

(No Model.)

R. W. BARRETT.
DEVICE FOR CASTING SASH WEIGHTS.

No. 438,137.

Patented Oct. 14, 1890.

Fig. 1.

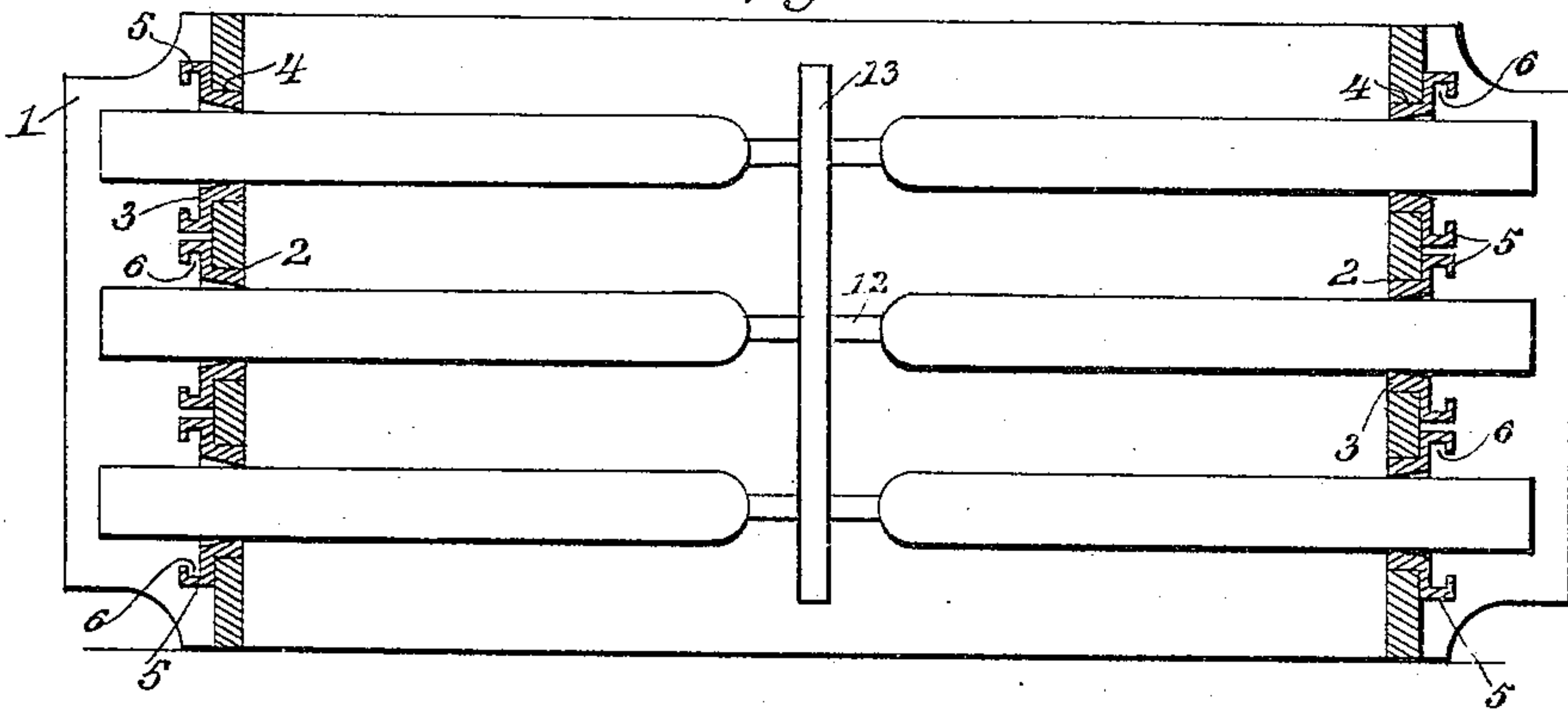


Fig. 2.

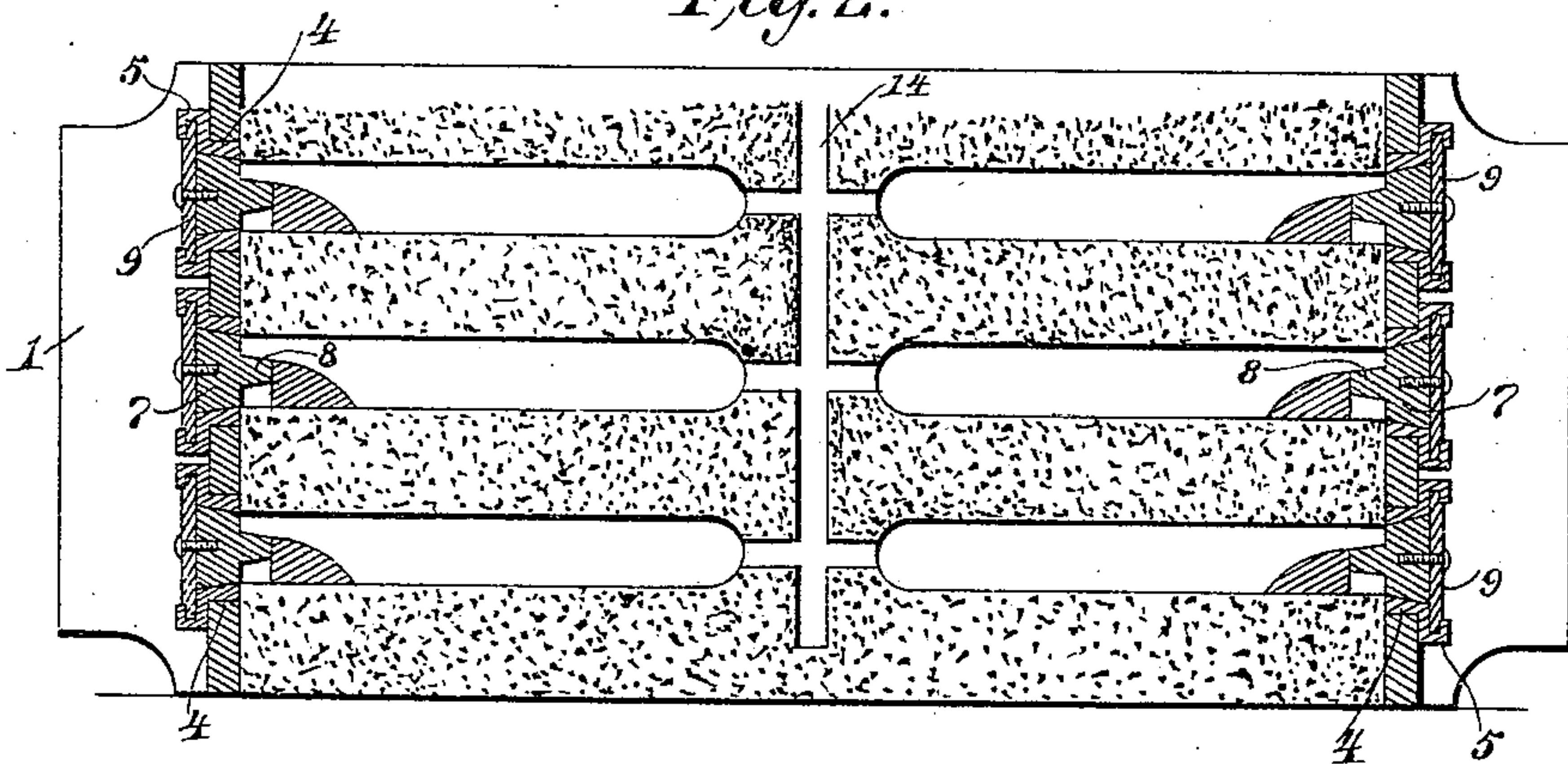


Fig. 3.

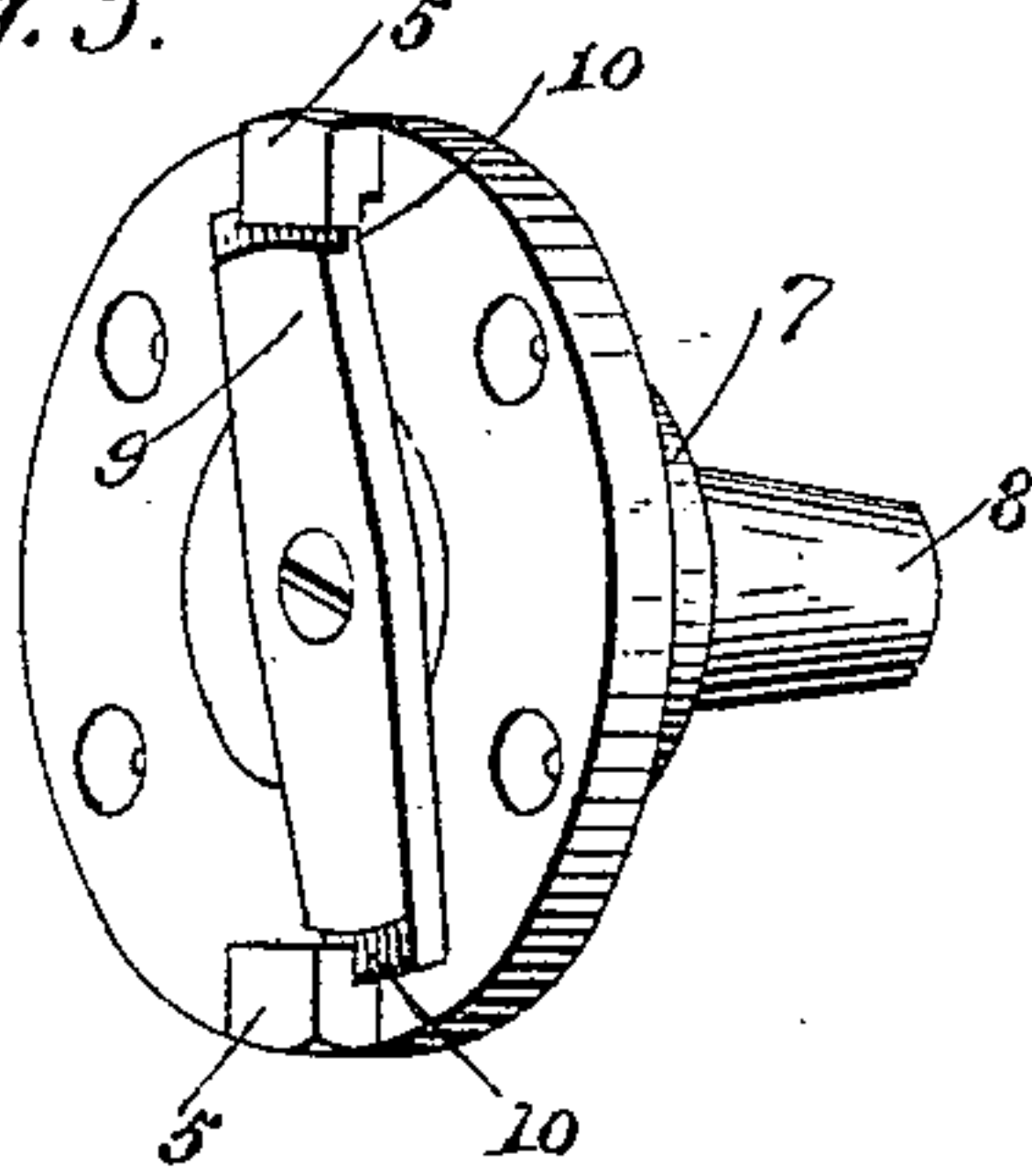


Fig. 4.

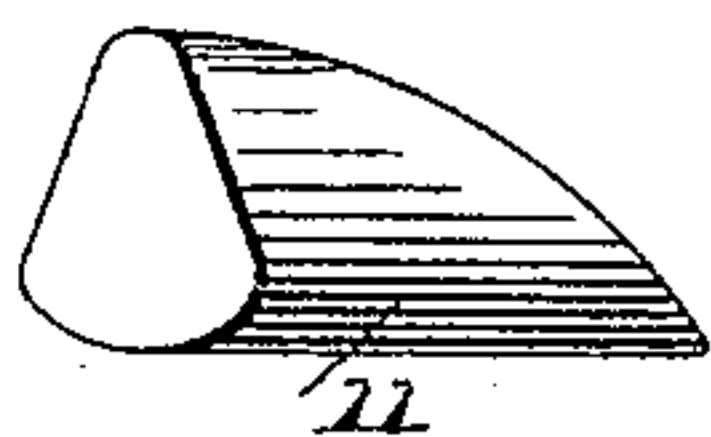


Fig. 5.



Witnesses

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UNITED STATES PATENT OFFICE.

ROBERT W. BARRETT, OF BRISTOL, TENNESSEE.

DEVICE FOR CASTING SASH-WEIGHTS.

SPECIFICATION forming part of Letters Patent No. 438,137, dated October 14, 1890.

Application filed August 16, 1890. Serial No. 362,209. (No model.)

To all whom it may concern:

Be it known that I, ROBERT W. BARRETT, a citizen of the United States, residing at Bristol, in the county of Sullivan and State of Tennessee, have invented a new and useful Device for Casting Sash-Weights, of which the following is a specification.

This invention relates to devices for casting sash-weights; and it has for its object to provide a device of this class which shall be simple in construction, easily manipulated, and by means of which a number of sash-weights may be cast or formed at a single operation, a single flask being made to contain any desired number of patterns forming molds, all of which are connected by a single weight.

The invention consists, essentially, in the construction of the chill-cores and the method of attaching the same to the sides of the flask, which will be hereinafter fully described, and particularly pointed out in the claims.

In the drawings hereto annexed, Figure 1 is a vertical sectional view of a flask having the patterns placed therein. Fig. 2 is a sectional view showing the flask after the withdrawal of the patterns and the insertion of the chills and cores, the gate-pattern having been also withdrawn. Fig. 3 is a perspective detail view showing the core and one of the plates for attaching the same to the side of the flask. Fig. 4 is a detail view of one of the chill-blocks. Fig. 5 is a detail view of a sash-weight constructed by my improved apparatus.

Like numerals of reference indicate like parts in all the figures.

1 designates an ordinary wooden flask, the sides of which are provided with perforations or apertures 2 2. Over the said apertures are secured the plates 3, having inwardly-extending collars or flanges 4, which fit in the perforations or apertures 2. The outer sides of the plates 3 are provided with diametrically-opposite lugs or catches 5, having notches 6. The inner sides of the flanges or collars 4 are made slightly tapering to form seats for the plugs 7, which are provided at their inner ends with the inwardly-extending tapering chill-cores 8. The outer ends of the plugs 7 are provided with the swiveled turn-buttons 9, adapted to engage the notched lugs 5,

and thereby to hold the plugs and chill-cores in position in their seats. The outer ends of the turn-buttons 9 are slightly beveled in opposite directions, as will be seen at 10 10, for the purpose of forcing the plugs 7 tightly into their seats when adjusted in position for operation.

11 designates the chill-blocks, which are adapted to be placed loosely in the outer ends of the molds for the purpose of forming the eyes or recesses in the sash-weights for the reception of the sash-cords. These blocks may be of any desired shape; but they are usually provided with rounded outer sides corresponding with the outer sides of the sash-weights, so as to fit neatly in the molds of the latter.

In carrying out the invention the bottom row of patterns is first placed in the flask, and sand is packed around the same and rammed. The patterns should extend through the apertures in the ends of the flask, and they are provided at their inner ends with pins 12, extending through perforations in the gate 13. The second row of patterns is then placed in position and packed in the same manner, and so on until the flask has been filled. The patterns are then withdrawn through the apertures in the ends of the flask, and the gate is then drawn, thus leaving open the pourway 14, as shown in Fig. 2. The chill-blocks 11 are now placed in the outer ends of the molds, and the plugs 7, having the chill-cores 8, are finally adjusted and secured by means of the turn-buttons 9. The flask is then ready for pouring, the turn-buttons serving to prevent the plugs from being displaced by the weight of the molten metal.

By this invention it will be seen that a large number of sash-weights may be formed at a single casting and in a much less expensive manner than by devices heretofore employed.

Having thus described my invention, I claim and desire to secure by Letters Patent of the United States—

1. In a device for casting sash-weights, the combination of a wooden flask having apertured ends, the plates having collars or flanges fitting in said apertures, the chill-blocks, and the plugs fitting in said collars or flanges and having inwardly-extending ta-

pering cores, and means for retaining the said plugs in position, substantially as described.

2. In a device for casting sash-weights, the
5 combination of the flask, the ends of which
are provided with apertures, the plates se-
cured to the outer sides of the ends of the
flask and having collars or flanges extending
into said apertures and provided with taper-
10 ing inner sides and diametrically-opposite
notched lugs, the chill-blocks, and the plugs
having the inwardly - extending tapering
chill-cores and provided with turn-buttons
swiveled to their outer sides and having bev-
15 eled ends adapted to engage the notched lugs
of the plates secured to the ends of the flask,
substantially as and for the purposes set forth.

3. The combination of the flask having

apertured ends, the patterns having inwardly-
extending pins, the gate having perforations 20
to receive said pins, the plates secured to the
outer sides of the ends of the flask and hav-
ing inwardly-extending collars or flanges
and outwardly-extending notched lugs, the
chill-blocks, and the plugs having the in- 25
wardly-extending tapering chill-cores and
provided with the swiveled turn-buttons hav-
ing beveled ends, substantially as and for the
purpose set forth.

In testimony that I claim the foregoing as 30
my own I have hereto affixed my signature in
presence of two witnesses.

ROBERT W. BARRETT.

Witnesses:

GEO. F. CRUSH,
L. B. CROSBY.