

(No Model.)

2 Sheets—Sheet 1.

E. REDDY.
METHOD OF MOLDING.

No. 390,398.

Patented Oct. 2, 1888.

Fig. 1.

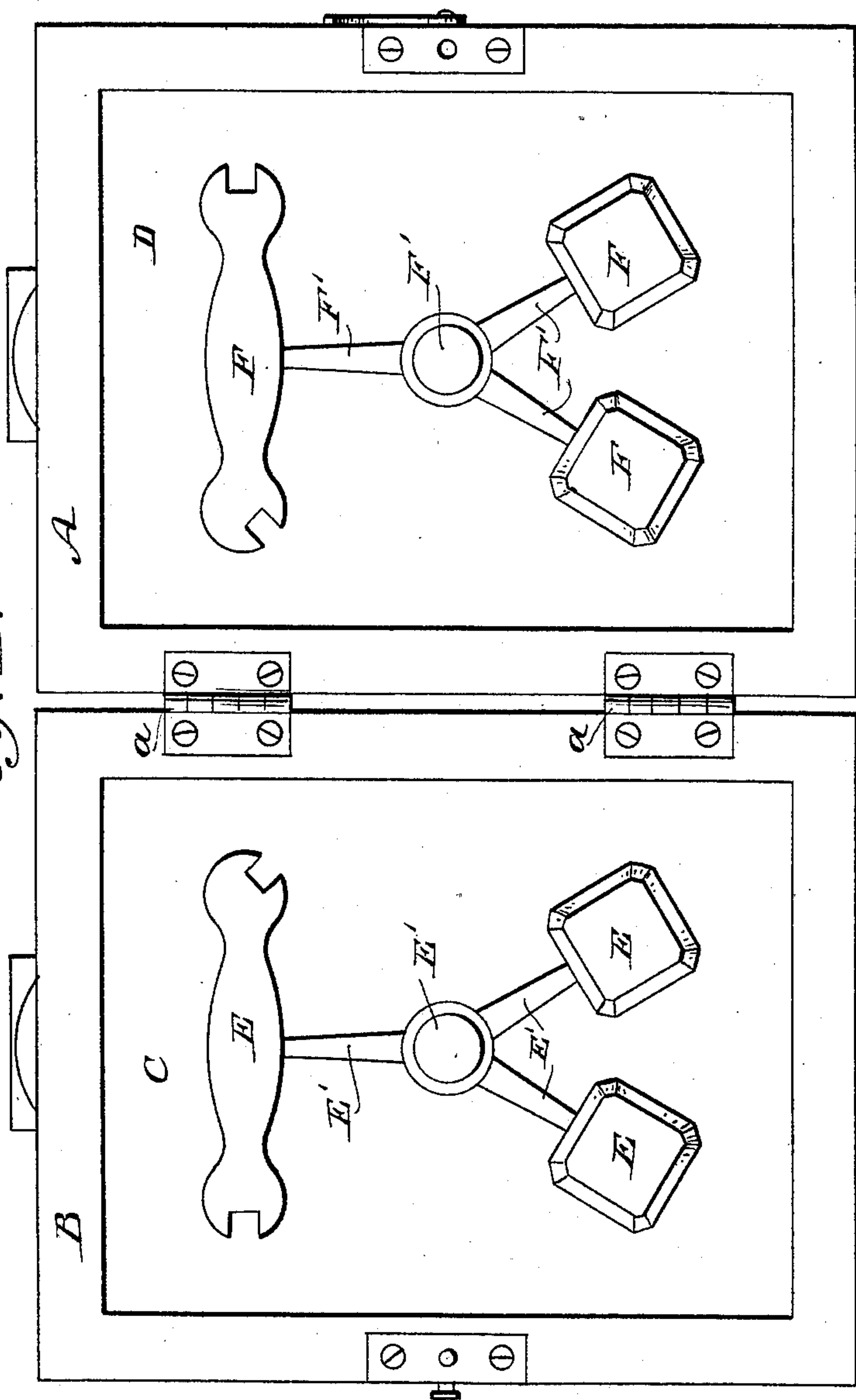
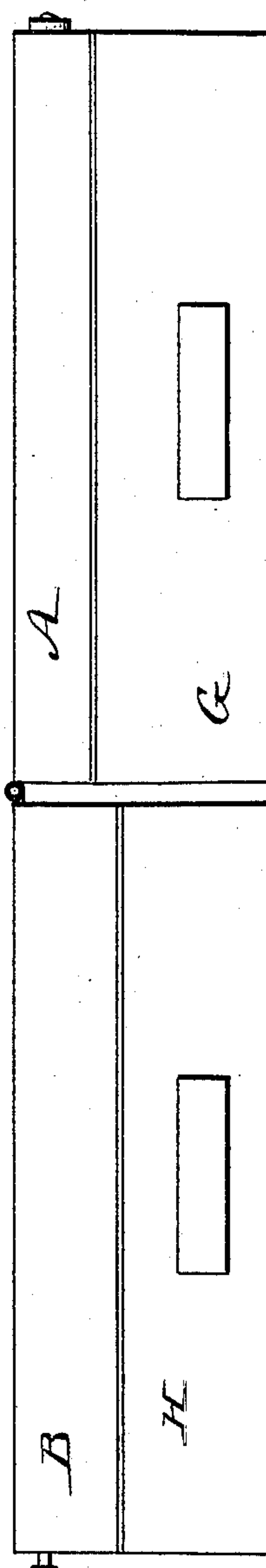


Fig. 2.



WITNESSES:
John H. Deane
E. M. Clark

INVENTOR:
Edward Reddy
BY *Munn & Co*
ATTORNEYS.

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Fig. 3.

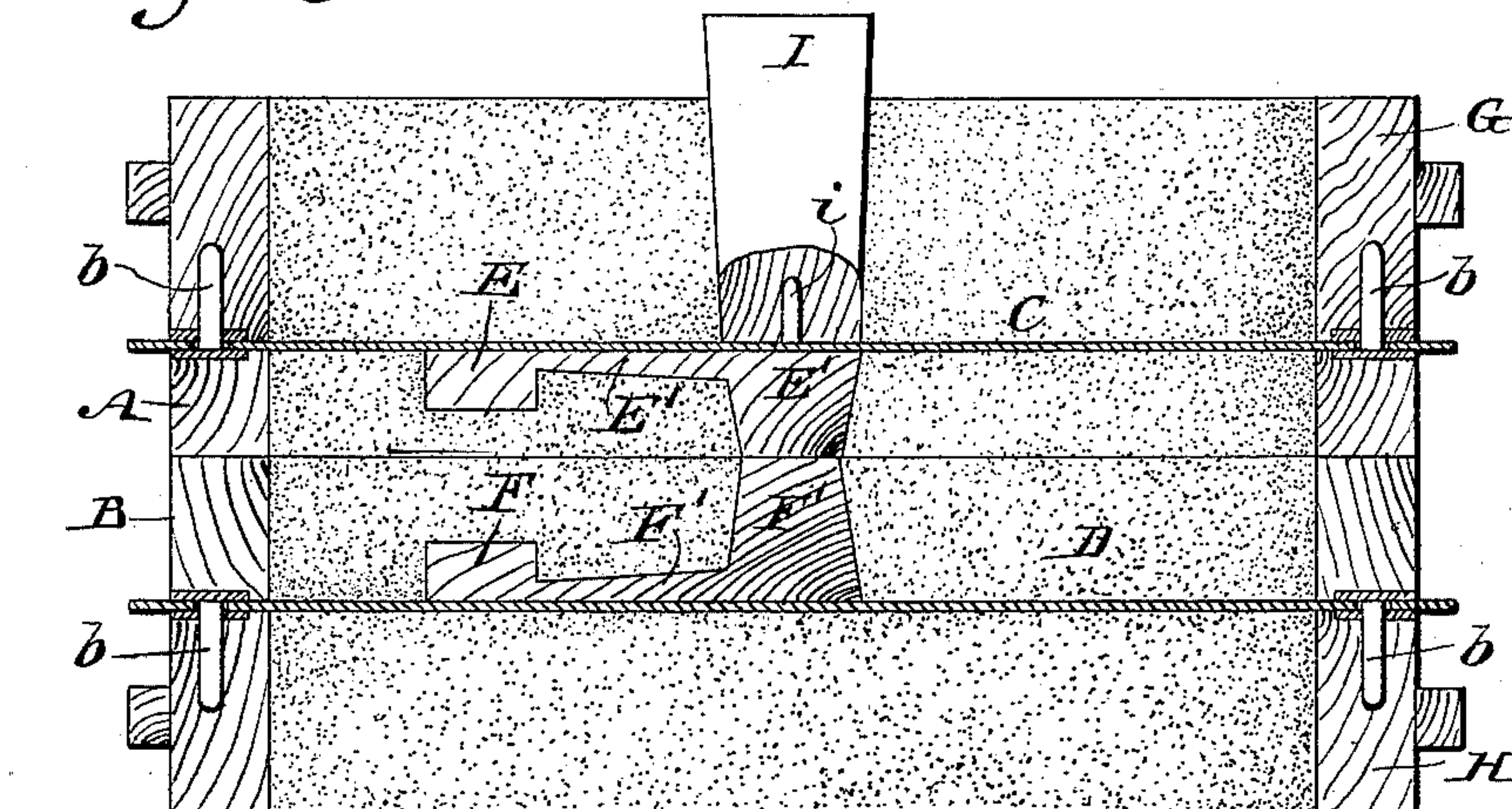
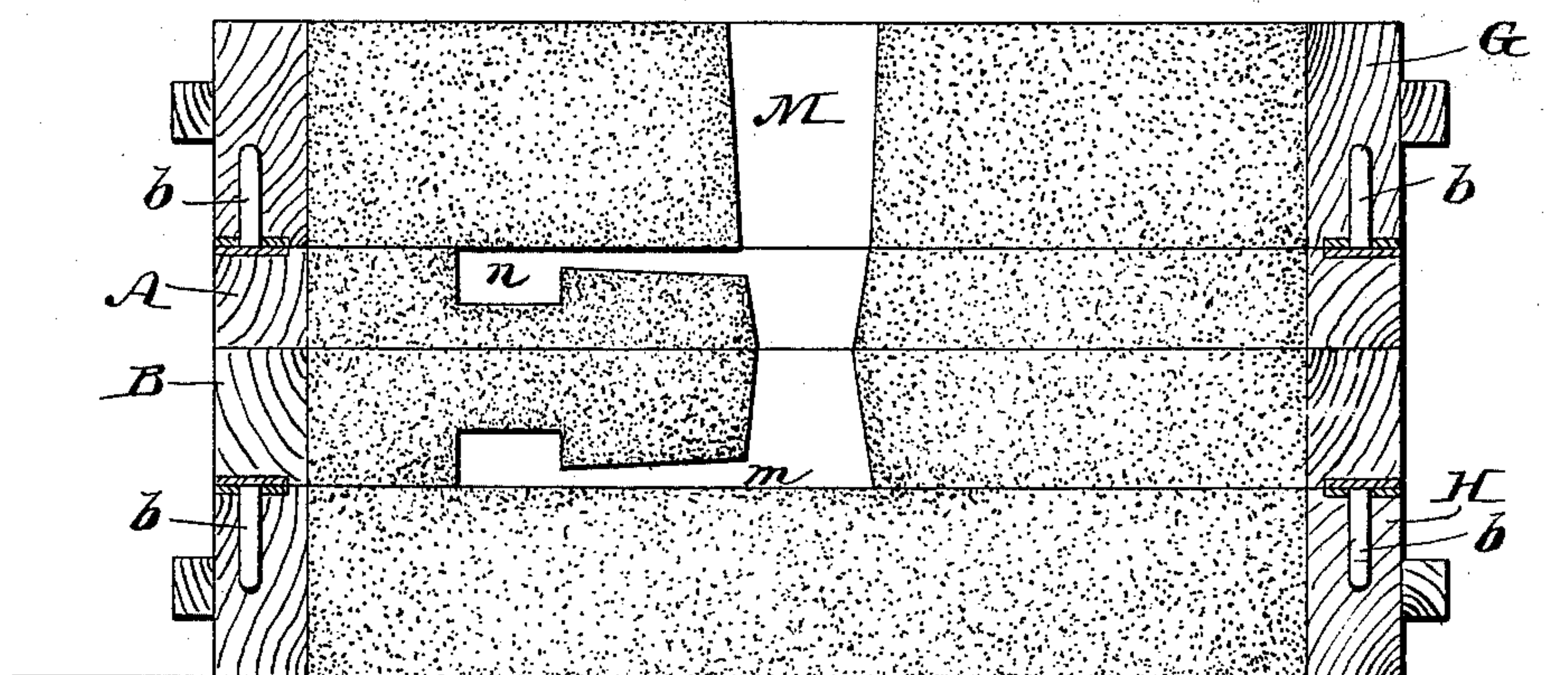


Fig. 4.



WITNESSES:

John M. Deemer
E. M. Clark

INVENTOR:

BY *Edward Reddy*
Munn & Co
ATTORNEYS.

UNITED STATES PATENT OFFICE.

EDWARD REDDY, OF LITTLE FALLS, NEW YORK.

METHOD OF MOLDING.

SPECIFICATION forming part of Letters Patent No. 390,398, dated October 2, 1888.

Application filed July 23, 1888. Serial No. 250,726. (No model.)

To all whom it may concern:

Be it known that I, EDWARD REDDY, of Little Falls, in the county of Herkimer and State of New York, have invented a new and Improved Method of Molding, of which the following is a full, clear, and exact description.

I employ two sets of patterns which I mold in the sand facing each other, one portion of each set of patterns being arranged to form a gate or passage from one mold to the other, a single sprue being formed by means of a removable core in one section of the mold. The patterns are attached to removable plates adapted to be held in the flask while the two inner sections of the mold are formed. The two outer sections of the mold are formed upon the backs of the said plates, one being provided with a sprue-core, and then the plates are removed and the four sections are put together, making the mold complete.

Reference is to be had to the accompanying drawings, forming a part of this specification, in which similar figures of reference indicate corresponding parts in all the figures.

Figure 1 is a plan view of one form of casting-flask which I employ for carrying out my new method of molding, the flask being shown open, showing the patterns in place in the flask. Fig. 2 is a side elevation of the same. Fig. 3 is a sectional elevation of the entire flask, and Fig. 4 is a similar view of the flask and molds ready for pouring the metal.

A B represent two frames attached together at the edges preferably by the hinges *a a*, so that said frames may be conveniently opened out, as shown in Figs. 1 and 2, and closed, as shown in Figs. 3 and 4. The outer edges of the said frames A B are provided with pins *b b*.

C D represent plates adapted to be placed upon said pins, as shown in Figs. 3 and 4, to properly connect said plates with said frames. Upon one surface of each of said plates are secured the patterns E F, having gates E' F'.

G H represent two outer frames adapted to be placed upon the pins *b b* for connecting them, respectively, with the frames A B, as shown in Figs. 3 and 4.

I is the tapering sprue-core attached to the

plate C by a stud or pin, *i*, or other suitable means, in line with the gates E' F'.

In carrying out my new method with this flask, the flask is first to be provided with the plates C D having the patterns attached, the said plates being placed between the sections A G and B H of the flask with the patterns facing each other when the flask is closed. The flask is then opened in the middle and two sections of the mold formed—that is, frames A and B are filled and rammed on plates C D over the patterns. The flask is then closed and the two outer sections of the mold formed in frames G H upon the outer plain surfaces of the plates C D. Frame H is first filled and rammed and then removed from frame B, and plate D and its patterns and gate removed. The frame H is then replaced upon the frame B, and the flask is then reversed. In filling frame G the tapering sprue core I is fitted in the center of the plate C in line with the gates E F. After this is filled and rammed the said sprue-core is removed and the frame G is lifted off from frame A and the plate C removed, drawing the patterns and gate attached thereto. The frame G is then replaced upon frame A, thus completing the mold. In this manner it will be seen that the bottom *m* and top *n* of the mold are formed by two separate and independent sections of sand, and that both molds may be filled through a single sprue, M.

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

The method of molding herein described, which consists in first forming two separate and independent sections, placing these sections together with the patterns abutting, forming a separate bottom section, and a separate top section having a sprue, removing these two last-named sections and drawing the patterns, and then placing the bottom and top sections upon the inner sections, thus forming the bottom and top of the molds, as described.

EDWARD REDDY.

Witnesses:

EDWARD HURLEY,
EDWARD WALSH.