C. J. P. HOEHN & G. GROSS.

PROCESS OF MOLDING SASH WEIGHTS.

APPLICATION FILED JUNE 15, 1908.

904,958.

Patented Nov. 24, 1908.

2 SHEETS—SHEET 1.

Fig. 1.

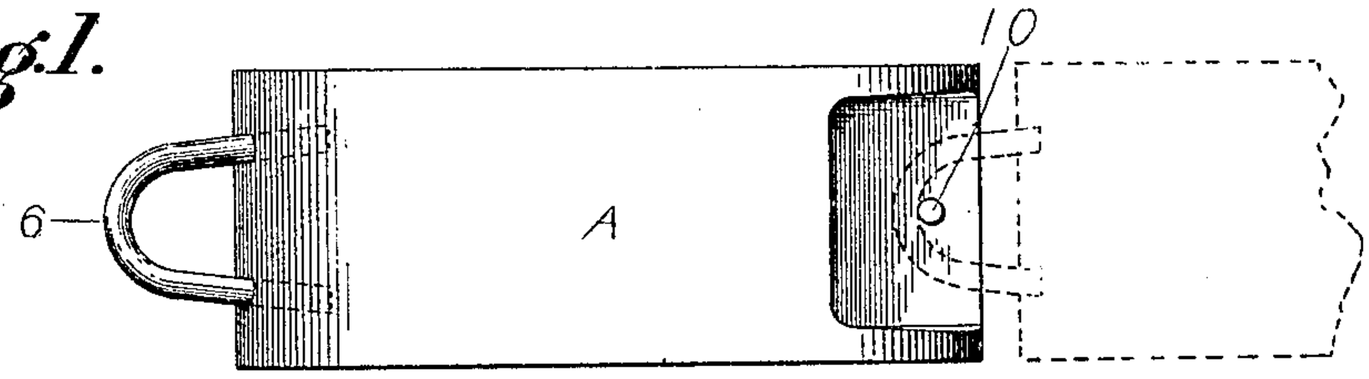


Fig. 2.

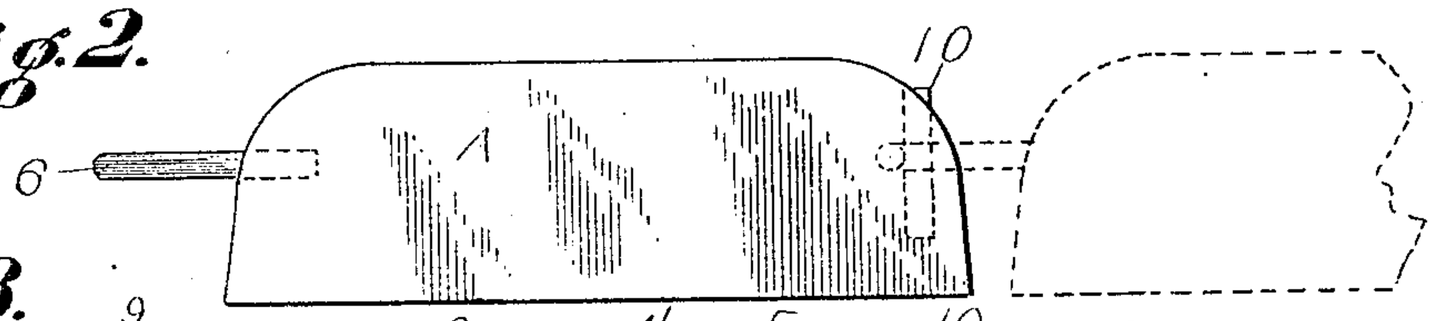


Fig. 3.

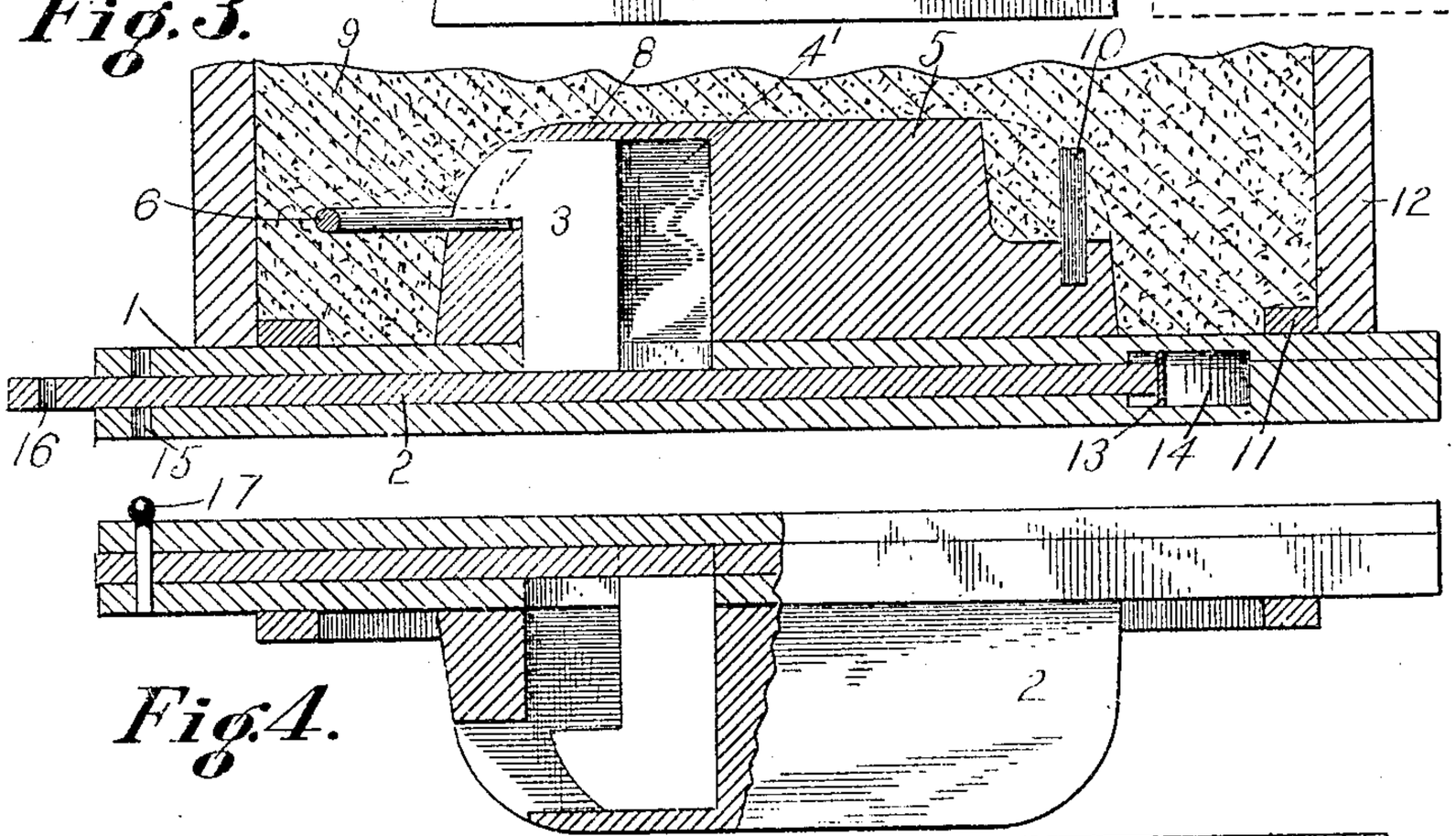
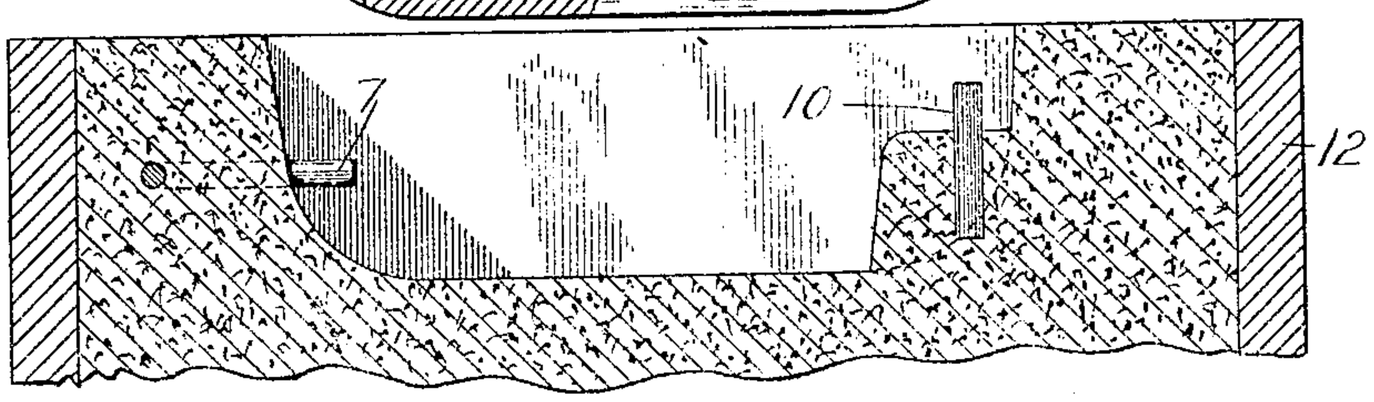


Fig. 4.



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2 SHEETS—SHEET 2.

Fig. 5.

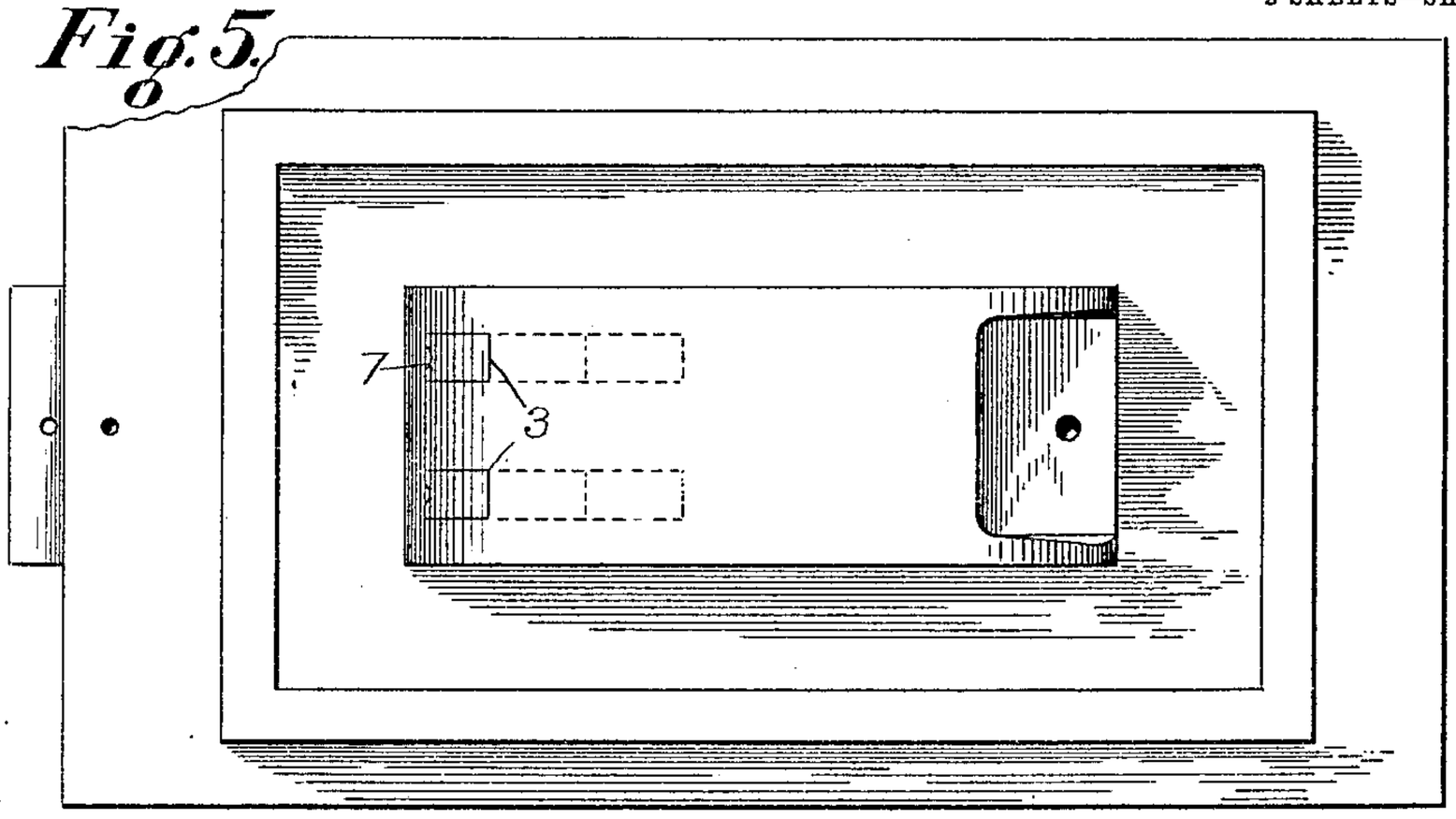


Fig. 6.

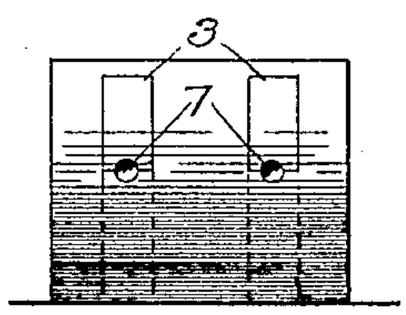


Fig. 7.

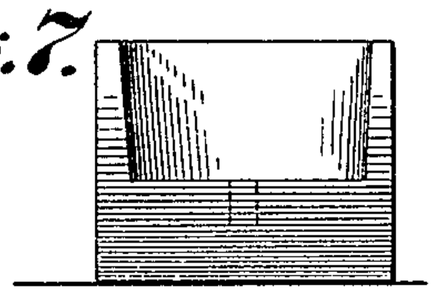
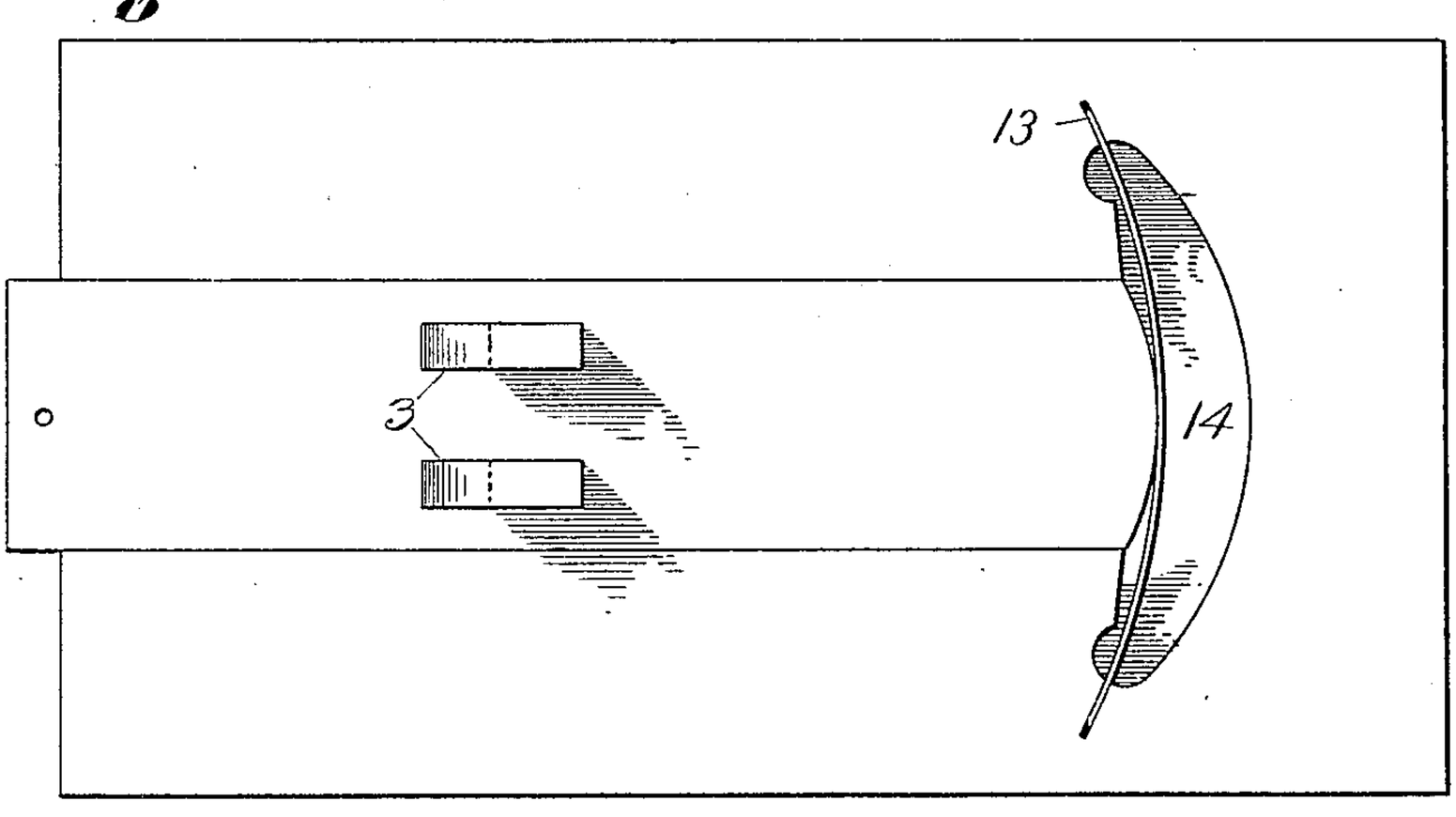


Fig. 8.



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UNITED STATES PATENT OFFICE.

CHARLES J. P. HOEHN AND GEORGE GROSS, OF SAN FRANCISCO, CALIFORNIA, ASSIGNORS TO ENTERPRISE FOUNDRY, A CORPORATION OF CALIFORNIA.

PROCESS OF MOLDING SASH-WEIGHTS.

No. 904,958. Specification of Letters Patent. Patented Nov. 24, 1908.

Application filed June 15, 1908. Serial No. 438,604.

To all whom it may concern:

Be it known that we, CHARLES J. P. HOEHN and GEORGE GROSS, citizens of the United States, residing at San Francisco, in the county of San Francisco, State of California, have invented certain new and useful Improvements in Processes of Molding Sash-Weights, of which the following is a specification.

This invention relates particularly to molding sash weights but is not limited in this respect, as it may be utilized in the molding of other articles where the part or parts embedded in the sand are of greater breadth, width or length than the base or plate of the pattern, requiring the pattern to be made in sections and withdrawn separately.

Our invention obviates the necessity for a sectional pattern.

In the accompanying drawing we have shown the invention in connection with a sash weight, but as stated, do not limit ourselves in this particular.

Figure 1 is a plan view of a sash weight of known construction. Fig. 2 is a side elevation of the same. Fig. 3 is a sectional view of a sand box with the pattern in place and the sand tamped around said pattern. Fig. 4 is a view of the sand box reversed and the pattern withdrawn. Fig. 5 is a plan view of the pattern. Figs. 6 and 7 are front and rear views of the pattern body minus the base. Fig. 8 is a detailed plan view showing the sub-base of the pattern.

The sash weights are indicated in Fig. 1 at A having a loop 6 at one end and a pin 10 at the other.

It is the object of this invention to provide simple and effective means for molding the sash weight with the staple 6 without requiring a sectional pattern.

As shown in these drawings, the pattern which is of the same shape as the body of the sash weight is shown at 5. This is supported upon a base plate 1 forming the bottom of the sand box 12 in the view shown in Fig. 3, and this base plate is provided with a movable plate 2 sliding within a recess within the base plate, as shown also in Fig. 8, and kept pressed outwardly in the position shown in Figs. 3 and 8 by a spring 13 held within an enlarged recess 14 in one end of the base plate and bearing against the end of the plate 2 so as to keep it pressed outwardly normally.

When it is desired to hold the plate 2 pressed inwardly resisting the pressure of the spring 13, we utilize a pin 17 which passes through an opening 15 in the base plate, which registers with an opening 16 in the sliding plate. The sliding plate carries the filler blocks 3, rigidly secured thereto, as shown in Figs. 3, 6 and 8, and these filler blocks are adapted to enter the cavity 4′ in the pattern when the sliding plate 2 is pushed back and when the plate is advanced by the pressure of the spring 13 the projecting portions 7 of the blocks extend into corresponding recesses in the pattern and engage the ends of the staple 6 holding the staple in place while the sand is being filled in to the sand box and around the pattern. In order to remove the pattern, it will be seen that it is only necessary to push back the sliding plate which will allow the pattern to be withdrawn, as shown in Fig. 4, leaving the staple properly embedded and supported in the sand. As will be seen, the construction enables the ready removal of the pattern without disturbing the projecting end of the staple.

The pin 10 is shown in the pattern in Fig. 3, and as held in the sand in Fig. 4. This pin 10 lies in the direction of withdrawal and so no special provision is necessary to hold it in place.

The figure 11 simply indicates a strip on the base plate to direct the sand box into the proper position.

What we claim is:—

1. In the molding of sash weights and the like, a pattern a projecting part extending from said pattern and a movable filler block supporting the same, substantially as described.

2. In combination with a pattern, a part supported therefrom and adapted to form a permanent part of the casting a filler block for supporting said part during the molding operation, said filler block being movable to allow the withdrawal of the pattern without disturbing the inserted part, substantially as described.

3. In combination with a pattern having a cavity a movable filler block adapted to enter said cavity and hold to the pattern during the tampering operation an inserted piece, and means for moving said filler block to allow the withdrawal of the pattern, substantially as described.

4. In combination, a base-plate 1, a mold supported thereby and having an interior cavity, a movable plate 2, a filler block carried thereby and adapted to support an inserted piece, the said block extending into the cavity in the mold and adapted to be detached therefrom in the movement of its supporting plate, substantially as described.

In testimony whereof we have affixed our signatures in the presence of two witnesses this 11th day of April, 1908.

CHARLES J. P. HOEHN.
GEORGE GROSS.

Witnesses:
HENRY J. F. NIEMANN,
HENRY MARTENS.