

V. PRICE.

Casting Ornaments for Sword Scabbards.

No. 139,023.

Patented May 20, 1873.

Fig. 1.

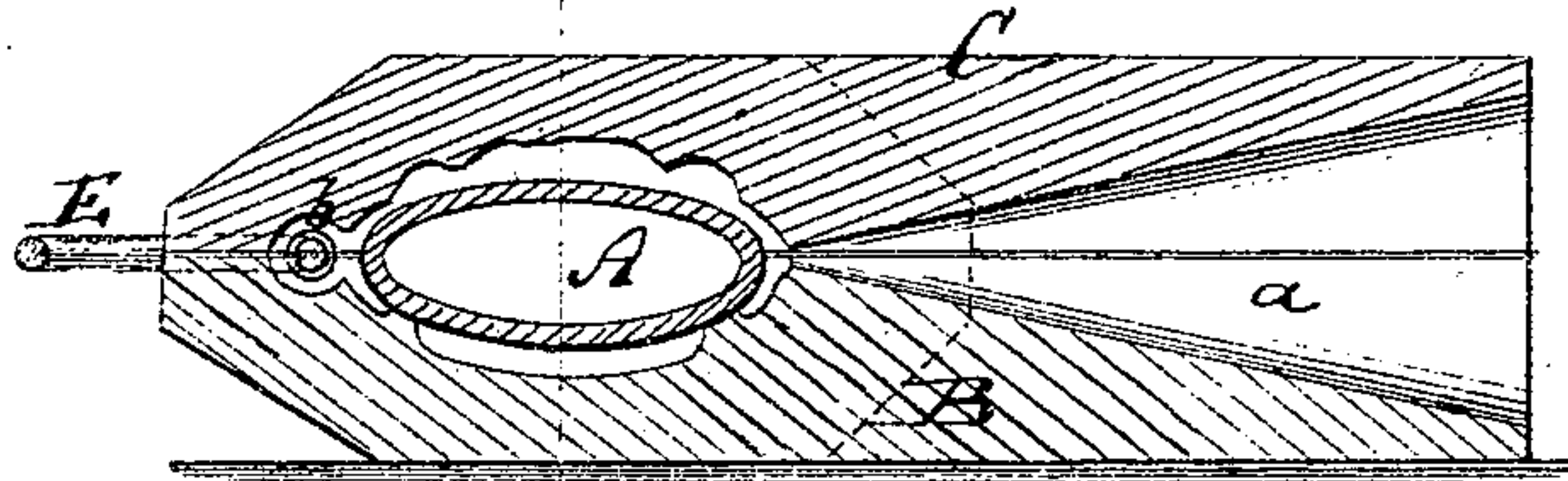


Fig. 2.

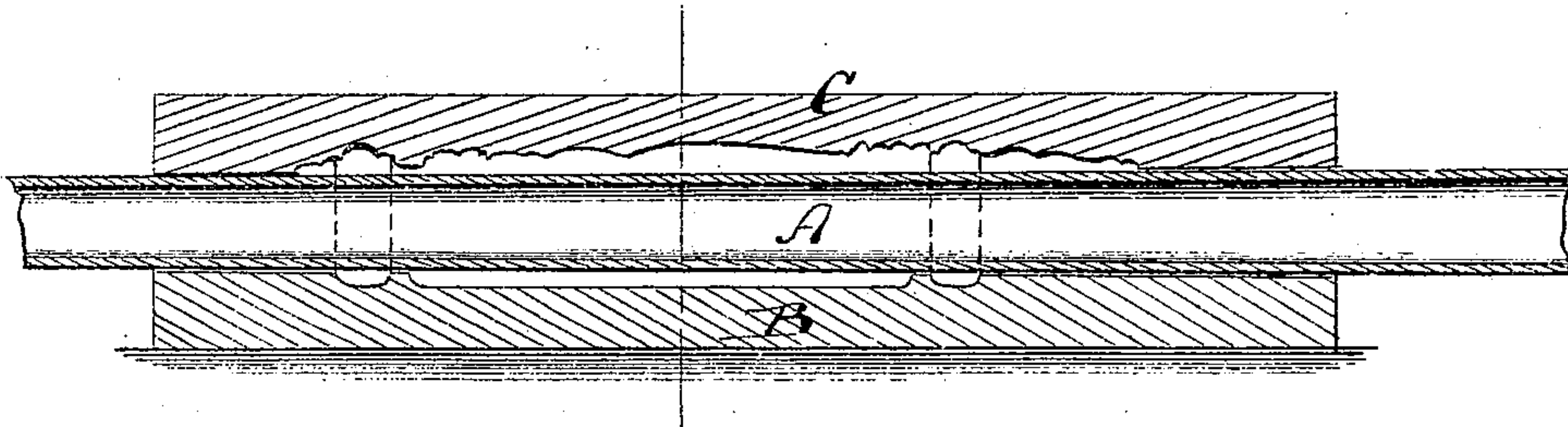
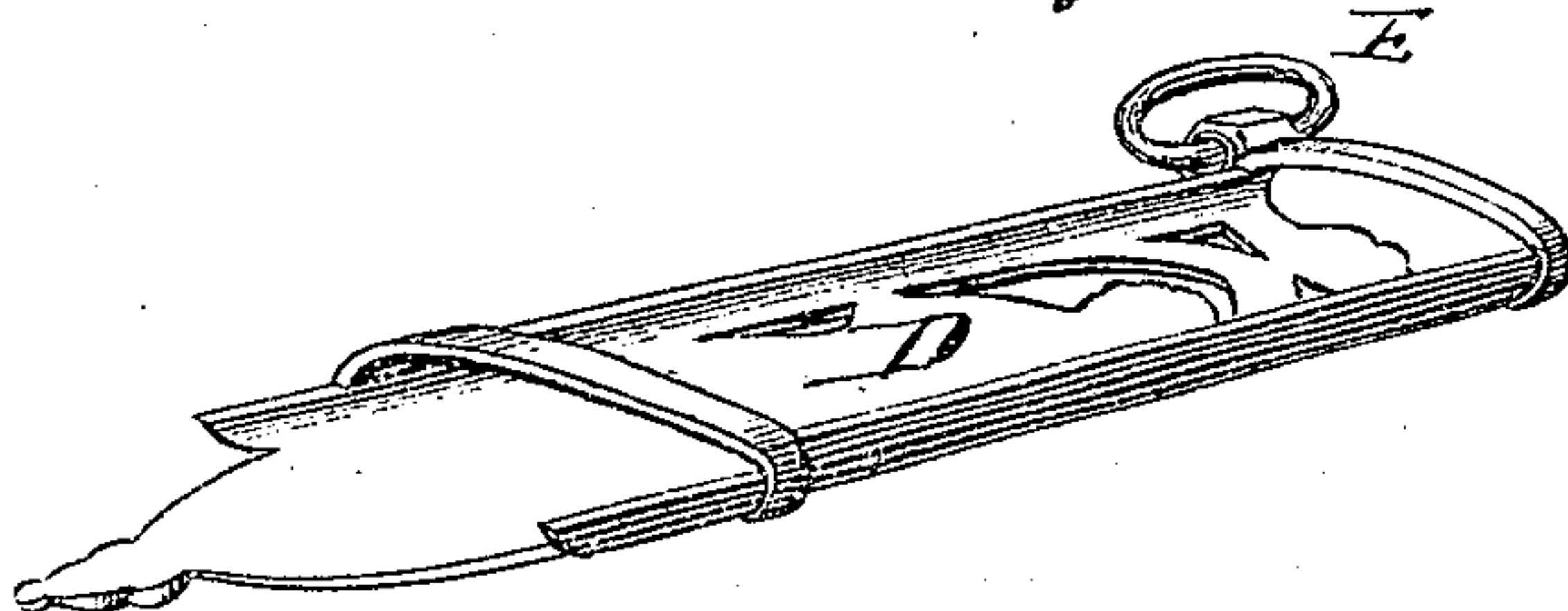


Fig. 3.



Witnesses.  
John Pecker.  
Fred Haynes

Virgil Price  
by his Attorneys  
Brown & Allen

# UNITED STATES PATENT OFFICE.

VIRGIL PRICE, OF WOODSIDE, NEW YORK.

## IMPROVEMENT IN CASTING ORNAMENTS FOR SWORD-SCABBARDS.

Specification forming part of Letters Patent No. **139,023**, dated May 20, 1873; application filed March 27, 1873.

*To all whom it may concern:*

Be it known that I, VIRGIL PRICE, of Woodside, in the county of Queens, and State of New York, have invented an Improved Mold for Casting Ornaments on Sword-Scabbards, of which the following is a specification:

This invention has for its object to permit the casting of ornaments on sword-scabbards direct, so that each scabbard will constitute the core of the mold in which such ornament is cast.

By this means I am enabled to fit each ornament with great exactitude and cheaply to each scabbard. In manufacturing sword-scabbards, which are ornamented by means of metallic clasps that embrace them, I find the scabbards are never exactly alike. They always differ more or less, and when the ornaments are cast in a mold with a solid core, they will have to be specially refitted, cut away, or bent, to fit the scabbards. By casting them directly on the scabbard an exact fit is of course produced, and I can, after the process of casting has been completed, mark the scabbard containing such ornament, and the ornament itself, to be able subsequently to replace the ornament on its proper scabbard; for, after casting, I withdraw the ornamental clasp from the scabbard-core in order to polish or plate the latter, and also the former, and when the surfaces have been entirely completed, the final connection of the parts is effected.

In the accompanying drawing, Figure 1 represents a transverse section of a sword-scabbard and mold. Fig. 2 is a longitudinal section thereof, and Fig. 3 a perspective view of an ornamental clasp for a scabbard.

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

The letter A in the drawing represents a sword-scabbard of suitable size and shape. B and C are parts of the mold properly prepared to form bas-relief or other ornaments on the clasp D, which is cast between such mold and scabbard, the scabbard constituting the core of such mold, as shown. A sprue-hole, *a*, is provided in the mold to receive the metal which is to be cast upon the scabbard. After the metal has been cast around the scabbard-core, and within the mold B C, the mold is opened and the scabbard then withdrawn from the ornament to leave the latter in the desired form, and both parts, the scabbard and ornament, may then be polished, painted, or otherwise treated in suitable manner, after which the ornament is again replaced on the scabbard and fastened thereto by screws, rivets, or other suitable means.

For the purpose of applying, during the process of casting, the scabbard-ring E to the ornament D, I provide a recess for the reception of such ring in the mold B C, and place around the ring a thin lining, *b*, of metal foil or fine metal. When the cast metal is poured into the mold it will reach and combine with the lining *b*, which will then constitute a bushing, allowing the ring E to play in the casting in the requisite manner.

I claim as my invention, and desire to secure by Letters Patent—

The process, herein described, of forming ornaments on sword-scabbards by casting them directly upon the scabbards, and subsequently removing them therefrom, as set forth.

VIRGIL PRICE.

Witnesses:

A. V. BRIESEN,  
FRED. HAYNES.