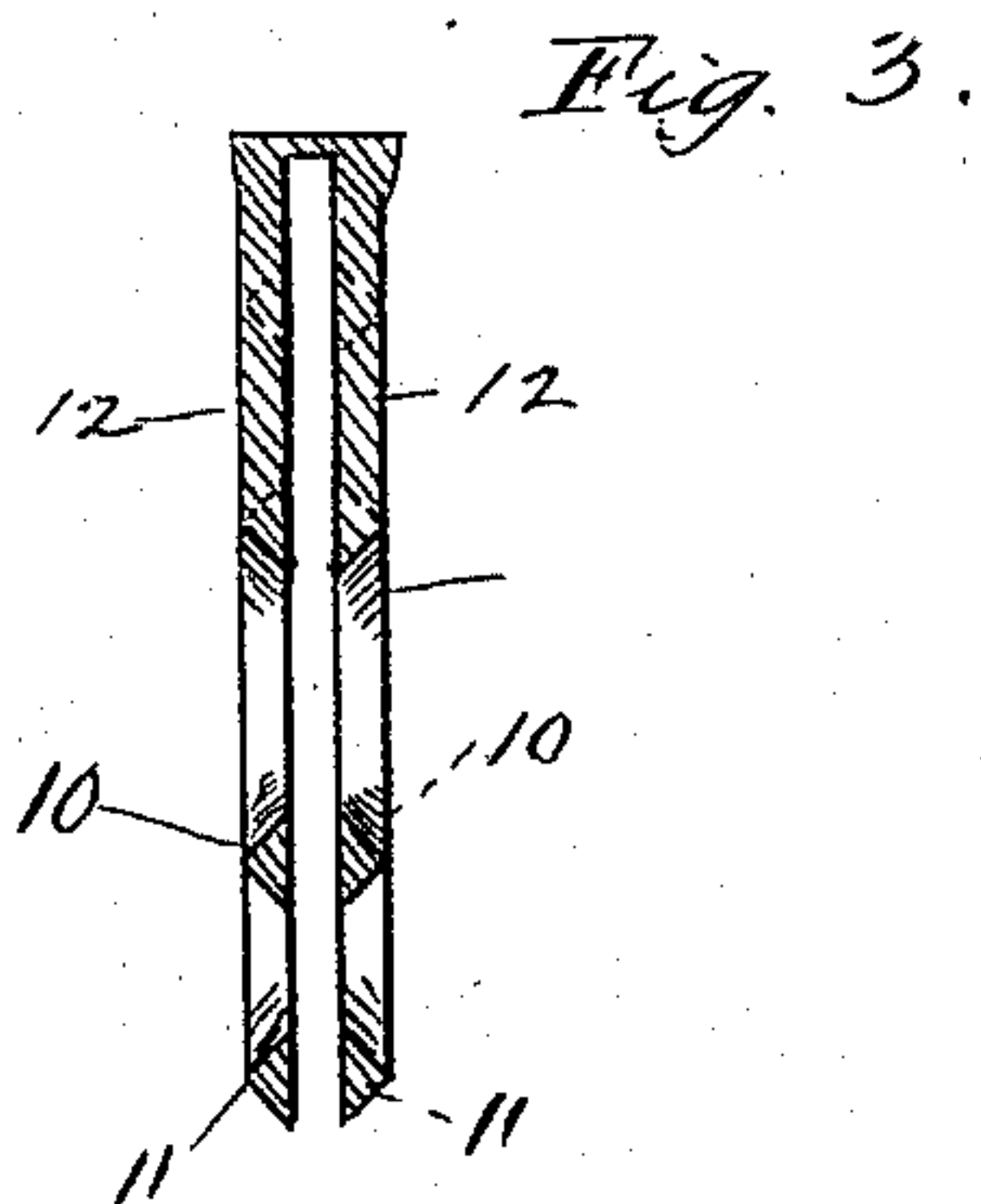
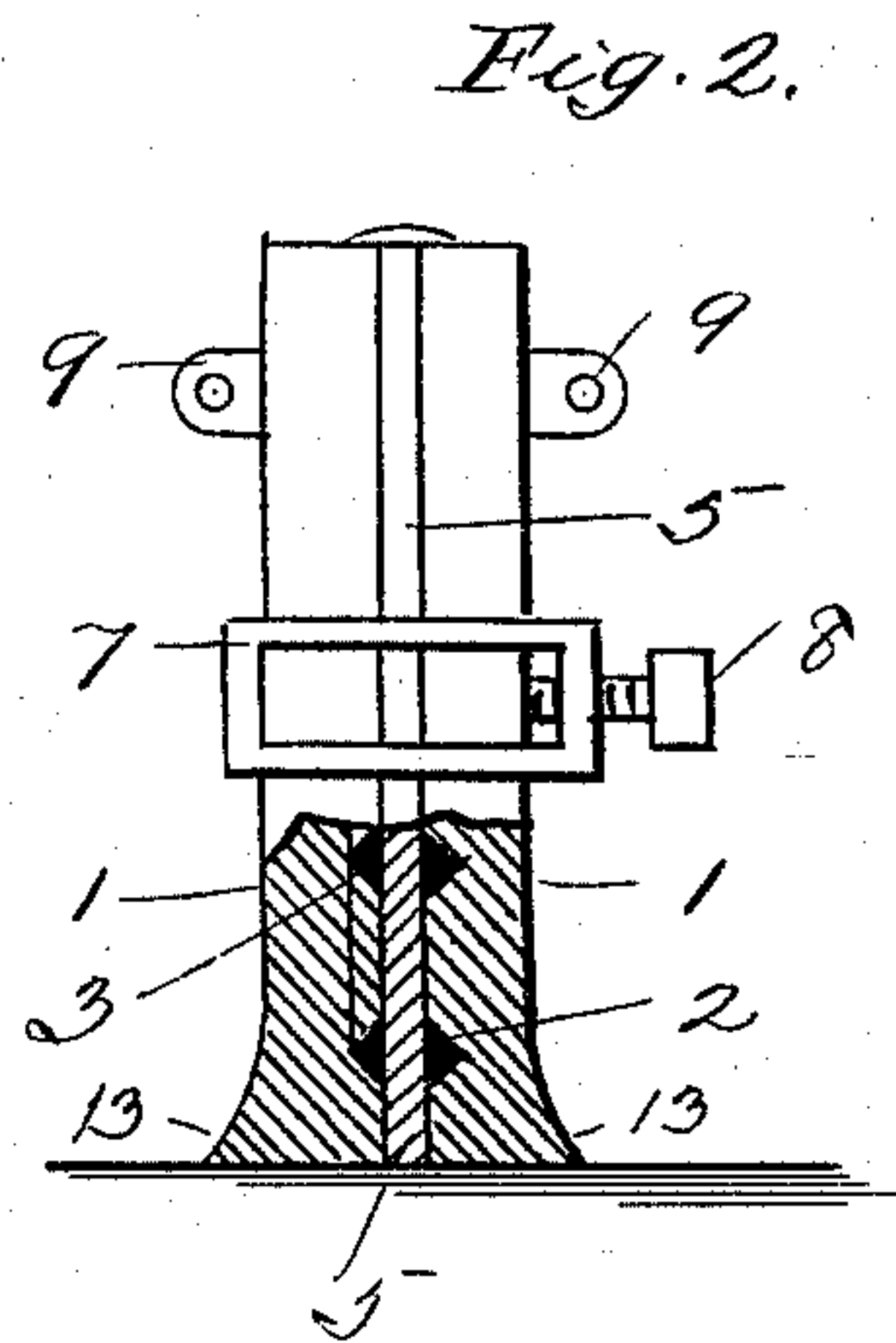
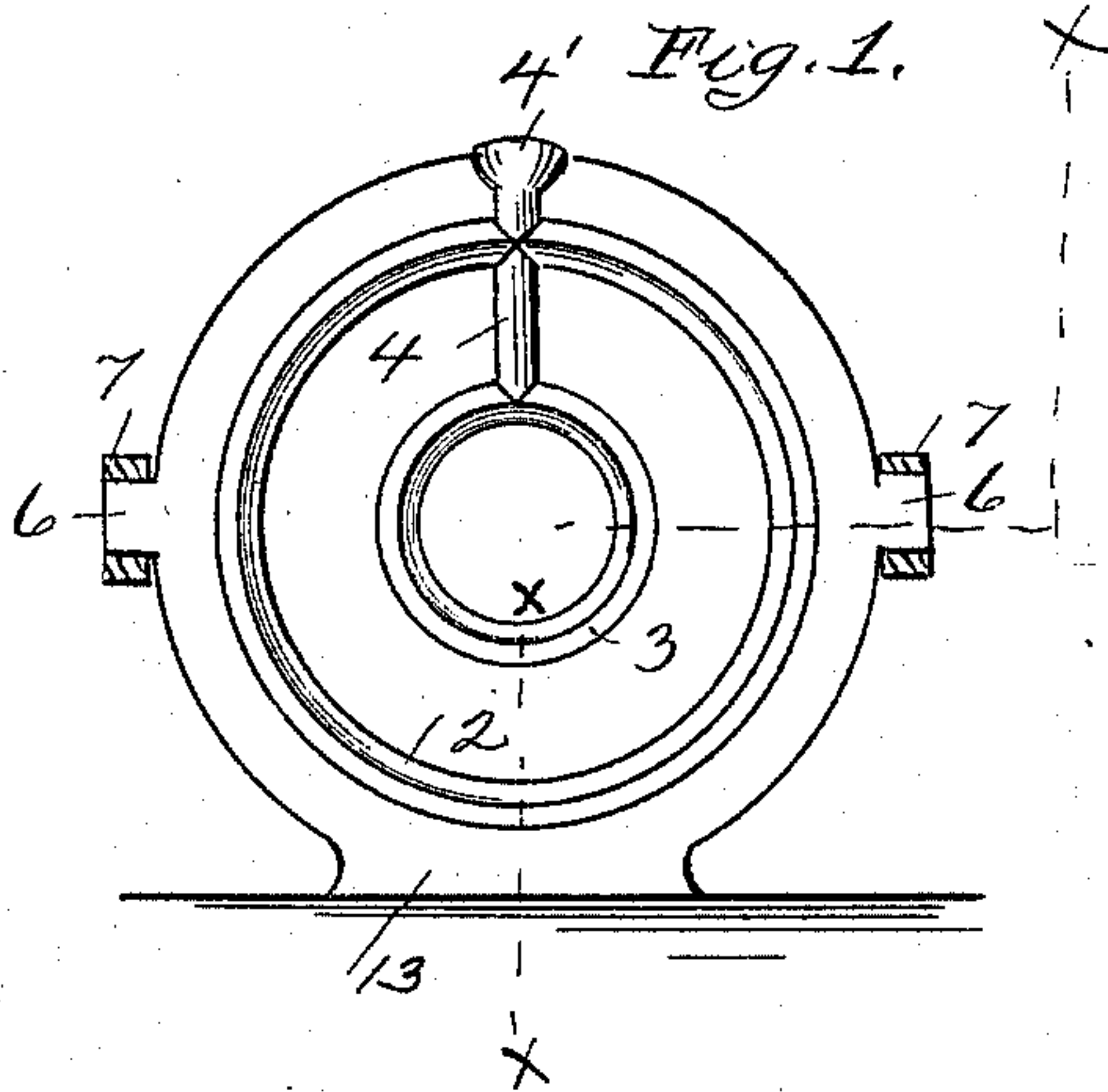


(No Model.)

J. LAMBERT.
MOLD FOR CASTING LEAD GASKETS.

No. 540,321.

Patented June 4, 1895.



Witnesses:
M. E. Harrison.
J. A. Hervey.

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UNITED STATES PATENT OFFICE.

JAMES LAMBERT, OF HOMESTEAD, PENNSYLVANIA.

MOLD FOR CASTING LEAD GASKETS.

SPECIFICATION forming part of Letters Patent No. 540,321, dated June 4, 1895.

Application filed May 28, 1894. Serial No. 512,623. (No model.)

To all whom it may concern:

Be it known that I, JAMES LAMBERT, a citizen of the United States, residing at Homestead, in the county of Allegheny and State of Pennsylvania, have invented certain new and useful Improvements in Molds for Casting Manhole and Hand-Hole Gaskets; 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 pertains to make and use the same, reference being had to the accompanying drawings, which form a part of this specification.

This invention relates to molds for casting lead gaskets for manholes and hand holes in boilers.

The object of my invention is to provide an improved mold of this character which will lessen the labor and increase the results ordinarily produced by such molds.

To these ends my invention consists in certain improvements in construction and adaptability of such a device as hereinafter described.

In the drawings, Figure 1 is a front sectional elevation of my improved mold, showing the form of the casting therein. Fig. 2 is a vertical cross-section of the same on the line X X of Fig. 1. Fig. 3 is a sectional cross-section of the gaskets still together as cast, but having the asbestos sheet removed.

Like numerals of reference denote like parts throughout the drawings.

My improved mold consists of a disk-shaped block of wood or other material preferably divided vertically through its center into two halves or sections, numbered respectively 1 and 1'. On the inner or contiguous faces of these sections 1 and 1' are cut or formed grooves 2—3 preferably V shaped and of a required depth for the reception of the molten metal. These grooves are shown in the drawings as circular in contour but may be of any desired outline, and are formed one within the other, as shown, and connected by a short similarly shaped groove 4 the outer groove being connected to the mouth or inlet 4' of the mold by a continuation of the groove 4, thus forming a continuous groove in each half of

the mold the edges of said grooves registering with each other when the mold is closed.

Between the two sections or halves 1 and 1' of the mold is interposed a sheet of asbestos 5 of about the size and shape of the mold and extending to within a short distance of the inlet 4', the object of this asbestos sheet being to separate the flow of metal, thus casting each half separately and distinct from the other except for a short distance in the continuation of the groove 4 at which point the two castings are joined as shown at Fig. 3 on the drawings. The rings or gaskets thus formed are also joined by a short strip 12 formed by the grooves 4 and are triangular in cross section as shown at 10 and 11 being formed thus by the V shaped walls of the grooves on two sides and the flat face or side of the asbestos sheet on the other. After being removed from the mold the asbestos sheet 5 is slipped from between the castings, the gate and connecting pieces cut away, leaving four gaskets, two man-holes and two hand hole gaskets cast by the one operation.

In order to clamp the two sections of the mold together I form integral lugs 6 on each side of each section of the said mold, over which suitable links 7 are placed, each of which are fitted with set-screws 8 by means of which the two sections are bound tightly together.

In order that the mold may be readily set on one edge without danger of upsetting when filling, I form the sections with a base portion 13 capable of supporting the mold in an upright position.

The advantages of a mold constructed as above described will be readily apparent, as the number of gaskets by one casting greatly accelerates the production of them and lessens the labor.

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

1. The combination of the disk-shaped block comprising two sections or halves, with a suitable spacing-apart material between them, each half or section of the block having formed therein circular grooves of suitable contour in cross-section, communicating with

each other and an inlet or gate for the reception of the molten metal, and links having set-screws engaging lugs on said sections, said links encompassing said lugs, substantially
5 as set forth.

2. In a mold for casting lead gasket rings for man holes and hand holes in boilers &c., the combination of a disk-shaped block, comprising two halves or sections and an asbestos sheet, the contiguous faces of each half
10 or section having circular grooves formed therein one within the other, and connected by a short straight groove of like shape, said
15 said halves or sections being secured together

by clamps consisting of rectangular link, adapted to engage with lugs formed integral with the sections of each half of the molds and set screws in said links to impinge against the said lugs, all arranged and combined for
20 service, substantially as and for the purpose described.

In testimony that I claim the foregoing I hereunto affix my signature this 9th day of December, A. D. 1893.

JAMES LAMBERT. [L. s.]

In presence of—

ALBERT J. WALKER,
M. E. HARRISON.