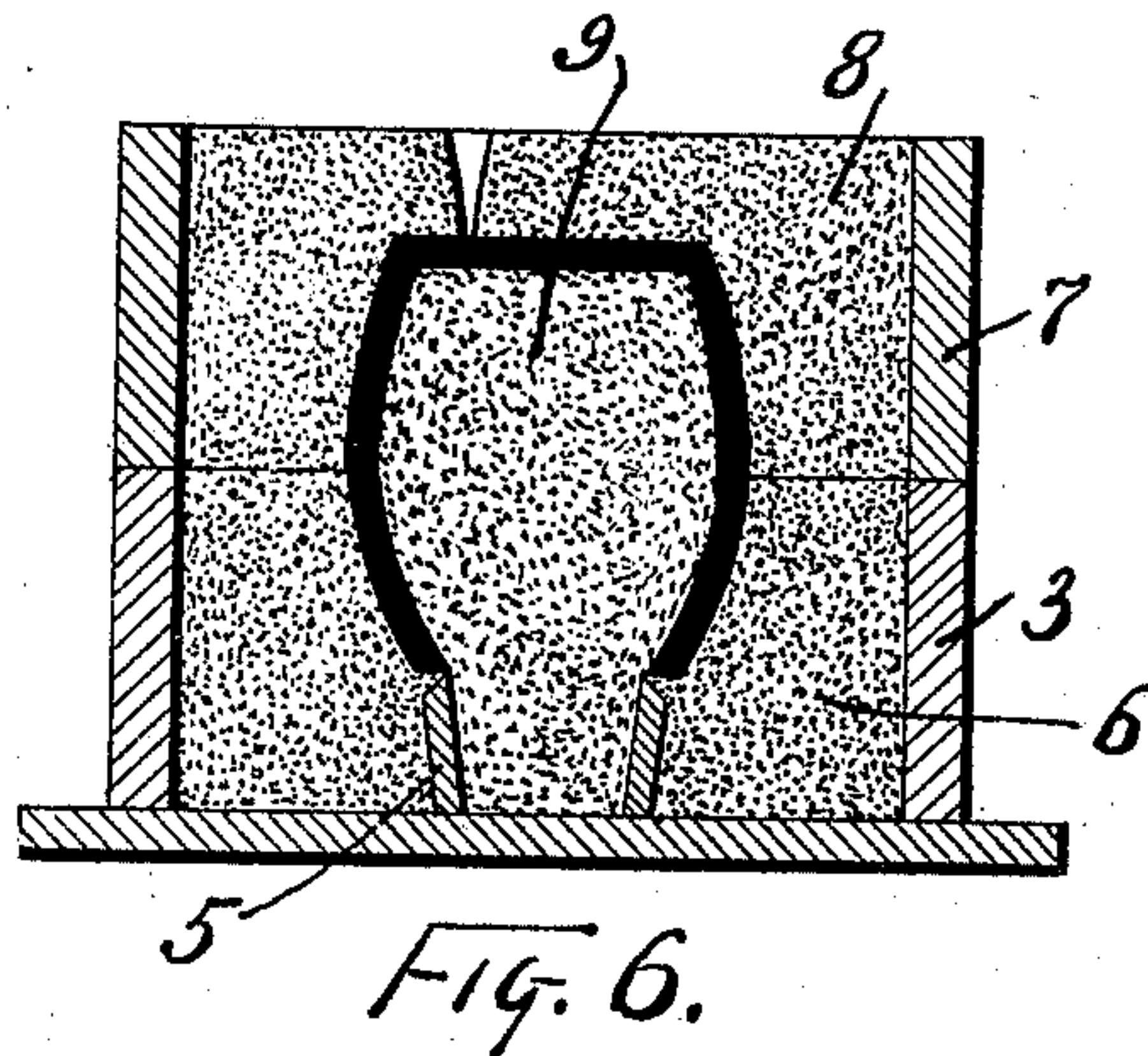
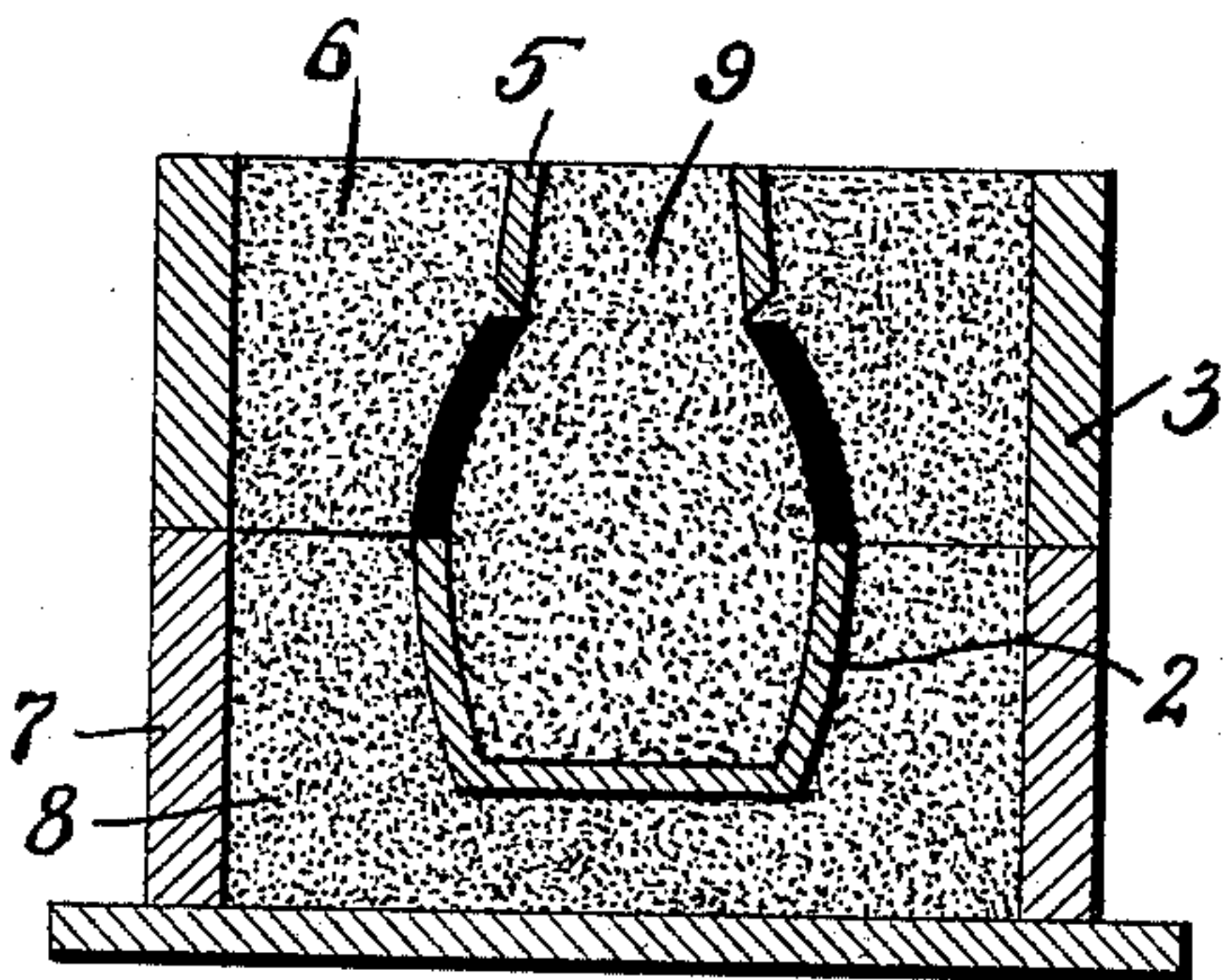
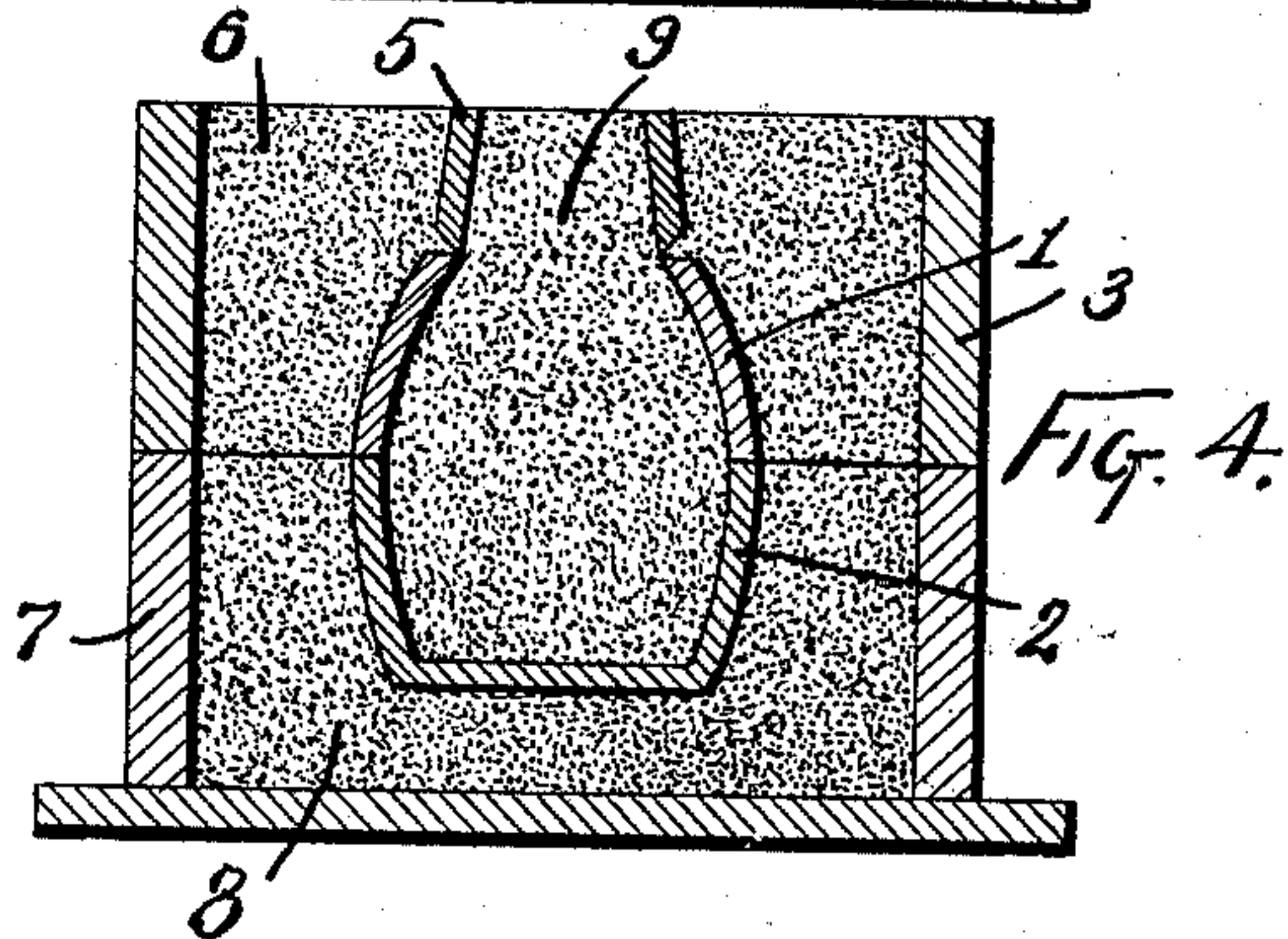
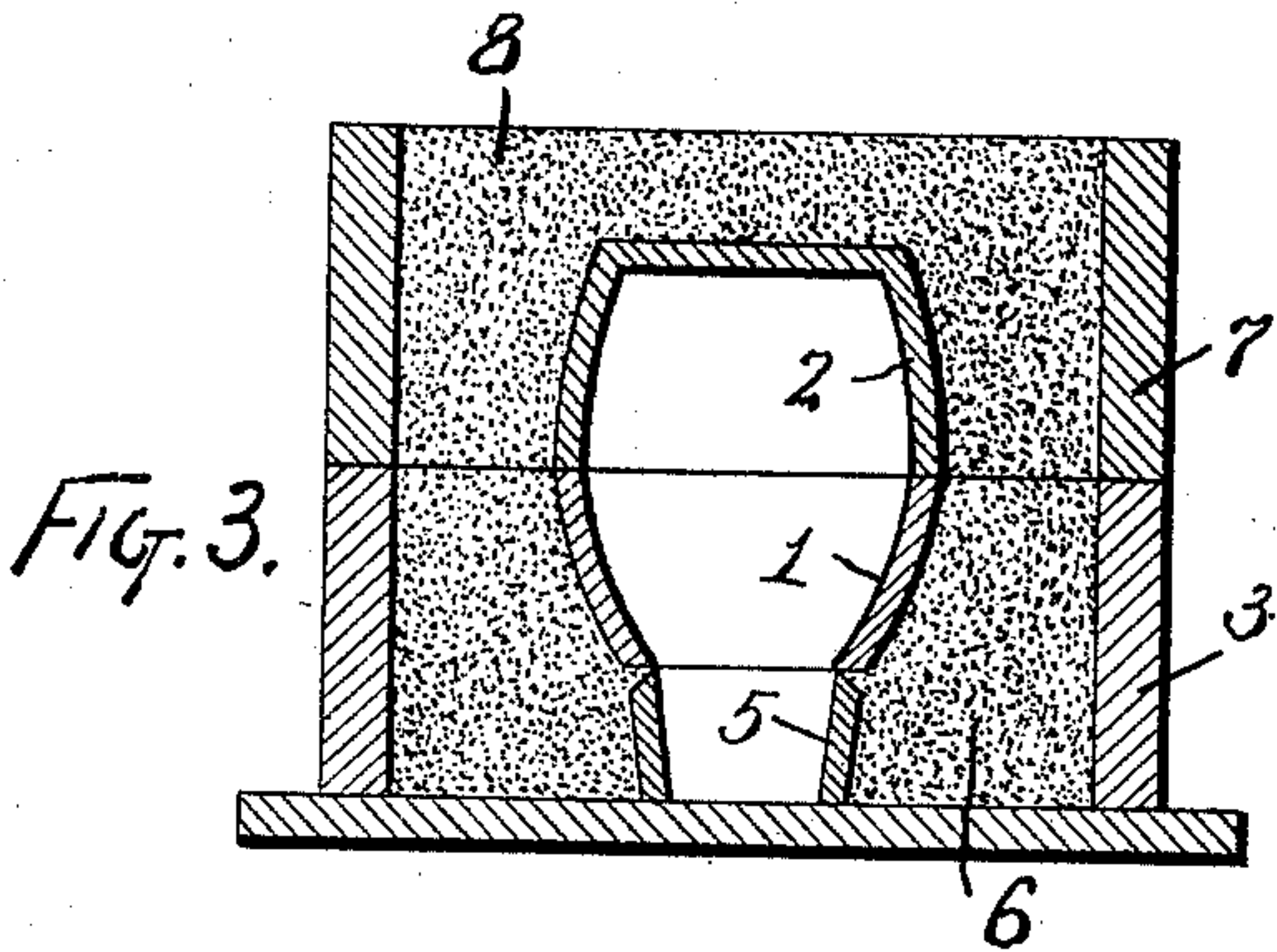
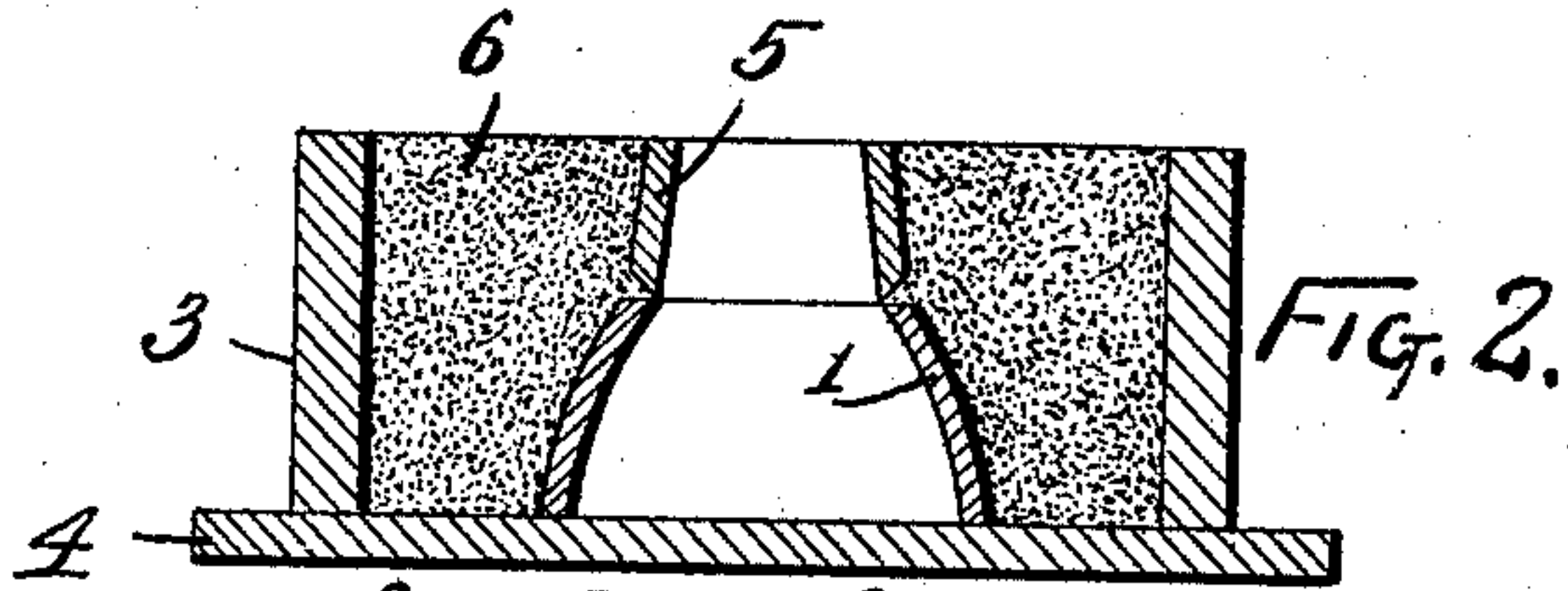
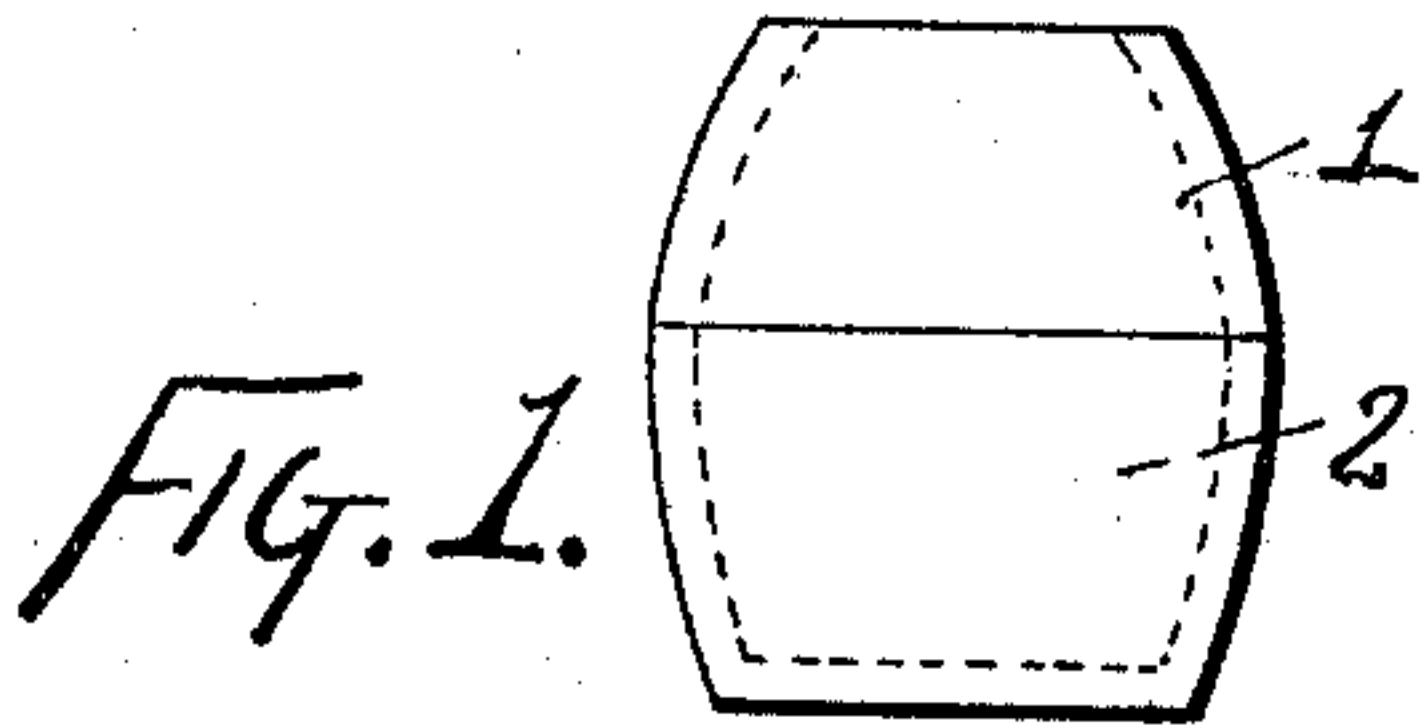


(No Model.)

H. V. MOORE.
MOLD FOR HOLLOW ARTICLES.

No. 585,689.

Patented July 6, 1897.



Harry V. Moore

Witnesses:
E. Shipley.
M. S. Belden.

Inventor
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UNITED STATES PATENT OFFICE.

HARRY V. MOORE, OF HAMILTON, OHIO, ASSIGNOR TO F. & L. KAHN & BROS., OF SAME PLACE.

MOLD FOR HOLLOW ARTICLES.

SPECIFICATION forming part of Letters Patent No. 585,689, dated July 6, 1897.

Application filed March 12, 1897. Serial No. 627,098. (No model.)

To all whom it may concern:

Be it known that I, HARRY V. MOORE, of Hamilton, Butler county, Ohio, have invented certain new and useful Improvements in
5 Molds for Hollow Articles, of which the following is a specification.

This invention pertains to improvements in molds for use in casting hollow articles having a large opening in a plane parallel with
10 the plane of a permissible parting in the pattern.

My improved method will be readily understood from the following description, taken in connection with the accompanying drawings,
15 in which my invention is exemplified in connection with a pot-like vessel.

Figure 1 is a side elevation of the exemplifying pattern, and Figs. 2, 3, 4, 5, and 6 vertical sections of the mold in successive stages
20 of formation.

In Fig. 1 is seen the pattern of the exemplifying hollow article, the pattern being formed in two parts 1 and 2 with a horizontal parting between them, there being a large
25 opening in the upper half-pattern 1 parallel with the plane of the parting between the two half-patterns.

Fig. 2 explains the first step in forming the mold. The upper half-pattern 1 is set on a
30 bottom board 4, on which is placed the drag 3. Over the top opening in the half-pattern is set a collar 5, which rests upon the pattern. This collar is to form part of the mold, and the sand of the drag may be employed
35 as the sole means for holding the collar in place. The half-flask, half-pattern, and collar having been placed as indicated, the drag-sand 6 is rammed in the half-flask around the half-pattern and the collar. The drag is then
40 to be reversed, as seen in Fig. 3, after which the other half-pattern 2 is to be set in place and then the cope 7 applied and its sand 8 rammed, leaving the parts as seen in Fig. 3. The entire mold is then to be reversed, as seen
45 in Fig. 4, and the green core-sand 9 is to be rammed into the interior of the pattern and

collar. The drag 3 is then to be lifted, collar 5 coming with it and leaving the core and pattern. Pattern-half 1 is then to be drawn and the drag replaced, leaving the mold in
50 the condition seen in Fig. 5. The entire mold, in the condition shown in Fig. 5, is then to be reversed and cope 7 lifted and pattern-half 2 drawn and the cope replaced, leaving the mold in the condition seen in Fig. 6 complete
55 and ready for pouring.

In many cases the apparatus, without modification, may be used after a somewhat different method or, rather, a different order of arrangement of the steps of the method.
60 Thus the part 2 of the pattern may be placed mouth down on a follow-board and the cope 7 rammed, after which the half-mold thus completed is to be reversed. The joint-face is then to be treated with parting-sand, after
65 which the part 1 of the pattern is placed in position, surmounted by the collar 5, and the drag 3 applied, after which the sand of the drag is to be rammed, and at the same time the sand of the core may be rammed through
70 the collar. This leaves the parts precisely as seen in Fig. 4 and ready for the subsequent steps, as previously described. By the modification of the method described it is to be
75 observed that one reversal of the mold is avoided, which may be quite an object in molding heavy articles.

I claim as my invention—

The combination, substantially as set forth, of a hollow pattern parted horizontally and
80 having an opening in a plane substantially parallel with said parting, two half-molds parted in the plane of said pattern-parting, and a collar supported in one of said half-molds and extending from the outer face of
85 such half-mold inwardly to engaging contact with the margin of the opening in said pattern.

HARRY V. MOORE.

Witnesses:

J. W. SEE,

SAM D. FITTON, Jr.