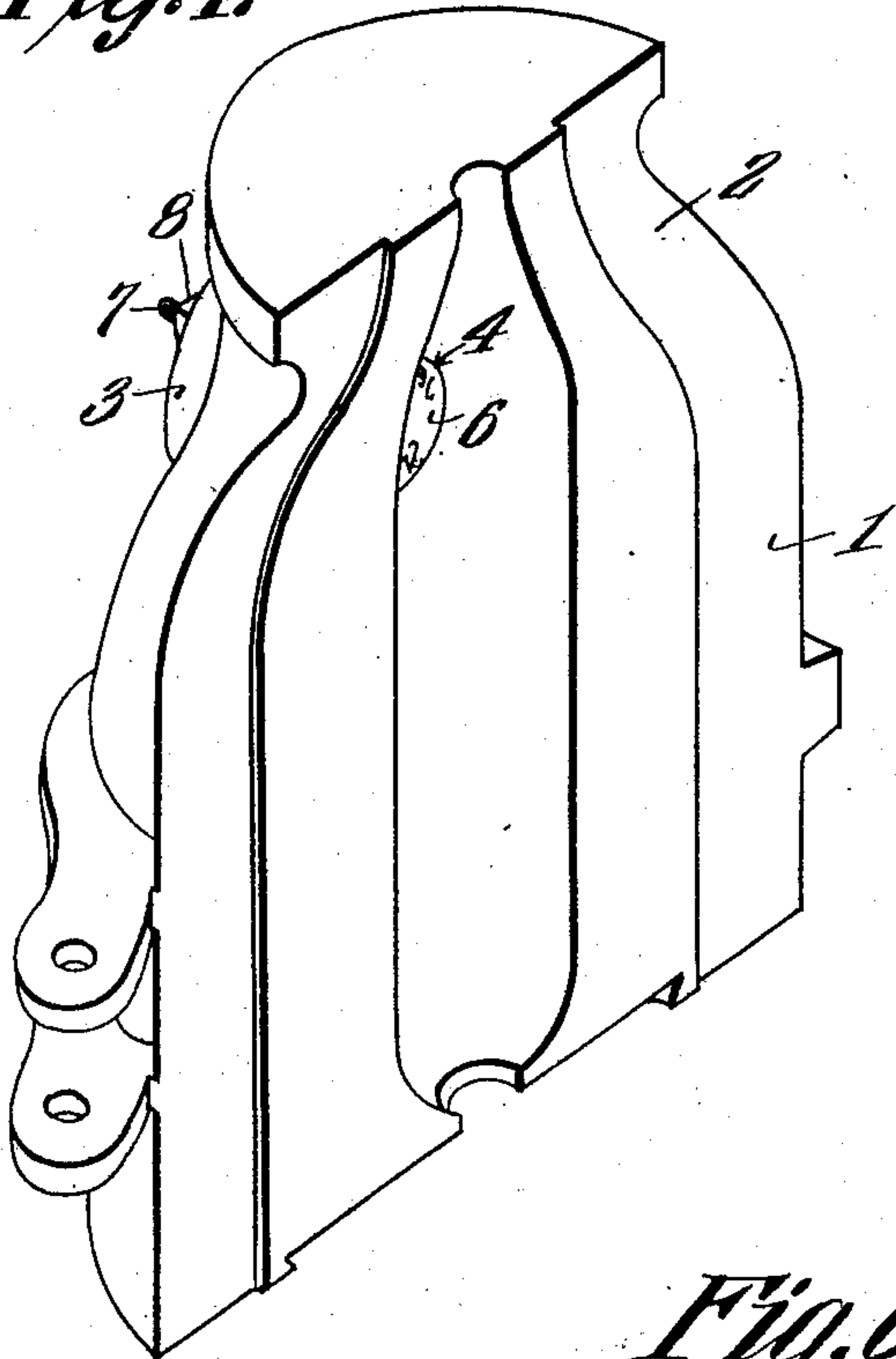


W. S. WHEATON.  
BOTTLE MOLD.  
APPLICATION FILED MAR. 28, 1911.

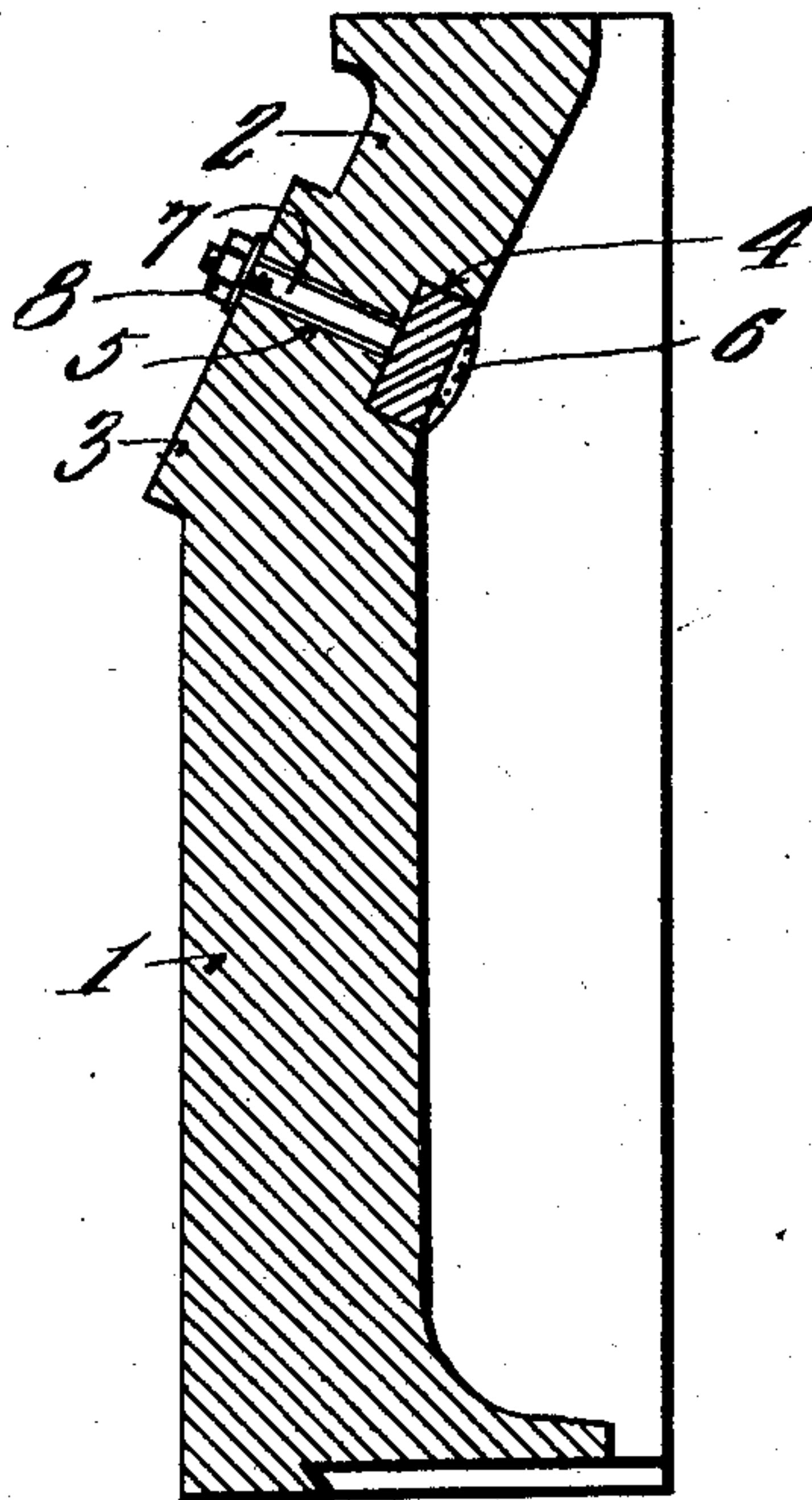
992,830.

Patented May 23, 1911.

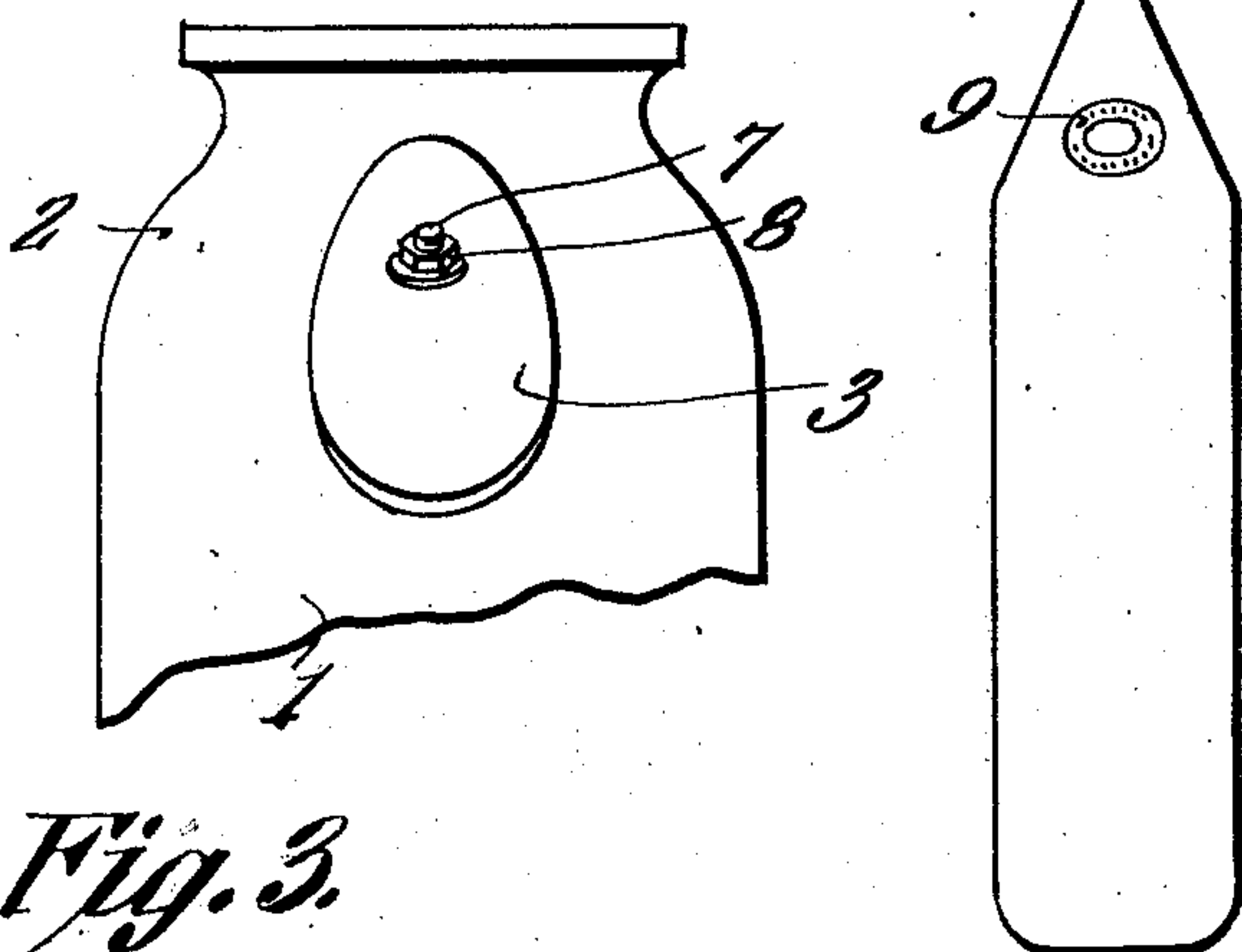
*Fig. 1.*



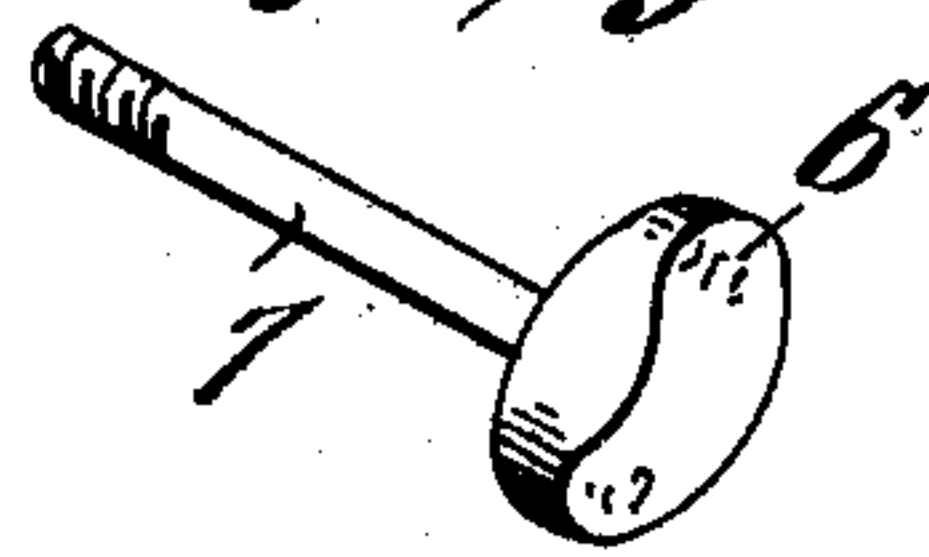
*Fig. 2.*



*Fig. 6.*



*Fig. 4.*



*Fig. 5.*



*Fig. 3.*

Witnesses

*J. J. McMein*  
*L. H. Wilson*

*W. S. Wheaton,*  
Inventor

by *C. A. Snow & Co.*  
Attorneys



# UNITED STATES PATENT OFFICE.

WALTER S. WHEATON, OF MILLVILLE, NEW JERSEY.

## BOTTLE-MOLD.

992,830.

Specification of Letters Patent.

Patented May 23, 1911.

Application filed March 28, 1911. Serial No. 617,393.

*To all whom it may concern:*

Be it known that I, WALTER S. WHEATON, a citizen of the United States, residing at Millville, in the county of Cumberland and State of New Jersey, have invented a new and useful Bottle-Mold, of which the following is a specification.

This invention relates to bottle molds and consists in the novel construction and arrangement of its parts as hereinafter described and claimed.

The object of the invention is to provide a bottle mold with an interchangeable die which may bear a trade mark or legend, the mold being so formed that the die will make its imprint upon the breast of the bottle and not upon the body of the same as is the usual practice. Also the portions of the material of which the mold is composed is so distributed about that part of the mold which contains the recess in which the said interchangeable die is seated as to strengthen the structure of the mold notwithstanding the fact that it is provided with a recess for the reception of the die.

To fully set forth the advantages of the mold it is considered necessary to explain the circumstances and conditions that surround the kind of bottle that is intended to produce from the mold. The mold is especially adapted to be used for forming infants' nursing bottles and these bottles include cylindrical body portions with tapering conical breast portions which merge into necks having bends upon which nipples may be mounted. It has been the practice heretofore to form upon the cylindrical body portion of the bottle characters, or legends descriptive of the bottle or of an advertising nature and in use it has been demonstrated that the characters and legends so positioned upon the bottle are objectionable for the reason that in the course of handling the bottle the body portion is usually used as the grip and consequently the said characters or legends accumulate filth or foreign matter which renders the bottle objectionable from sanitary points of view. Therefore in the manufacture of these bottles it is the aim to preserve the advantages incident the advertising features and means of identification and at the same time to avoid the objections above pointed out in connection with the bottle having the said advertising matter positioned as indicated. Therefore

in the manufacture of the bottles from the mold as hereinafter described the advertising matter or means of identification is impressed or formed upon the breast of the bottle instead of upon the body or handle portion of the same. Consequently the breast of the mold must be recessed to receive the interchangeable dies and as this portion of the mold is subjected to maximum pressure during the time that the bottle is being formed or blown therein, it is necessary to distribute the material of which the mold is composed about the recess as to effectually brace the structure and preserve the strength of the mold notwithstanding the presence of the said recess. Without a proper distribution of material thereabove the recess would have a tendency to materially weaken the mold at that point which is subjected to maximum pressure.

In the accompanying drawings:—Figure 1 is a perspective view of one of the mold halves. Fig. 2 is a transverse sectional view of the same. Fig. 3 is an outside elevation of a portion of the same. Fig. 4 is a perspective view of a detachable die which may be used in the mold. Fig. 5 is a side elevation of said die. Fig. 6 is a side elevation of a bottle such as is formed by the mold.

The mold consists of the usual halves each of which is provided with a body portion 1 of maximum diameter, a breast portion 2 of gradually decreasing diameter into which the upper portion of the body 1 merges and an exserted portion 3 standing out from the upper part of the body portion 1 and the sides of the breast portion 2. The breast portion 2 is recessed upon its inner surface as at 4 and a cylindrical bore 5 is provided in the said portion said bore extending from the recess 4 through the exserted portion 3 to the outer surface thereof. A detachable die 6 fits snugly in the recess 4 and is provided with a shank 7 which traverses the length of the bore 5 and a nut or other securing device 8 is screw threaded upon the outer end of the said shank and bears against the outer surface of the exserted portion 3. The exserted portion 3 is of greater diameter than the recess 4 and is so positioned with relation to the said recess that the walls of the recess are within the circumference of the edge of the said exserted portion. Therefore there is a distribution of material at the breast of the body which maintains



the strength of the molds notwithstanding the fact that the breast is provided with a recess for the reception of the die 6.

In view of the fact that the dies 6 are  
5 interchangeable a manufacturer may use the mold herein described and by changing the dies different trade marks or advertisements for the same or different customers may be placed upon the breasts of the bottles at the  
10 time that they are formed. Fig. 6 shows a bottle so made with the trade mark or advertisement indicated at 9 located upon the breast thereof.

Having described the invention what I  
15 claim as new and desire to secure by Letters Patent is:—

A mold having a body portion of maximum diameter merging into a breast portion of gradually reduced diameter with an

exserted portion standing out from the body 20 and breast portion, said mold having a recess in the inner surface of its breast portion and a bore extending from said recess through the breast and exserted portions, a detach-  
able die fitting snugly within said recess and 25 having a shank which traverses the length of the said bore, and a securing device mounted upon the outer end of said shank and bearing against the outer surface of said  
exserted portion. 30

In testimony that I claim the foregoing as my own, I have hereto affixed my signature in the presence of two witnesses.

WALTER S. WHEATON.

Witnesses:

J. E. MITCHELL,  
CLARENCE CORSON.

---

Copies of this patent may be obtained for five cents each, by addressing the "Commissioner of Patents, Washington, D. C."

---