No. 695,782. Patented Mar. 18, 1902.

H. BASTOW.

MANUFACTURE OF HANDLED GLASSWARE.

(Application filed June 10, 1901.)

(No Model.)

Fig 1

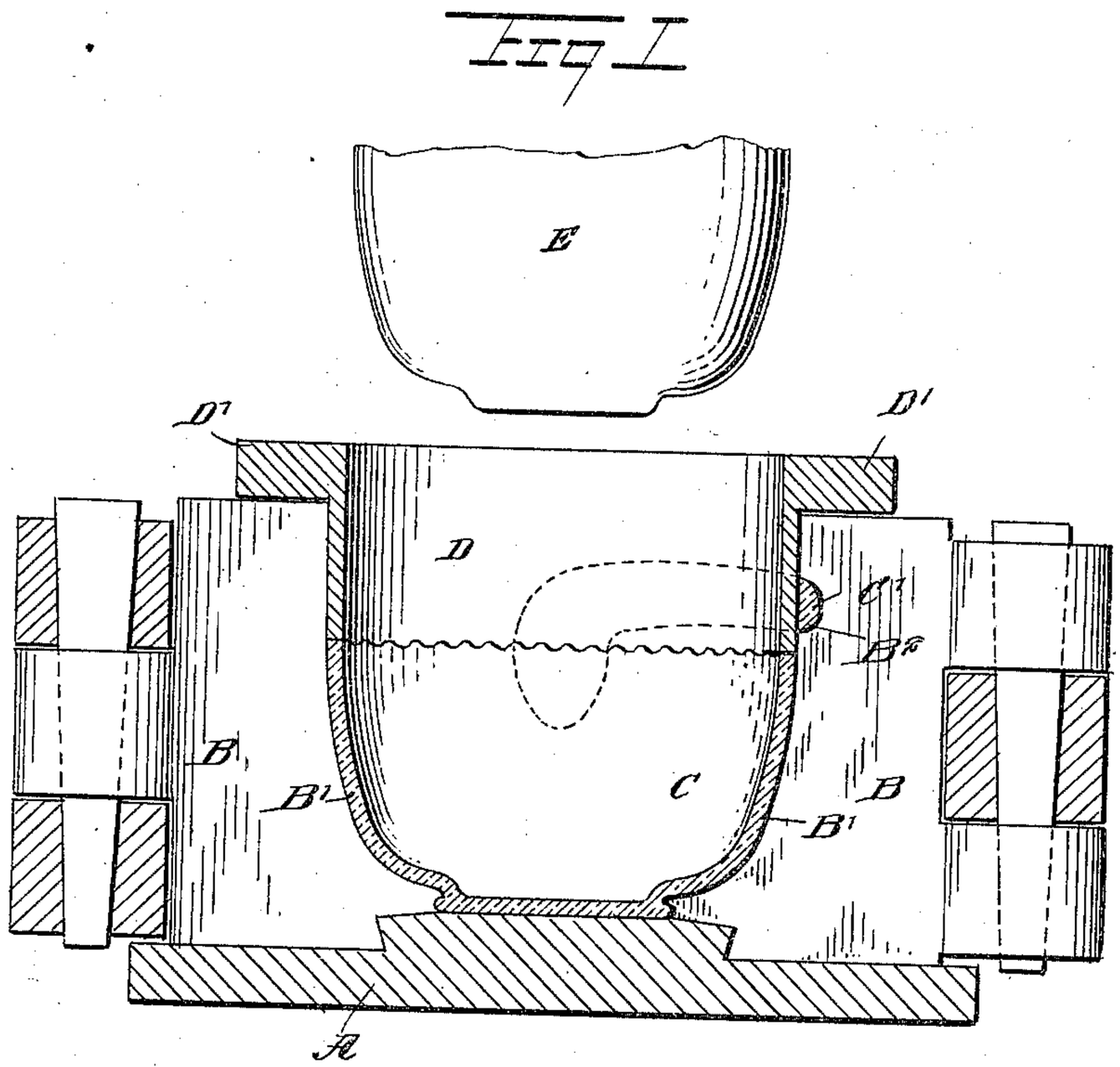


Fig 3

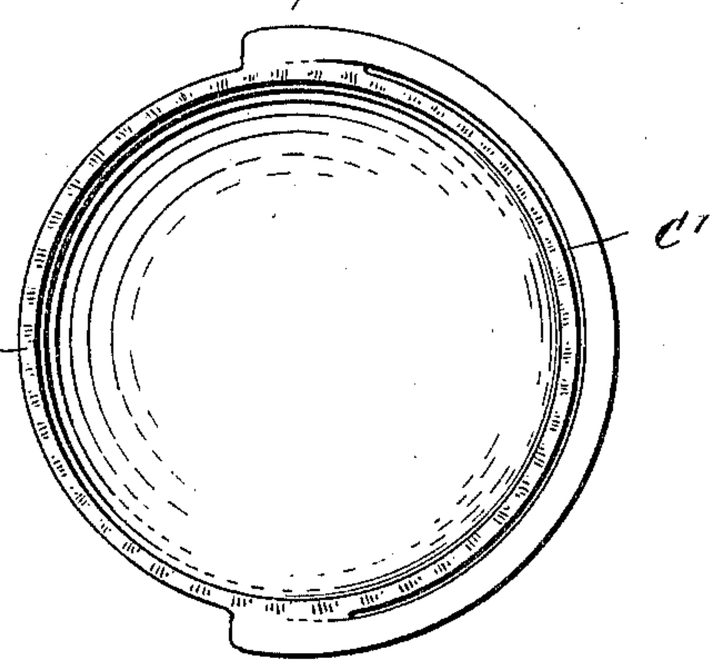


Fig 2

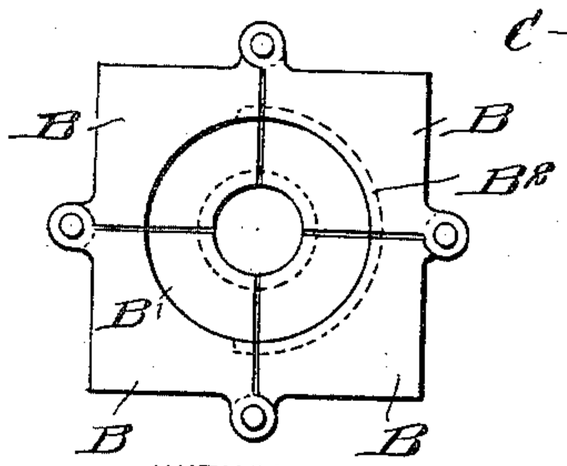
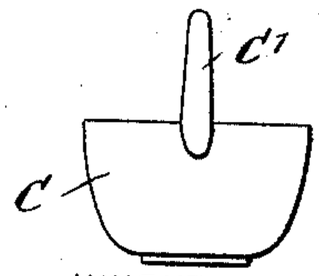


Fig 4



WITNESSES:

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MANUFACTURE OF HANDLED GLASSWARE.

SPECIFICATION forming part of Letters Patent No. 695,782, dated March 18, 1902.

Application filed June 10, 1901. Serial No. 63,891. (No model.)

To all whom it may concern:

Be it known that I, HARRY BASTOW, a citizen of the United States, and a resident of Steubenville, in the county of Jefferson and State of Ohio, have invented certain new and useful Improvements in the Manufacture of Handled Glassware, of which the following is a full, clear, and exact description.

The object of the invention is to provide certain new and useful improvements in the manufacture of handled glassware, such as glass baskets and the like, whereby the handle is cast directly upon the bowl or body to insure homogeneity between the body and the handle and render the manufacture of the article less expensive by avoiding the costly process of sticking the handle made from a separate piece of glass upon the body or bowl after the same is formed by pressing or blowing, as heretofore practiced.

A practical embodiment of the invention is represented in the accompanying drawings, forming a part of this specification, in which similar characters of reference indicate corresponding parts in all the views.

Figure 1 is a sectional side elevation of the article in the mold. Fig. 2 is a reduced plan view of the mold with the core removed. Fig. 3 is a plan view of the article after being finished in the mold, and Fig. 4 is a side elevation of the finished article.

In order to produce the article, I provide a mold having the usual base A and the sectional sides B, which when closed produce the form B′ for the sides of the article C and the form B^2 for the outside of the handle C′, said sides also receiving the ring D for forming the upper edge of the article, the inside of which is formed according to a plunger E, adapted to pass through the core into position above the base and spaced from the form B′, according to the thickness of the wall of the article. In order to produce the form B^2, some of the sides are grooved to correspond to the cross-section of the handle C′, the groove extending in a horizontal direction a distance above the top edge of the form B′ and then curving downwardly into the forms B′ at diametrically opposite sides, as will be readily understood by reference to Figs. 1 and 2. It is expressly understood that the sides B are shaped on the inside in such a manner that when closed they produce the form B′ for the side of the article, as well as the form B^2 for the outside of the handle, the latter extending as described, the form B′ being extended upward to receive the ring D for shaping with its lower edge the top of the article and with its side the inner face of the handle C′. By this arrangement the sides of the mold can be readily opened after the article is produced, it being understood that the division of the sectional sides is preferably on diametrical lines, as indicated in Fig. 3.

The ring D has a central aperture for the passage of the plunger E to form the inside of the article C, said ring D having flanges D′ adapted to be seated on the top of the sides B, so as to extend the core the desired distance down into the mold—that is, with the lower edge of the core at the upper edge of the form B′ for the article C. By the arrangement described the ring D forms the core for the handle C′ at the time the sides B are closed and the plunger E and the ring D are in position, and when the glass is now poured then the article C is formed with the handle C′ of the same mass as the body or bowl and integrally therewith at diametrically opposite sides, the shank of the handle extending horizontally a distance above the top edge of the bowl or body, as will be readily understood by reference to Figs. 1, 2, and 3. The article thus formed is then removed from the mold by opening the latter in the usual manner—that is, removing the plunger E and the ring D and opening the sides B—so that the article can be lifted from the base A. The article so far formed is reheated in a suitable oven or otherwise, and when the desired temperature has been reached then the handle C′ is bent upward to extend transversely of the bowl or body—that is, in a vertical plane passing through the axis of the bowl or body, as shown in Fig. 4.

From the foregoing it is evident that the handle C is formed integrally with the body or bowl and of the same mass of molten material, so that the costly process of manufacturing the handle separately and then sticking it upon the bowl or body is entirely obviated.

It is expressly understood that my inven-

tion relates to baskets or similar pieces having a homogeneous handle across the top of the basket-body from one point in the circumference to an opposite point thereof.

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

The herein-described method for forming handled glassware, consisting in molding the body and handle from the same mass, the handle being integral with the body at opposite points thereof, said handle extending approximately parallel with the upper edge of the body, and then reheating the body and handle and bending the latter to extend transversely of the body in a vertical plane passing approximately through the axis of the body, as set forth.

In testimony whereof I have signed my name to this specification in the presence of two subscribing witnesses.

HARRY BASTOW.

Witnesses:
GEORGE MORTIMER,
G. GRANT FISH.