

(No Model.)

R. JOWITT.
MOLD FOR CASTING SASH WEIGHTS.

No. 407,732.

Patented July 23, 1889.

Fig. 1.

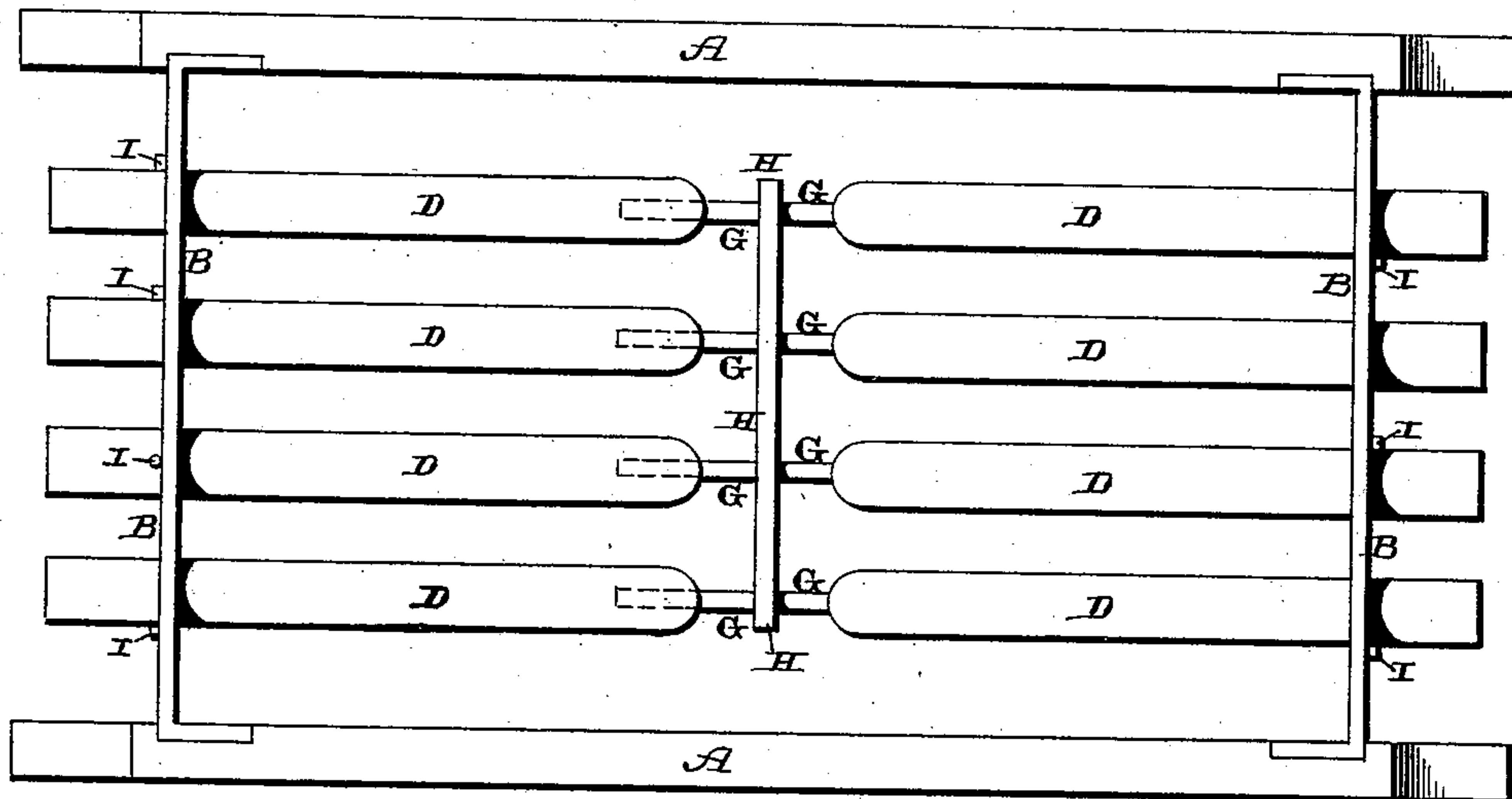
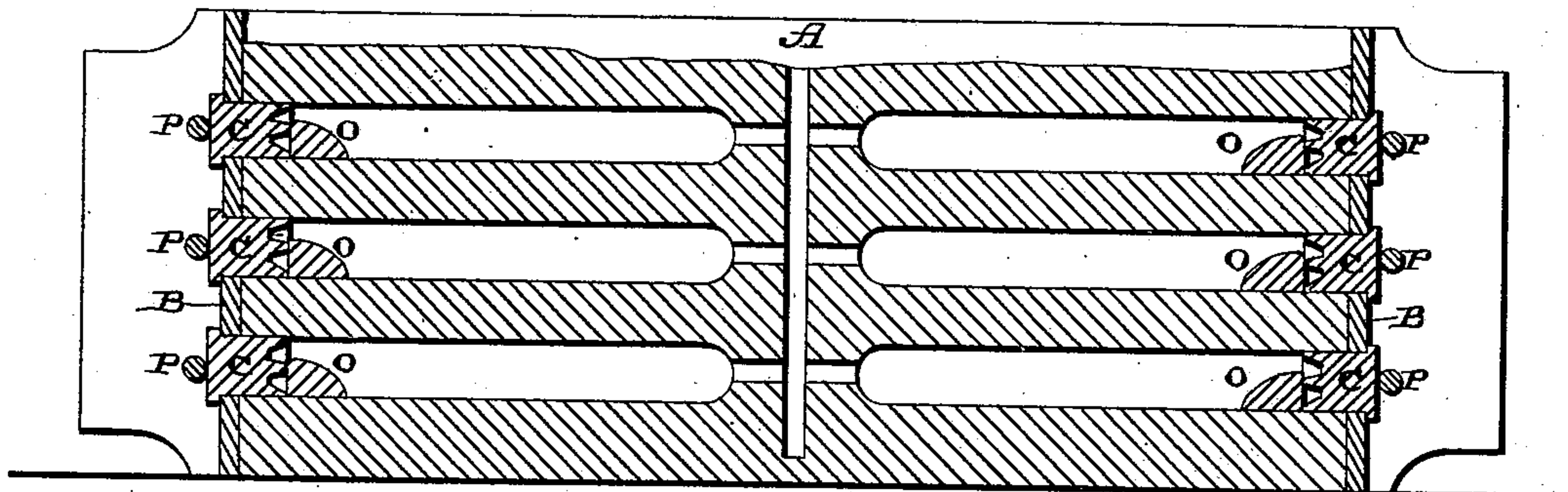


Fig. 2.



Witnesses:

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UNITED STATES PATENT OFFICE.

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MOLD FOR CASTING SASH-WEIGHTS.

SPECIFICATION forming part of Letters Patent No. 407,732, dated July 23, 1889.

Application filed May 29, 1889. Serial No. 312,492. (No model.)

To all whom it may concern:

Be it known that I, RICHARD JOWITT, of South Pittsburg, in the county of Marion and State of Tennessee, have invented certain
5 new and useful Improvements in Molds for Casting Sash-Weights; and I do hereby declare the following to be a full, clear, and exact description of the invention, such as will enable others skilled in the art to which it
10 pertains to make and use it, reference being had to the accompanying drawings, which form part of this specification.

My invention relates to an improvement in molds for casting sash-weights; and it consists in the combination of the flask having
15 apertured metallic end pieces, the chills which are passed through the end pieces, the gate, and the rods which hold the chills in position, as will be more fully described hereinafter.

The object of my invention is to produce a flask in which a number of tiers of weights can be cast at the same time, the weights all
25 being either of the same size, or of two different sizes, as may be desired.

Figure 1 is a plan view of a flask which embodies my invention. Fig. 2 is a longitudinal vertical section of the same.

A represents the wooden side pieces of the
30 flask, and B the metallic apertured end pieces, which are secured thereto in any suitable manner. These end pieces have tiers of openings made through them, so that a large number of weights can be cast at the same
35 time, any desired number of weights being cast in each tier. The openings through the metallic end pieces are just large enough to allow the chills C to be passed through them after the patterns have been withdrawn.
40 Each pattern D consists of a solid cylinder of any desired size, and the patterns upon one side are provided with long projections G, which fit in corresponding recesses in the other patterns, as shown. These projections
45 pass through corresponding openings in the gate-pattern H and form the passages from the central opening formed by the gate into each pair of molds. The patterns are provided with projections or stops I, which strike
50 against the metallic end pieces B, and thus regulate the distance that they shall extend inside of the flask. If it is desired to cast all

of the weights of the same size, then they will extend an equal distance into the flasks at each end; but if both light and heavy weights
55 are to be cast the gate will be moved beyond the center in the direction of the light weights, and the patterns of the heavy weights will be forced correspondingly farther inward. The chills are made of cast-iron, and two are placed
60 in each mold. The one O, which is placed inside of the molds, forms the eye for the knot of the sash-cord, while the one which is passed through the end pieces forms the end of the weight. The flask is placed in position, and
65 then the bottom tier of patterns are inserted and connected in the gate, as shown. Sand is then thrown in and rammed up, after which the second tier of patterns is rammed up in the same manner. A third tier is now inserted,
70 and so on. The patterns are then all drawn from each end of the flask, the gate is drawn, the small eye-chills are then placed in the ends of the molds, and the end chills are then passed through the end pieces into the ends of the
75 mold and in direct contact with the eye-chills. The melted iron is then poured into the gate, and which flows into each mold through the holes which are formed by the projections upon the ends of the patterns. The small
80 gates, which connect with the large gate, are easily broken off, leaving a perfect weight. The end chills are then taken out of the end of the flask, which is then lifted from the sand. These end chills, while the casting is
85 going on, are held in position by means of the rods P, which pass laterally through the side pieces A, just beyond the metallic end pieces B, and which serve to prevent the weight of metal from forcing the chills outward.
90

Having thus described my invention, I claim—

The combination of the apertured side pieces A, the metallic perforated end pieces B, the chills which are passed through the end
95 pieces, and the rods passing through the apertures in the side pieces to hold the chills in position, substantially as described.

In testimony whereof I affix my signature in presence of two witnesses.

RICHARD JOWITT.

Witnesses:

SAMUEL TYLER,
JAMES E. WADLY.