

(No Model.)

S. CLARKE.

MANUFACTURE OF NIGHT LIGHTS.

No. 329,536.

Patented Nov. 3, 1885.

Fig. 1.

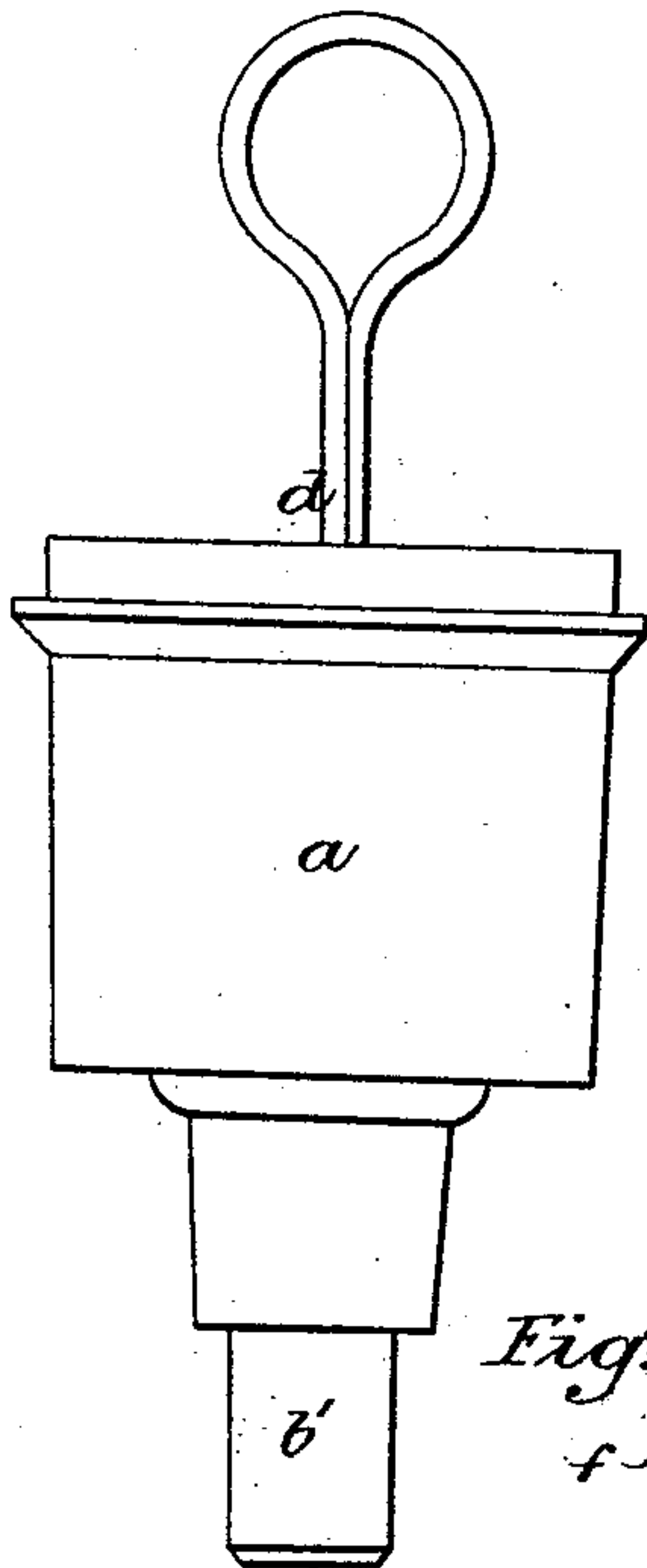


Fig. 2.

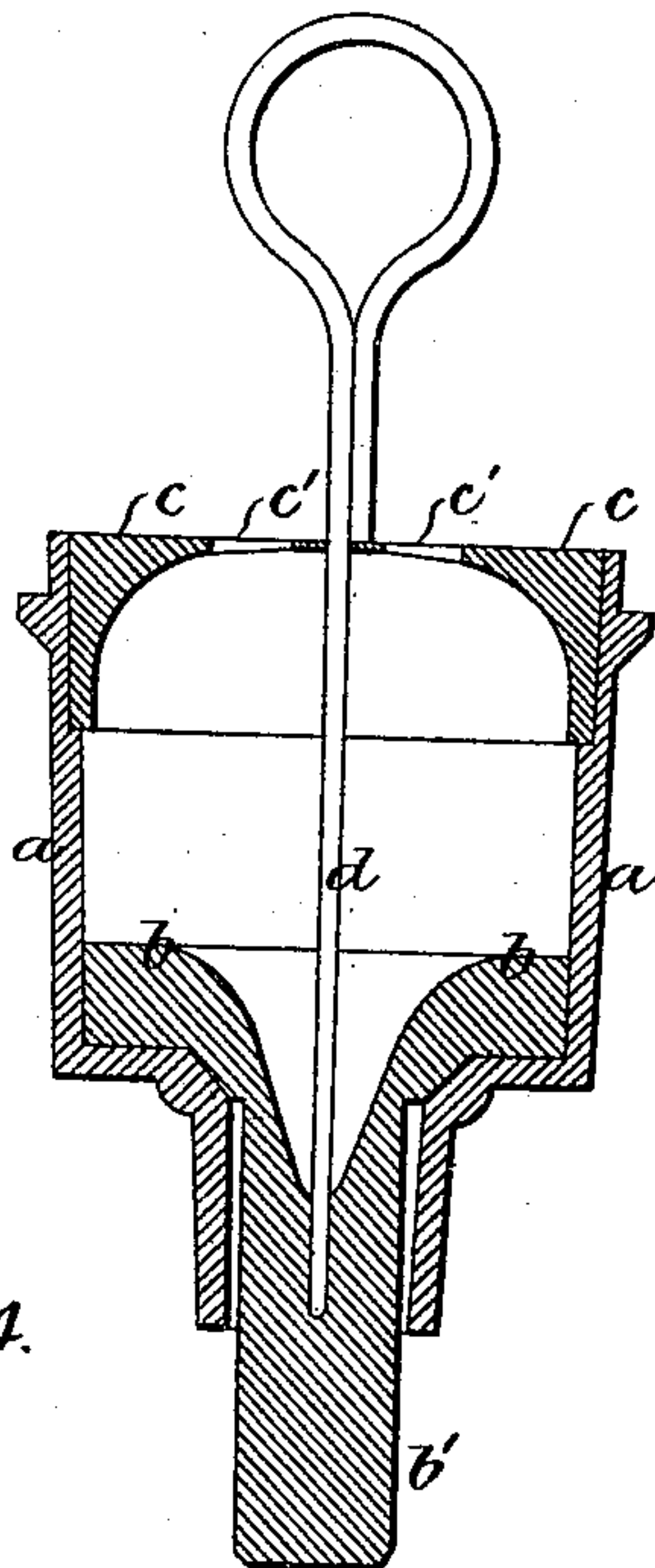


Fig. 3.

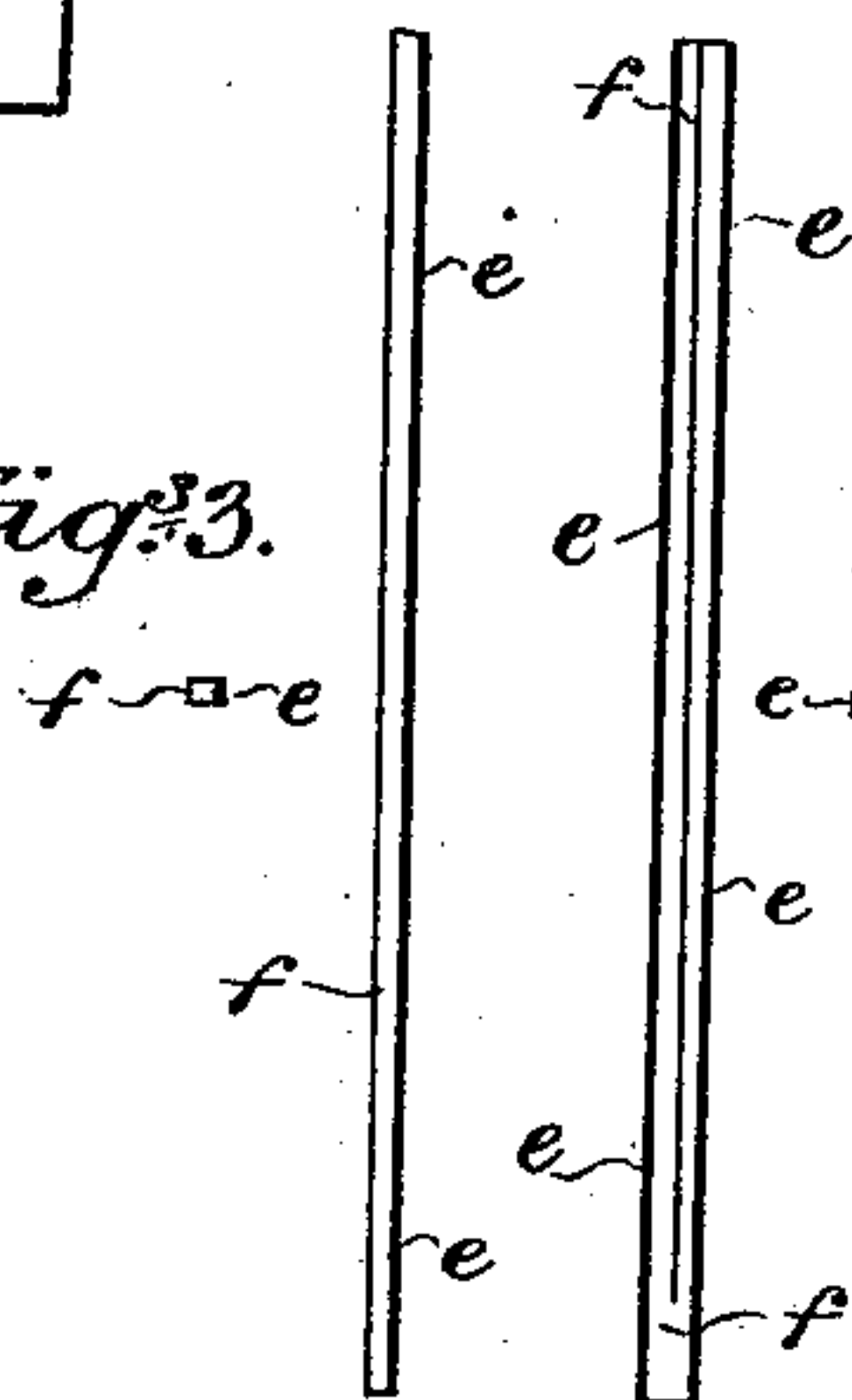


Fig. 4.

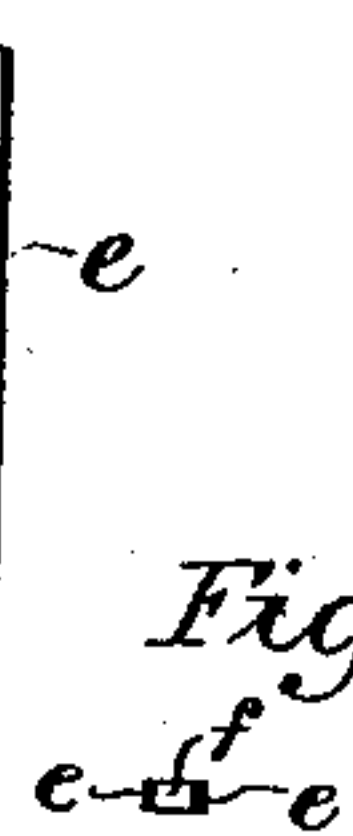
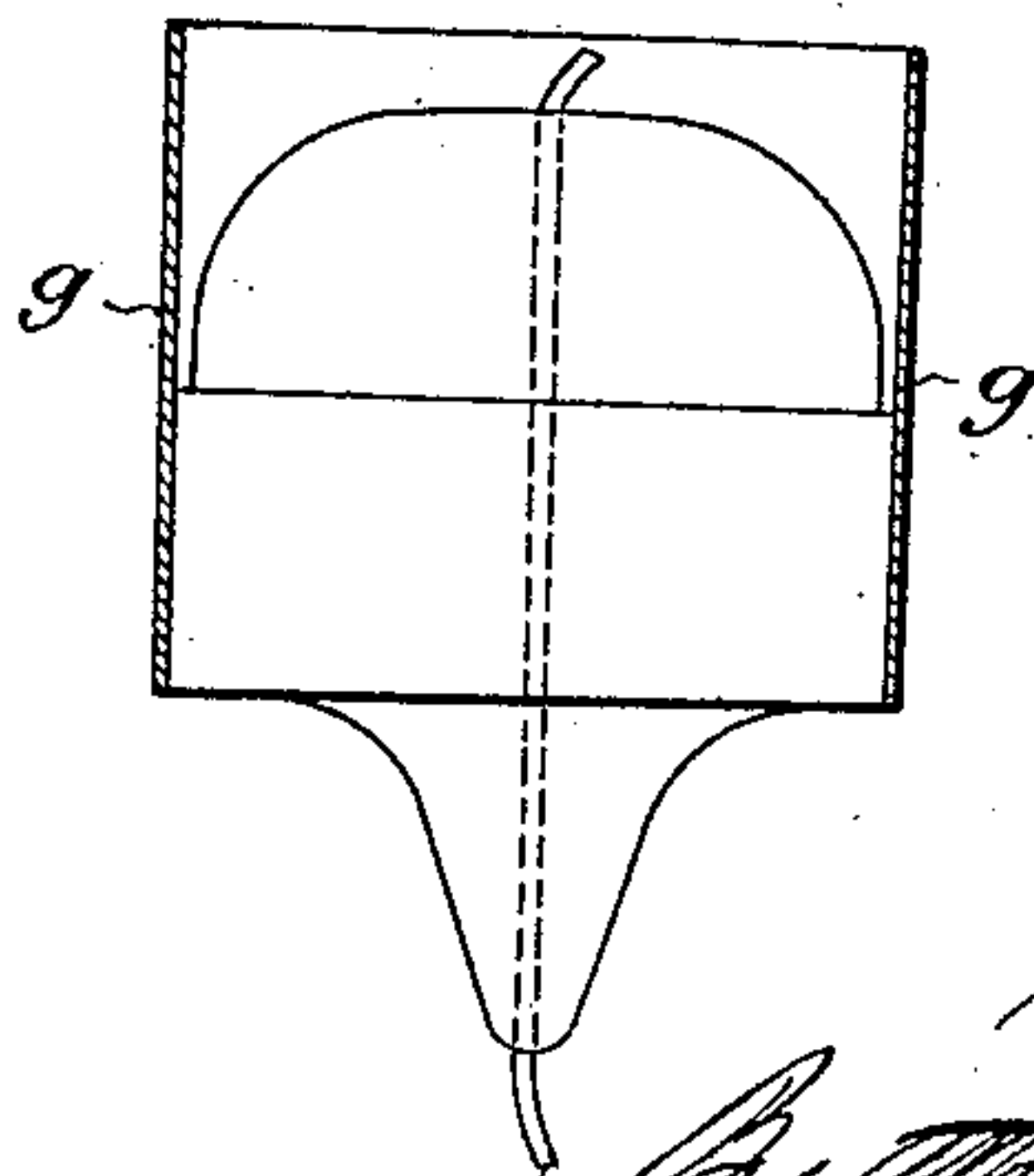


Fig. 5.



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MANUFACTURE OF NIGHT-LIGHTS.

SPECIFICATION forming part of Letters Patent No. 329,536, dated November 3, 1885.

Application filed April 9, 1885. Serial No. 161,668. (No model.) Patented in England March 21, 1885, No. 3,683.

To all whom it may concern:

Be it known that I, SAMUEL CLARKE, of the Childs Hill Works, in the county of Middlesex, England, candle and night-light manufacturer, a subject of the Queen of Great Britain, have invented certain new and useful Improvements in the Manufacture of Night-Lights, of which the following is a specification.

10 This invention has for its object improvements in the manufacture of night-lights, and relates especially to night-lights having a wick consisting of a strip of rush with the bark left on one side only. This is done with the intention of causing the top of the wick to turn
15 out of the flame. Such night-lights have heretofore been made by casting the fatty material onto the wick itself; but for reasons which it is unnecessary here to state there is
20 great difficulty in obtaining a perfect night-light of this class in this manner. I overcome these difficulties by casting the mass of fatty material with a wire in place, instead of the
25 strip of rush. I leave the rush projecting beneath the mass of fat, and I cast plaster-of-paris around it to form the base to the night-light. I form the block of fatty matter with
30 a conical projection at the top, as in an ordinary pyramid night-light of my manufacture. The object of this is to prevent the rush from being bent and semi-broken close down to the
35 body of the fat, which would prevent the wick from being readily lighted. Where considerable light and heat are required, I cast the block of fatty material upon a flat wire, and after
40 drawing this wire I insert a strip of rush divided down the center and with the bark removed on two opposite sides. This in burning forms two wicks. Similarly I make a
45 night-light with four wicks, inserting after the wire has been withdrawn a rush divided longitudinally into four strips.

In order that my said invention may be most fully understood and readily carried into effect, I will proceed to describe the drawings hereunto annexed.

50 In the drawings, Figure 1 is a side elevation, and Fig. 2 is a vertical section, of a night-light mold such as I employ in the manufac-

ture of my improved night-lights. Figs. 3 show a wick suitable for the same. Figs. 4 show another form of wick. Fig. 5 is a section of the finished night-light.

The mold consists of a barrel, *a*, which receives into it a movable lower end, *b*, having a stem, *b'*, and also a movable cover, *c*, in which are apertures *c' c'*, one for filling the mold with the melted fatty material and the other for the escape of air from the mold. 55 The cover *c* also has a hole in it for the passage of the wire *d*, and the lower end of the wire enters another hole bored centrally through the stem *b'*. After the mold has been filled and the fatty matter has solidified, and 60 the excess has been scraped off, the movable end *b* is raised by means of its stem *b'*, and so the molded block of fatty material is ejected from the mold. It will be understood that as is usual numerous molds are arranged in a 65 frame, and all are filled at the same time. It is, as will be seen, the lower end of the mold which gives the form to the upper surface of the night-light having the conical or tapering projection for protecting the wick. The wire 70 *d* is drawn out, leaving a hole through the mass of fatty material, and into the hole a wick is inserted, consisting of a strip of rush having the bark left on one side. This wick is represented in Figs. 3, and the bark is in- 80 dicated by the thick line *e*. On the other side of the wick is the pith *f* of the rush. When the night-light is burned, the wick deflects toward the side on which the bark is left. The mass of fatty matter is placed within a 85 cylindrical envelope of paper, *g*, as is usual in making night-lights of this class, and liquid plaster-of-paris is poured in to fill the projecting end of the envelope, the night-light being then in an inverted position, as it is repre- 90 sented in Fig. 5. The projecting end of the rush wick becomes embedded in the plaster, and this fixes it in place. Sometimes I make a two-wick night-light, the wick being then a strip of rush with the bark left on two sides 95 and divided down the middle, as is represented by Figs. 4. Similarly a triple or quadruple wick may be produced, and such wicks may be used with advantage in night-lights to be primarily employed for heating purposes. 100

Having now particularly described and ascertained the nature of my said invention and in what manner the same is to be performed, I declare that what I claim is—

- 5 The process for the manufacture of night-lights, which consists in casting upon a wire a cylindrical mass of fatty material having a conical or tapering projection from its upper surface, withdrawing the said wire, and inserting in its place a rush wick, also surrounding

the mass with a wrapper projecting beyond it on the under side, and filling this projecting part of the wrapper with plaster, all substantially as herein described.

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