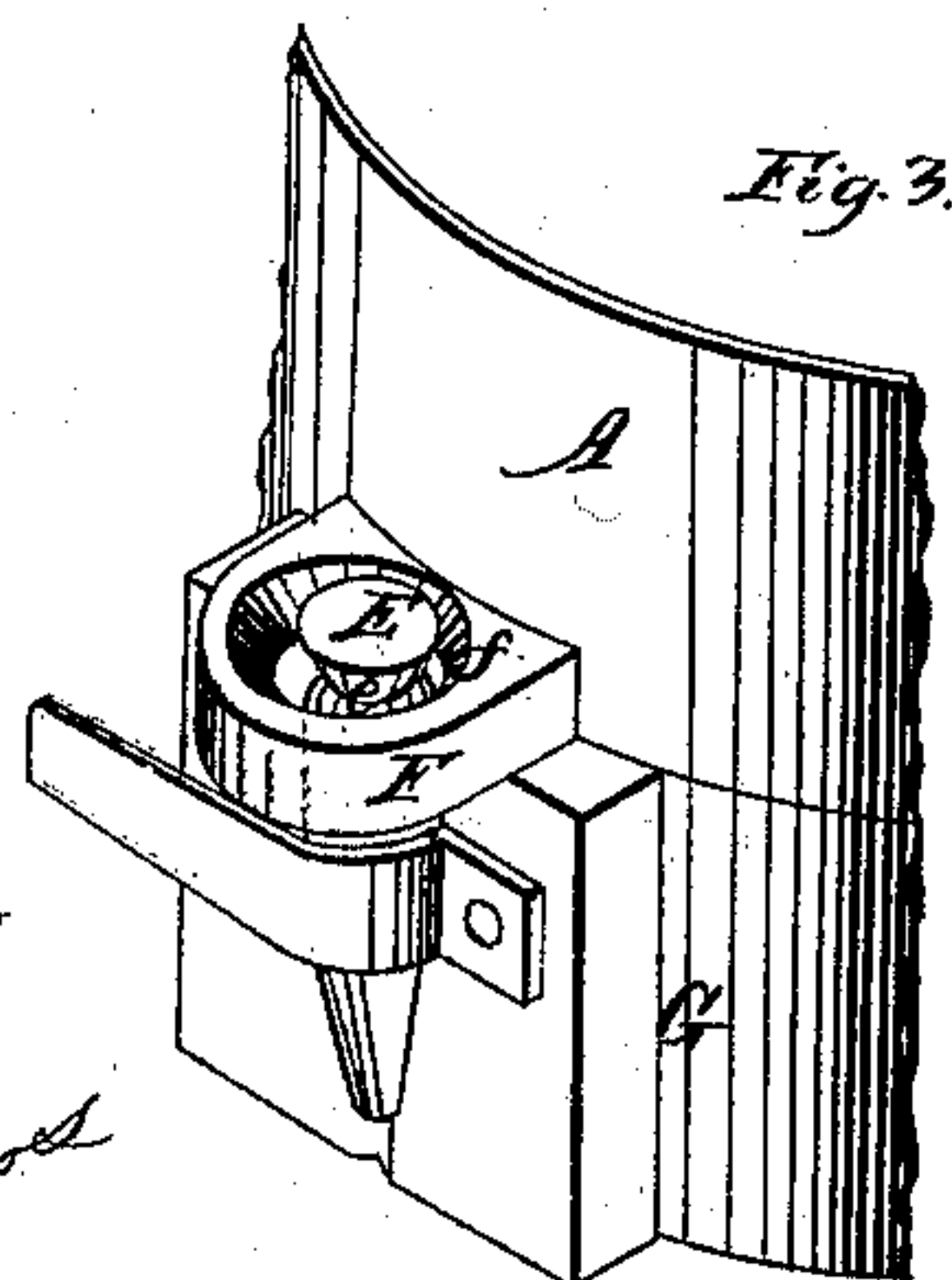
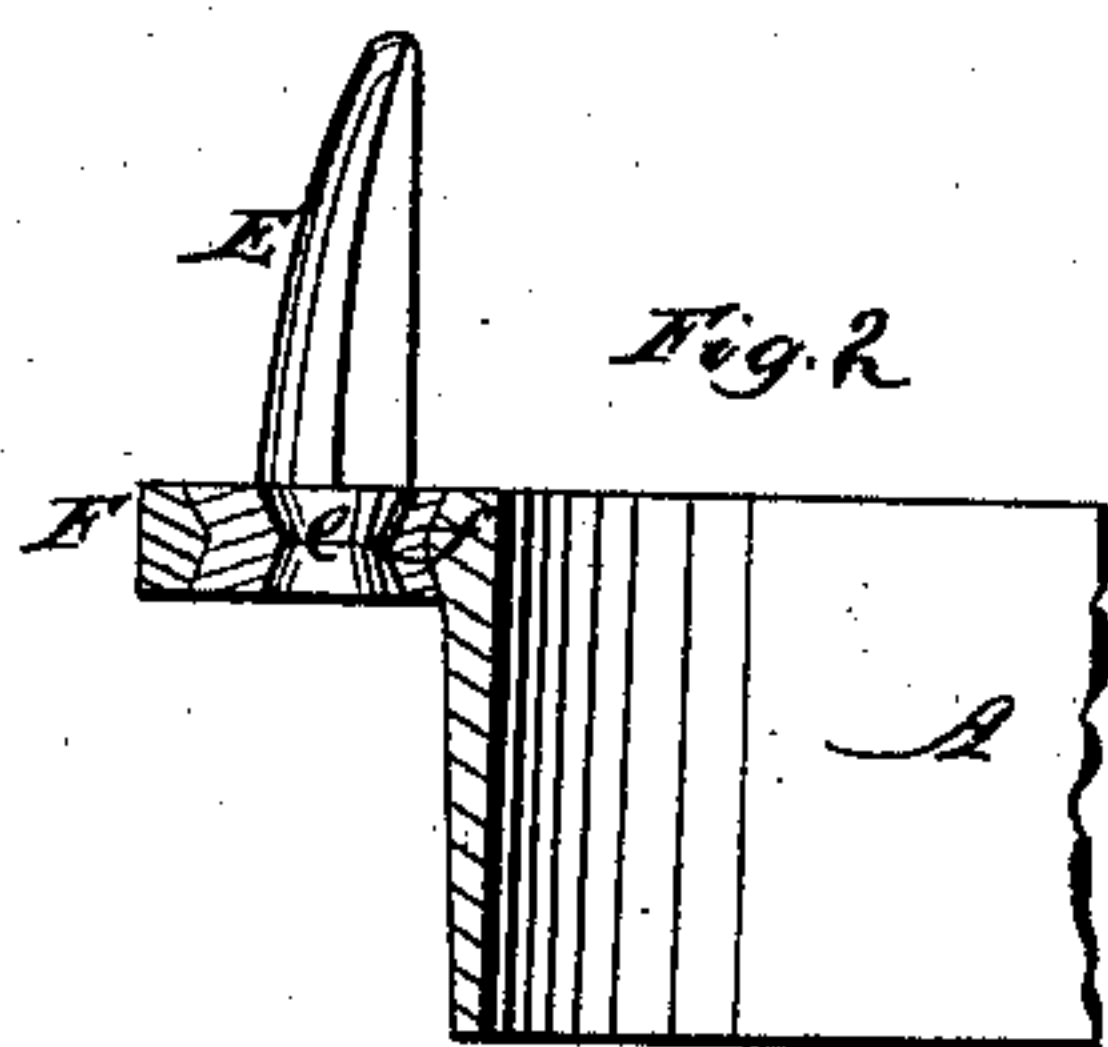
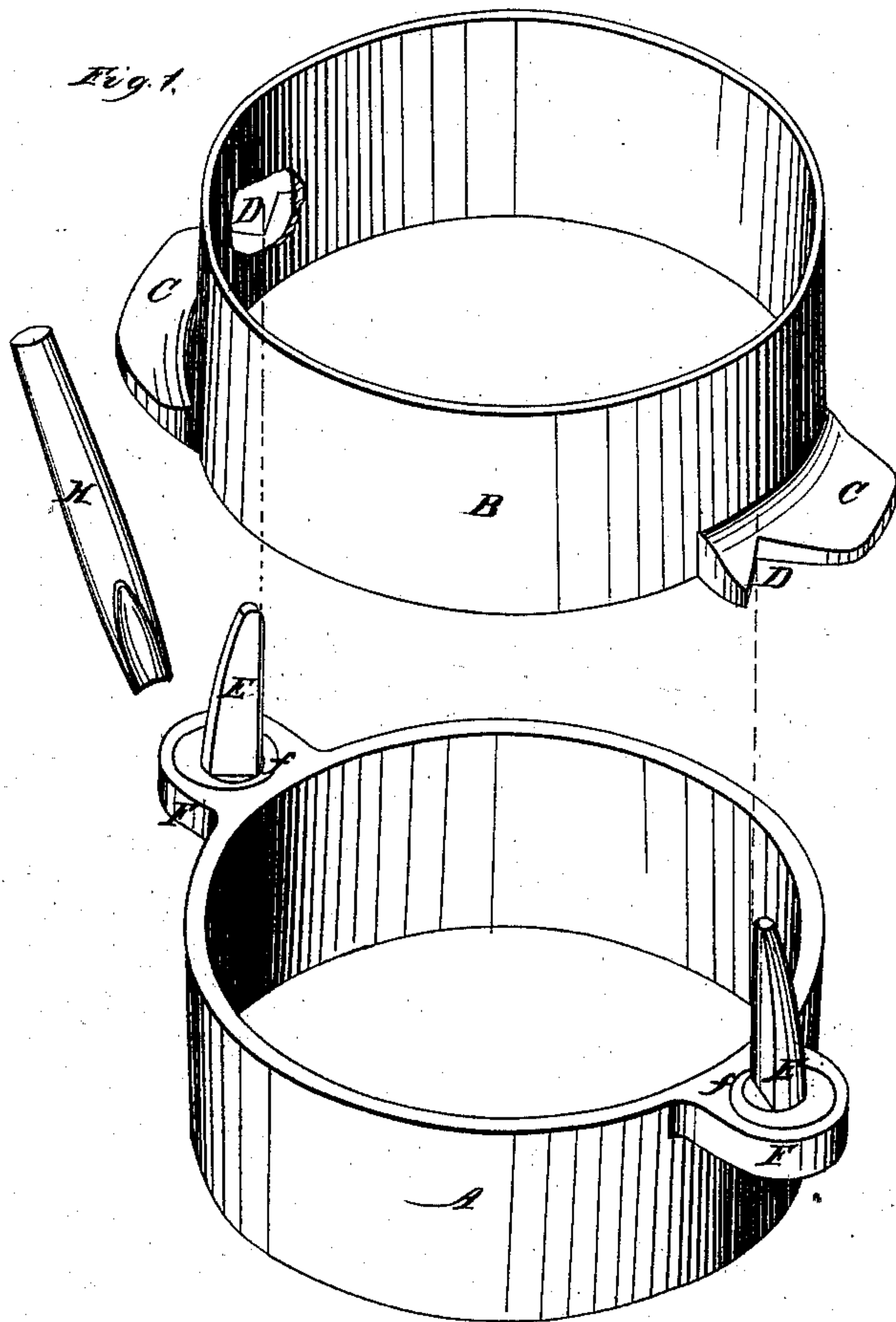


*M. M. Donnelly,
Molders' Flask.*

No 67,850.

Patented Aug. 20, 1867.



*Witnesses
J. H. Lyman
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United States Patent Office.

MATTHEW M. DONNELLY, OF CINCINNATI, OHIO.

Letters Patent No. 67,856, dated August 20, 1867; antedated August 11, 1867.

IMPROVEMENT IN MOULDERS' FLASKS.

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

TO WHOM IT MAY CONCERN:

Be it known that I, MATTHEW M. DONNELLY, of Cincinnati, Hamilton county, Ohio, have invented a new and useful Improvement in Moulders' Flasks; and I do hereby declare the following to be a full, clear, and exact description thereof, reference being had to the accompanying drawings, making a part of this specification.

This invention relates to an improved construction of the guide-pins of a moulder's flask, which enables them to be set up as they wear, so as to insure the accurate coming together of the several parts of the mould, and to avoid unsightly and injurious faults, fins, or seams at the parting line of the casting.

Figure 1 is a perspective view of a moulder's flask provided with my improvement.

Figure 2 is an axial section through the guide-pin and lug.

Figure 3 represents the device for holding and grasping the pin for securing the same accurately in its lug.

I have selected for illustration a cylindrical flask, such as is employed for moulding fly-wheels and other circular objects.

A is the drag and B the cope, the latter having wings C, which serve the twofold purpose of handles, whereby to lift the cope and flask, and to contain the guide notches D. The guide-pins E, instead of being cast solidly to the drag, are secured to it in the following manner: F are lugs, which project laterally from the drag, and have doubly countersunk eyes *f*. That portion of the guide-pin E which is contained in the lug has a contraction or waist, *e*, each guide-pin being confined on opposite sides of a gauge, G, a portion of which is shown in fig. 3. Lead or other fusible metal is cast into the annular space included between the lug and the narrowed portion of the pin.

The pins having been thus accurately cast in place the drag is removed from off the gauge and is ready for use. Whenever the guiding surfaces are so worn as to impair the accuracy of the fit, one or both guide-pins may be set inward with the utmost nicety by the use of a drift, H, on the surface of the soft-metal filling around the pin.

I claim the combination of the lug F with its countersunk hole, *f*, in combination with the pin E, with its waist, *e*, when the two are united and held together by soft metal, in the manner described.

In testimony of which invention I hereunto set my hand.

MATTHEW M. DONNELLY.

Witnesses:

GEO. H. KNIGHT,

JAMES H. LAYMAN.