

A. NEUHAUSEN.

Improvement in the Manufacturing of Candy Whistles.

No. 119,392.

Patented Sep. 26, 1871.

Fig. 1

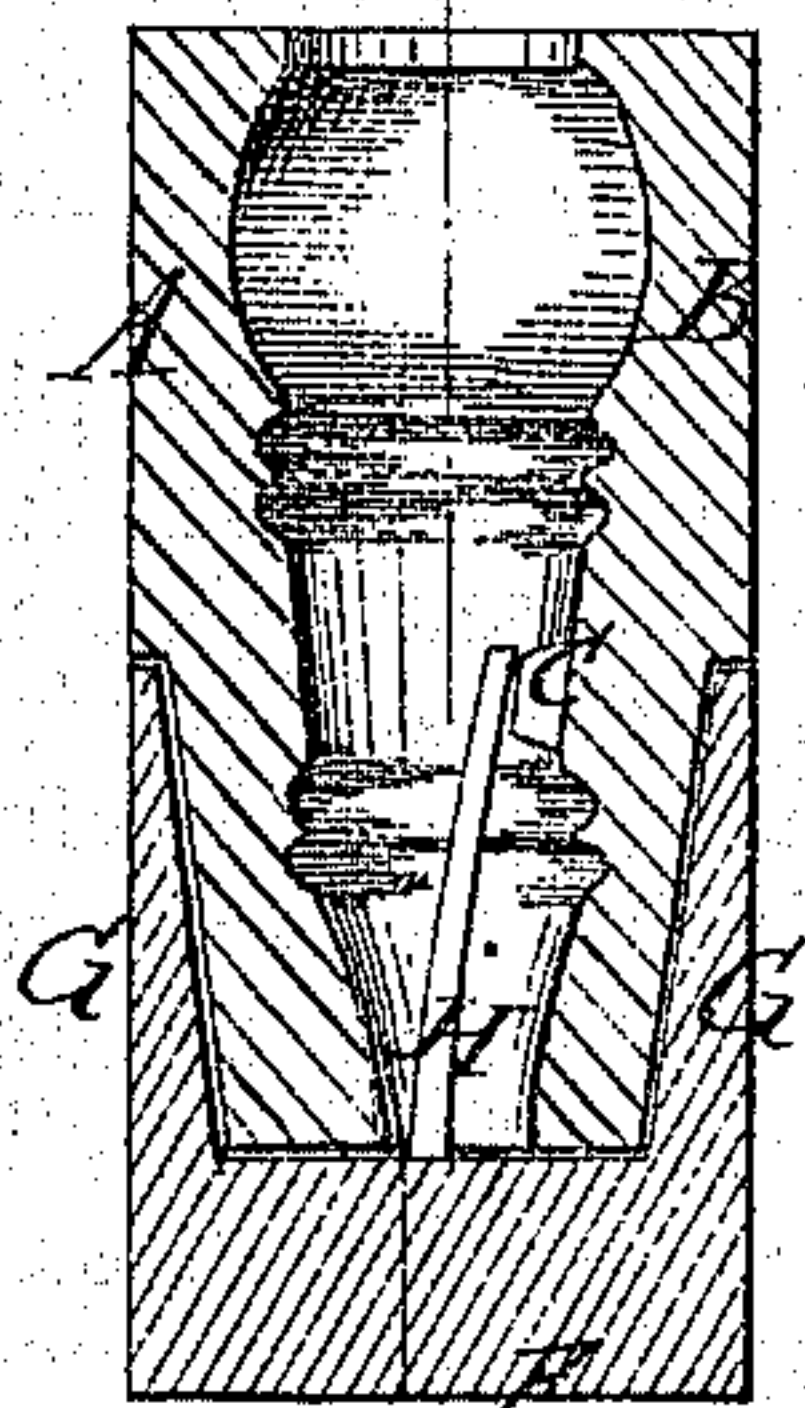


Fig. 3.



Fig. 4.

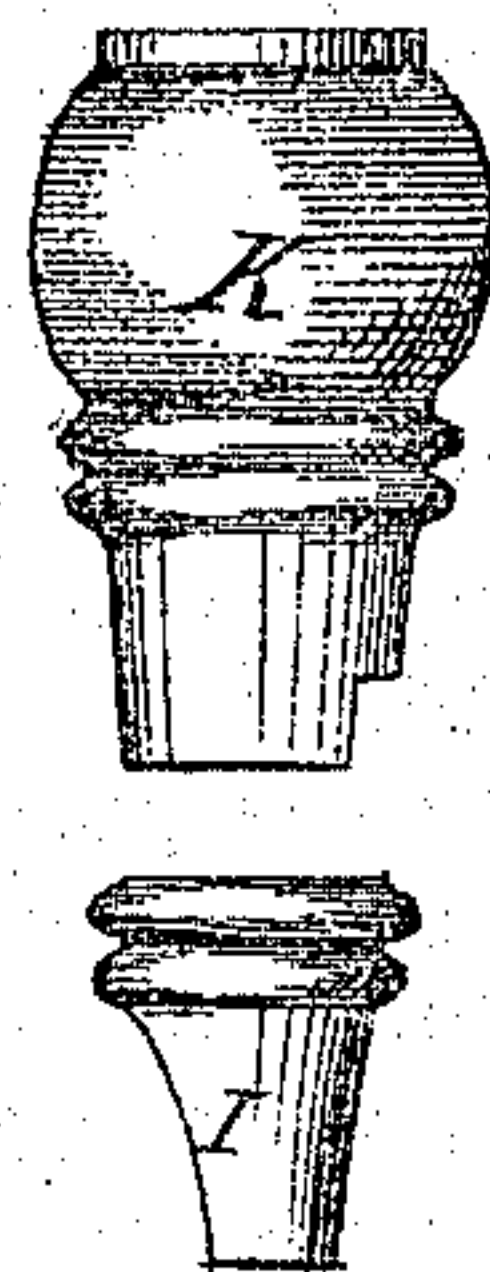
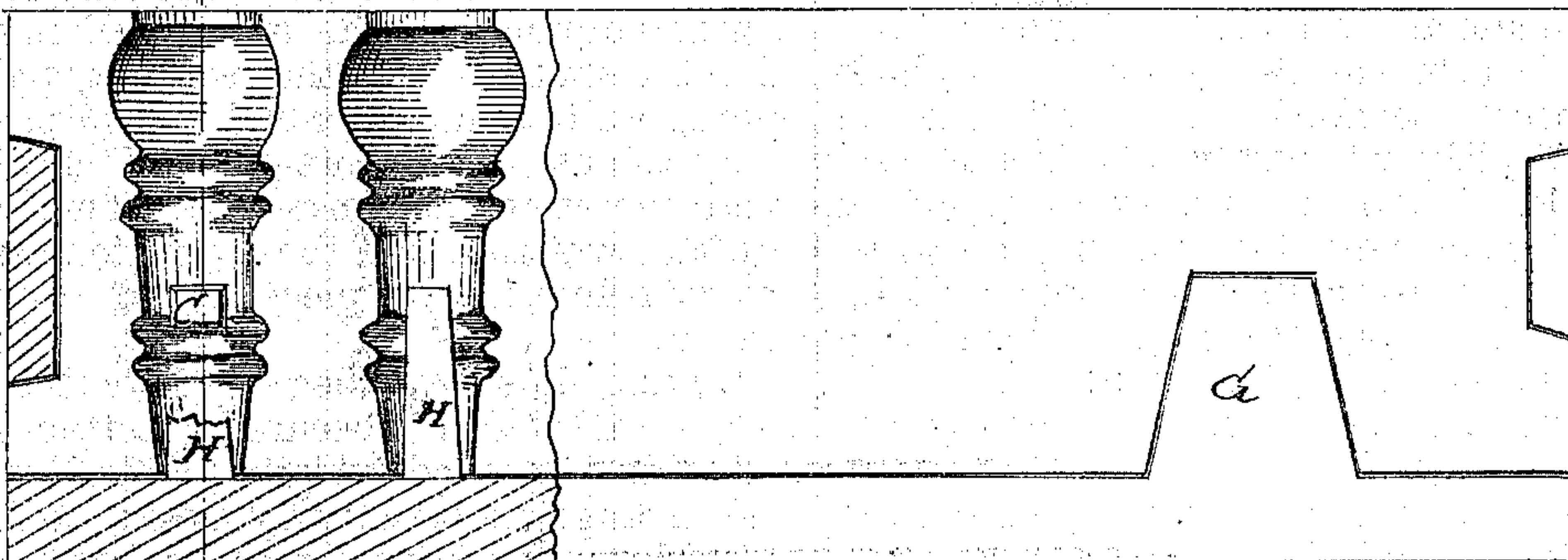


Fig. 2



Witnesses:

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UNITED STATES PATENT OFFICE.

AUGUST NEUHAUSEN, OF WHEELING, WEST VIRGINIA.

IMPROVEMENT IN THE MANUFACTURE OF CANDY WHISTLES.

Specification forming part of Letters Patent No. 119,392, dated September 26, 1871.

To all whom it may concern:

Be it known that I, AUGUST NEUHAUSEN, of Wheeling, in the county of Ohio and State of West Virginia, have invented new and useful Improvements in the Manufacture of Whistler of Candy and other materials; and I do hereby declare that the following is a full, clear, and exact description thereof, which will enable others skilled in the art to make and use the same, reference being had to the accompanying drawing forming part of this specification.

My invention relates to improvements in the manufacture of cast whistles of sugar and other substances; and it consists in a three-part flask of novel construction and a process of casting the whistles, whereby whistles that have heretofore had to be cast in two parts to be afterward connected together may be molded in one piece, thereby saving considerable labor and time, particularly the latter. The invention also comprises a new article of manufacture, consisting of the whistles so made and completed in the casting.

Figure 1 is a transverse section of a blank such as I use, the section being taken on the line *x x* of Fig. 2. Fig. 2 is partly a horizontal section and partly a side elevation of my improved plate. Fig. 3 is an elevation of a complete whistle made according to my improvement; and Fig. 4 is an elevation of the two parts as heretofore made previous to joining them together.

Similar letters of reference indicate corresponding parts.

A and B are two parts which together have the molds for the exterior of the whistle, to be cast in one piece. The part B is provided with a stud, C, to form the cavity D in the side, to connect with the channel or wind-passage leading from the mouth-piece E to said opening to produce the sound. F is a third part of the flask, corresponding to the mold-board of an ordinary two-part flask, but provided with the dowels G to adjust it relatively to the parts A B, which have notches to correspond, and it has metallic core-piece H to form the channel or air-passage leading from the mouth to the opening D. This

core-piece runs up against the inner end of said projection and as high as the top of it, so that they form a continuous passage. One set of pieces, A B F, may have as many molds as preferred.

The casting is effected by placing the flask in the position indicated in the drawing, filling the molds with the molten substance, which begins to chill and harden whenever it is in contact with the metal, gradually solidifying to the center; but as it is desirable not to have the whistle made solid the flask is turned upside down as soon as a shell of sufficient thickness is formed and the remaining substance is poured out, leaving a hollow space below the wall formed along the core H by chilling on it. The piece F is then lifted off, withdrawing the cores H, after which the two parts A B are separated to liberate the castings.

Heretofore these whistles have been cast in two pieces, I and K, to be joined on a line at the upper end of the passage D, the part I being hollow throughout and the opening D in the part K being shut off from the hollow space by a dividing wall at the lower end of said passage D.

By the use of the core-piece H and the complete molds in the parts A B, I am enabled to produce whistles with the requisite passage and cavity below, in one piece, at one operation, as shown.

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

1. The improved whistle-molds, constructed and arranged substantially as specified.

2. The process of casting whistles complete in one piece on a core-piece, and a stud arranged in the mold to form the air-passage, substantially as herein specified.

3. As an improved article of manufacture, a whistle, composed of sugar or other substance cast in one piece and having the air-passage formed on cores, substantially as specified.

AUGUST NEUHAUSEN.

Witnesses:

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