a conical aperture, *a*, in a suitable piece of metal, said aperture extending entirely through the piece of metal, so that a small circular opening, *b*, is allowed at its upper end. The piece of metal is provided with a shank or handle, C, to the under surface of which a thin strip of metal, D, is attached by a pivot, *c*, so that said strip D may turn thereon.

To the outer end of the strip D there is attached a conical projection, E, which corresponds in size to the desired opening or cavity of the bullets, and around the lower end of the conical projection upon the strip D there is a circular flange, *d*, which fits within the lower end of the cavity *a*. The strip D is allowed some play upon the pivot *c*.

On the upper end of the piece of metal B there is attached by a pivot, *e*, a metal strip, F, which has a circular aperture, *f*, made through its end directly over the opening *b*. The aperture *f* is beveled or countersunk, so

as to form a cutting-edge at its lower part. The strip F is turned so that the aperture *f* is brought directly over the opening *b*, and the projection E is placed within the conical aperture *a*. The melted lead is then poured through the aperture *f* and opening *b* into the conical aperture *a* till it is filled. The strip F is then turned upon the pivot *e*, and the lower edge of the aperture *f* will cut off the superfluous lead above the upper surface of the piece of metal or mold *a*. The projection E is then withdrawn from the aperture *a* by depressing the end of the strip D, it being sufficiently elastic for that purpose, the bullet being on the projection; or if the bullet remains within the aperture *a* it is forced therefrom by jarring the mold.

The above improvement is extremely simple, and perfect bullets may be cast with rapidity. As the melted lead is poured into the aperture *a*, the air will escape at the lower part of the aperture, for the flange *d* fits only close enough to prevent the escape of the lead and not the air. The bullets, therefore, will be perfectly cast.

The molds of ordinary construction open longitudinally or lengthwise of the aperture *a*, and have a permanent or immovable core. No provision is made for the escape of air, and consequently, unless the lead is poured into the mold cautiously, the bullets will be cast of irregular form, technically termed "screws."

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

Constructing the mold as herein shown and described—viz., having a conical aperture, *a*, made in a piece of metal, and having a projection or core, E, and flange *d* attached to a metal strip, D, which is secured to the shank or handle C of the mold by a pivot, *c*, so that said projection or core may be inserted in and withdrawn from the aperture *a*, as herein shown and described.

WILLIAM ASHTON.

Witnesses:

JAS. GEO. MASON,
J. W. COOMBS.