No. 735,147. PATENTED AUG. 4, 1903.

C. T. PRATT.

CHAPLET.

APPLICATION FILED MAY 18, 1903.

NO MODEL.

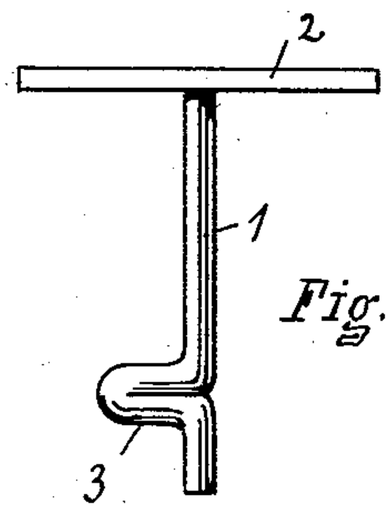


Fig. 1

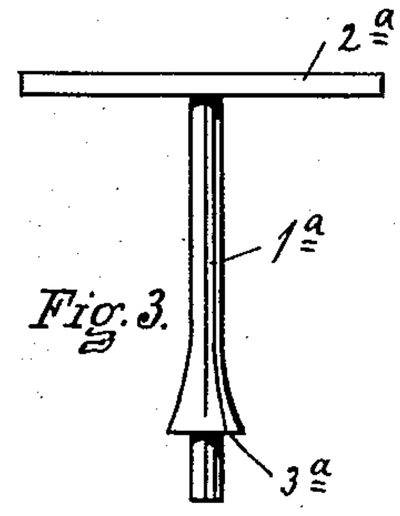


Fig. 3.

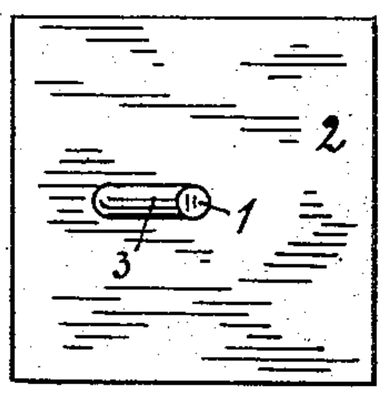


Fig. 2.

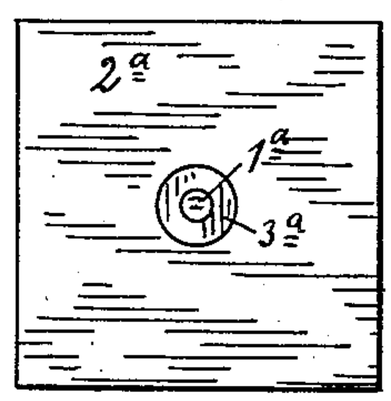


Fig. 4.

Fig. 5.

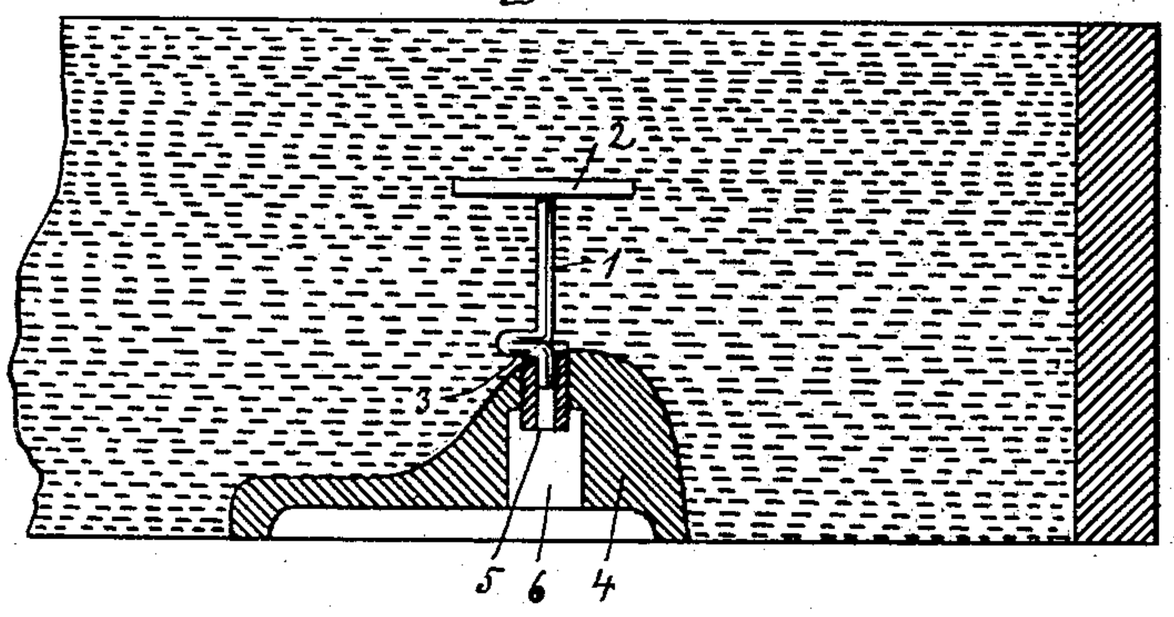
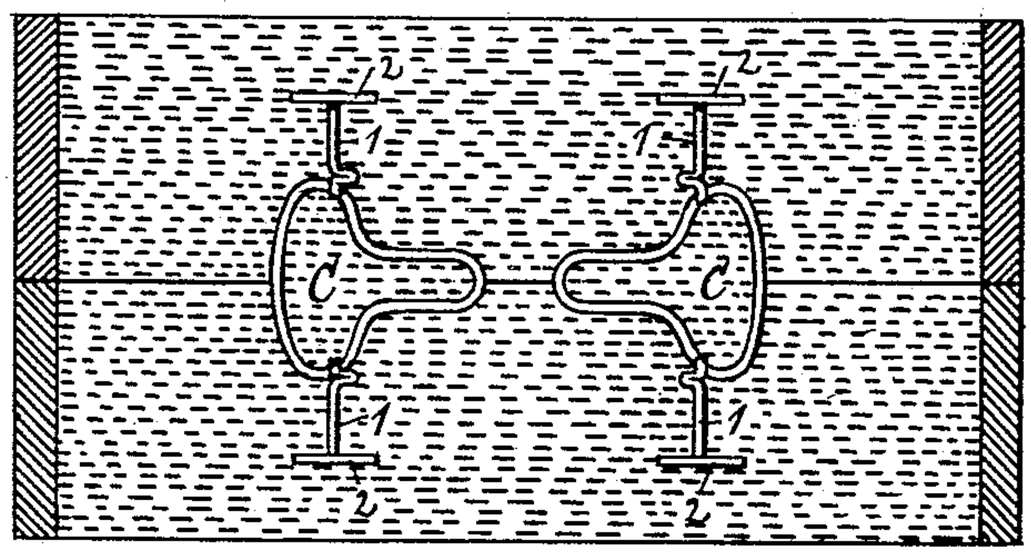


Fig. 6.



WITNESSES
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No. 735,147. Patented August 4, 1903.

UNITED STATES PATENT OFFICE.

CHARLES T. PRATT, OF FRANKFORT, NEW YORK.

CHAPLET.

SPECIFICATION forming part of Letters Patent No. 735,147, dated August 4, 1903.

Application filed May 18, 1903. Serial No. 157,553. (No model.)

To all whom it may concern:

Be it known that I, CHARLES T. PRATT, of Frankfort, in the county of Herkimer and State of New York, have invented certain new and useful Improvements in Chaplets and Molding-Patterns; and I do hereby declare that the following is a full, clear, and exact description of the invention, which will enable others skilled in the art to which it appertains to make and use the same, reference being had to the accompanying drawings, and to the letters and figures of reference marked thereon, which form part of this specification.

The object of my invention is to provide an improved chaplet, together with a mold or pattern for use in connection with the chaplet, whereby better and more accurate results can be attained with little or no special attention.

In the drawings, Figure 1 shows a side elevation, and Fig. 2 a bottom view, of one form of my chaplet. Fig. 3 shows a side elevation, and Fig. 4 a bottom view, of another form of chaplet. Fig. 5 shows in cross-section a portion of a molder's flask with a pattern in cross-section therein and the chaplet in position. Fig. 6 shows, on a reduced scale with reference to Fig. 5, the flask ready for casting with the casting-cores in position and the chaplets in position.

Referring to the reference letters and figures in a more particular description, 1 indicates the stem portion of the chaplet, and 2 the plate portion as shown in Figs. 1 and 2. The chaplet, as shown in Figs. 1 and 2, is provided with a shoulder at 3, formed by bending the stem 1.

In the form of construction shown in Figs. 3 and 4, 1^a indicates the stem portion of the chaplet, and 2^a the plate portion. The stem is provided with a shoulder 3^a, which in this case is circular, surrounding the end of the stem, and may be formed by upsetting or in any other suitable way.

In connection with either form of the chaplets described I propose to employ a pattern, as 4, which is provided with an opening receiving a hardened bushing 5, preferably of steel and capable of being adjusted in the opening which receives it by being driven longitudinally. The opening through the bushing 5 is adapted to receive the end of the chaplet. Below the bushing 5 there is provided a clearance-opening 6.

In using the pattern and chaplet the pattern is placed on the molding-surface and the chaplet is inserted in position therein, as shown in Fig. 5, with the end beyond the shoulder entering the bushing 5 and the shoulder resting on the end of the bushing. The sand is then placed around the pattern and chaplet and pounded down in the usual manner. When the pattern is removed, the portion of the chaplet-stem which projects beyond the shoulder is found projecting into the opening left by the pattern in the sand. These projecting ends serve to support the core (indicated by C in Fig. 6) when the casting is being poured. The projecting portions of the chaplet are cut off from the completed casting, as is customary in the use of chaplets.

The feature of the construction to which particular attention may be called is the fact that the shoulder on the chaplet serves to definitely locate the chaplet when making up the mold, and where several chaplets are employed on the same piece of work, as is quite customary, the amount that they will project into the mold for the purpose of supporting the core at exactly the desired position can be definitely fixed. With chaplets which have no shoulder by which to locate them it is extremely difficult to locate them exactly. If their end is allowed to project into a socket in the pattern, the socket is liable to become more or less filled with sand, and the projecting end of the chaplet would then fall short of the position which it should occupy. By employing the adjustable bushing 5 any wear can be nicely taken care of by driving the bushing outward, and also the amount that the end of the chaplet will project into the mold can also be nicely regulated in the same way. In soft-metal patterns the bushing 5 may be made of hardened steel, and thereby a better wearing surface or part secured.

What I claim as new, and desire to secure by Letters Patent, is—

1. A chaplet for molding having a stem with a shoulder formed thereon at the point

of separation between the mold and the pattern when used and a plate-like head or end, substantially as set forth.

2. The combination of a chaplet having a plate-like head or end and a stem with a shoulder thereon, of a pattern having an opening to receive the projecting end of the chaplet with the shoulder thereof resting on the pattern, substantially as set forth.

3. A chaplet having a shoulder on its stem portion adapted to engage the pattern and properly locate the chaplet in the mold, substantially as set forth.

4. A pattern having an opening to receive the end of the chaplet continued in a clearance-opening in the pattern and a chaplet having a shoulder to engage the pattern when the end of the chaplet is inserted in said opening, substantially as set forth.

5. A pattern having an opening to receive the chaplet and continued in a clearance-opening, an adjustable bushing in said chaplet-opening, and a chaplet having a shoulder to engage on the end of said adjustable bushing, combined, substantially as set forth.

In witness whereof I have affixed my signature, in presence of two witnesses, this 12th day of May, 1903.

CHARLES T. PRATT.

Witnesses:
W. J. MINARD,
F. B. WATSON.