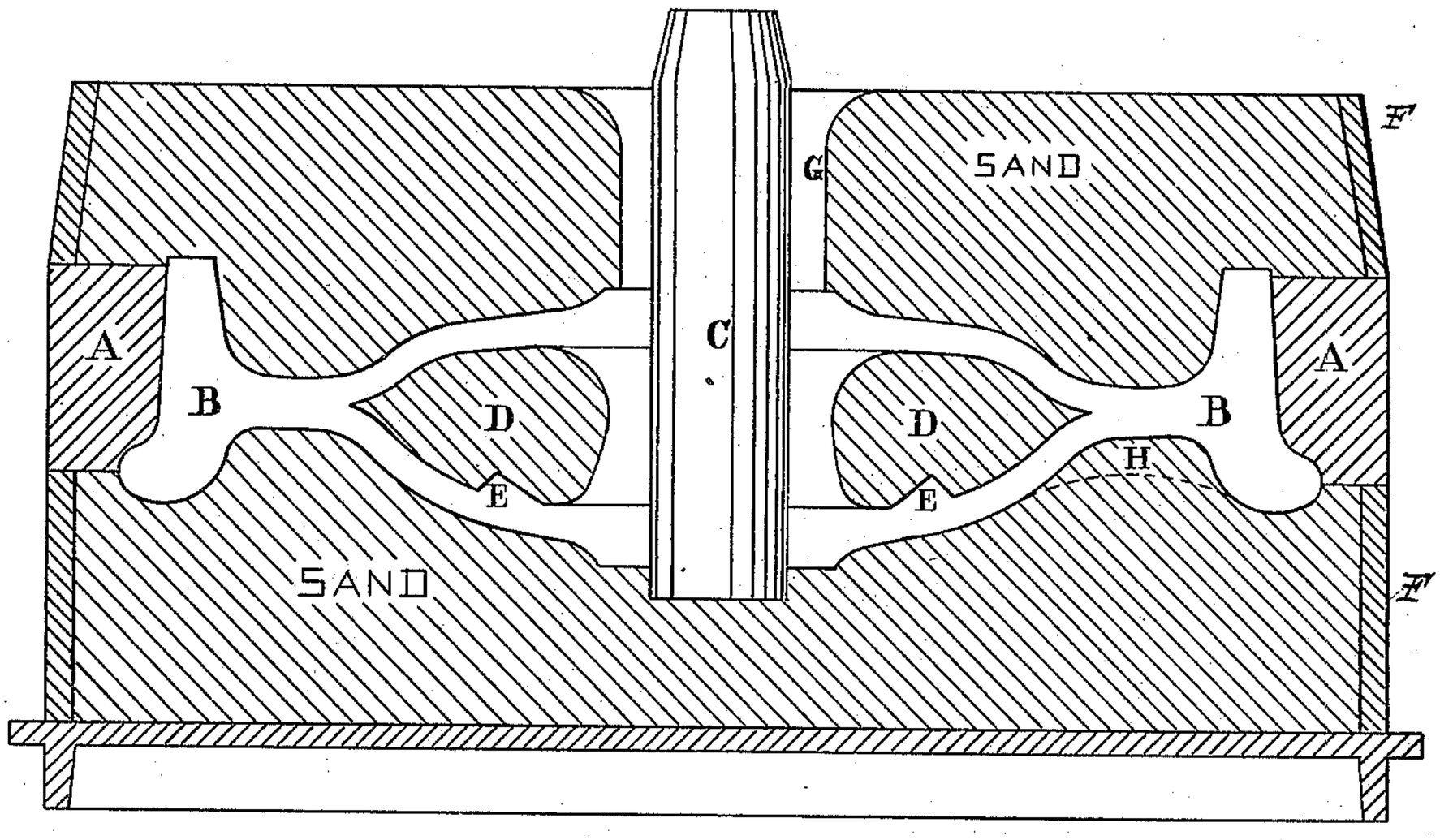
(No Model.)

T. H. PASCO.

MOLD FOR CASTING.

No. 383,318. Patented May 22, 1888.



WITNESSES.
Henry D. Lothrop.
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INVENTOR,
Thomas H. Pasco.
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atty.

UNITED STATES PATENT OFFICE.

THOMAS H. PASCO, OF DETROIT, MICHIGAN, ASSIGNOR TO THE DETROIT CAR WHEEL COMPANY, OF SAME PLACE.

MOLD FOR CASTING.

SPECIFICATION forming part of Letters Patent No. 383,318, dated May 22, 1888.

Application filed March 21, 1888. Serial No. 268,004. (No model.)

To all whom it may concern:

Be it known that I, THOMAS H. PASCO, of Detroit, in the county of Wayne and State of Michigan, have invented a new and useful Improvement in Molds for Casting, of which the following is a specification.

This invention has for its object to provide a novel mold for casting wheels and other articles; and it consists of the features of construction hereinafter described and claimed.

The drawing is a vertical section through a car-wheel mold.

F represents a flask, in two parts, in which the mold is formed.

A represents the chill, and B the space for the car-wheel.

H represents one of the elevations in the mold, between which the ribs on the side of the wheel are formed, the top of the rib being represented by the dotted line beneath.

D represents a core, supported in the mold in the usual manner to form the hollow of the wheel, and C represents a core to form the hole in the center of the wheel.

G represents the gate through which the molten metal is poured.

In casting car-wheels the molten metal descends to the bottom of the mold and then flows in each direction under the core D toward the tread of the wheel, and finally returns above the core D until it meets the metal flowing through gate G. Any slag or dross which is in the molten metal, being lighter than the metal, flows along on the surface of the metal until it reaches the ends of the core D, and then, flowing upward with the metal, strikes against the lower part of the mold and is retained there, so that finally it is embedded at that point where the wheel branches from a single into a double plate, thus weakening the weakest point of the wheel and causing breakages. My invention is designed to obviate this difficulty; and it consists in a core, D, having in its under side an annular groove, E.

As the molten metal rises in the mold and flows outward in all directions from the gate, it comes in contact with the under surface of the core D, and the slag or dross which floats on the metal rises into and is held by the groove E, so that it is prevented from reaching any other part of the wheel, and, instead of weakening any part of the wheel, does no injury.

I have shown my invention as applied to a car-wheel mold; but it of course may be applied to any mold in which the molten metal flows along the under side of a core before rising and flowing above the upper side.

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

1. In a mold for casting, a core having on its under side an annular groove, substantially as and for the purposes set forth.

2. In a mold for casting, a core having on its under side a groove adapted to arrest slag carried on the surface of molten metal, substantially as shown and described.

THOMAS H. PASCO.

Witnesses:

OLIVER PHELPS,

J. H. WHITING.