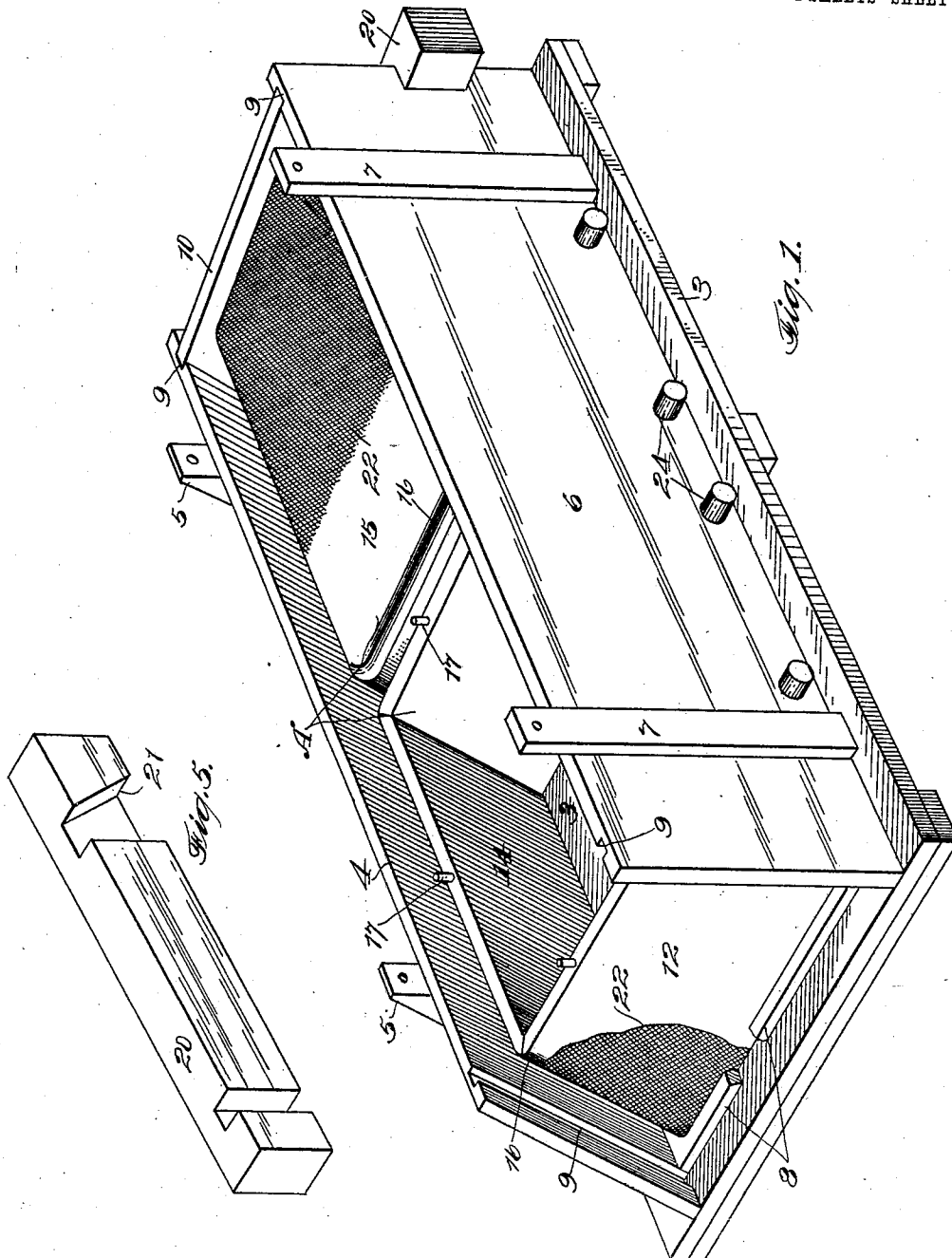


T. V. GALASSÉ.
MOLD FOR CEMENT WASHTUBS.
APPLICATION FILED MAR. 10, 1909.

941,139.

Patented Nov. 23, 1909.

2 SHEETS—SHEET 1.



WITNESSES:
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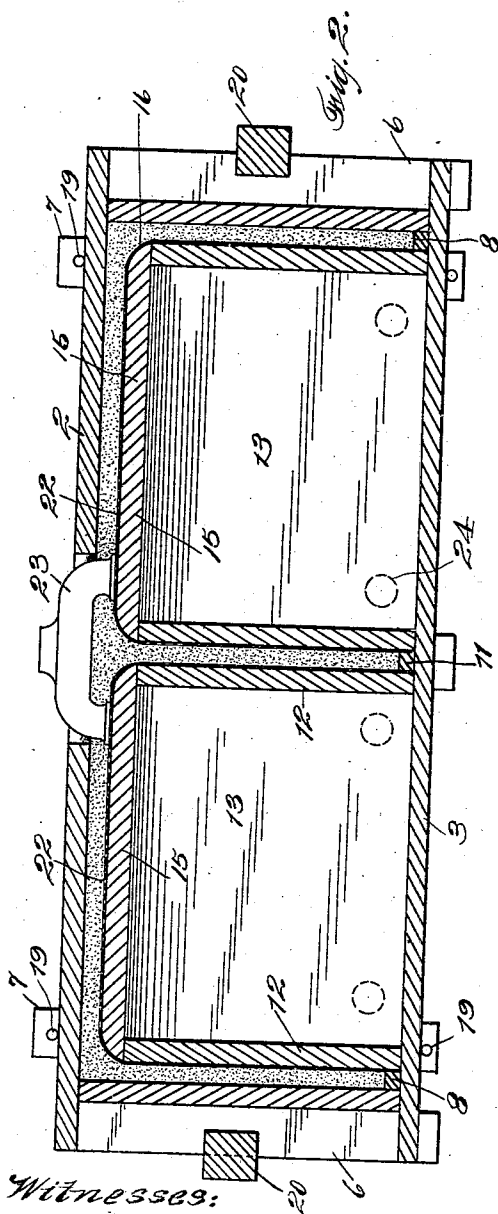
Inventor
Theodore V. Galassé
By Geo H. Strong
his Atty.

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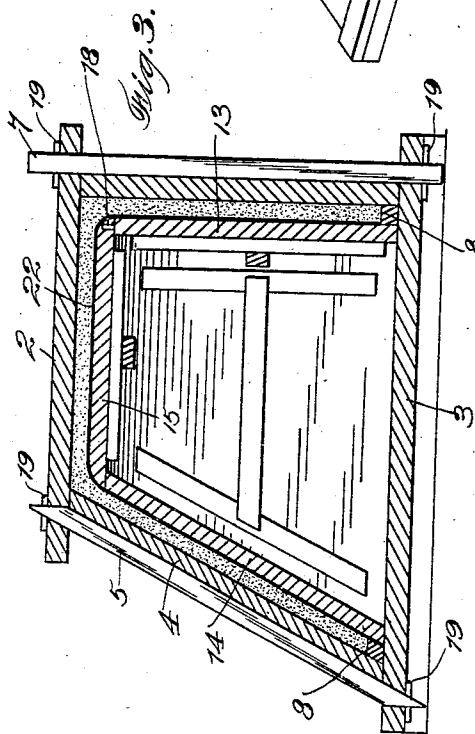
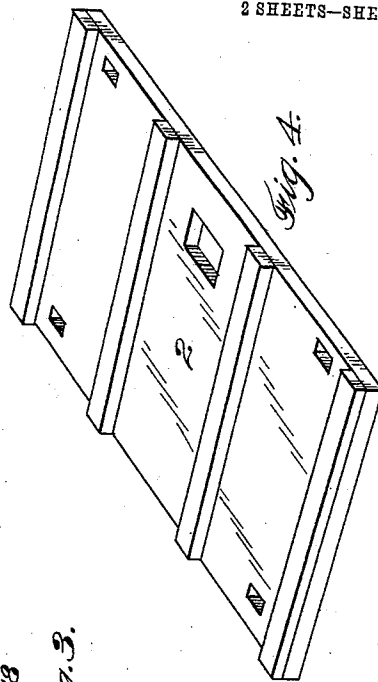
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2 SHEETS—SHEET 2.



Witnesses:

F. & Maynard
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Inventor:
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UNITED STATES PATENT OFFICE.

THEODORE V. GALASSÉ, OF SAN FRANCISCO, CALIFORNIA.

MOLD FOR CEMENT WASHTUBS.

941,139.

Specification of Letters Patent.

Patented Nov. 23, 1909.

Application filed March 10, 1909. Serial No. 482,560.

To all whom it may concern:

Be it known that I, THEODORE V. GALASSÉ, a citizen of the United States, residing in the city and county of San Francisco and State of California, have invented new and useful Improvements in Molds for Cement Wash-tubs, of which the following is a specification.

This invention relates to molds, and pertains especially to sectional molds for the manufacture of cement wash-tubs, and other trapezoidal hollow shapes, basins, trays, and the like.

It is a particular purpose of my invention to devise a mold which will so facilitate the manufacture of wash-tubs or trays that a large increase of production is obtained, and at the same time the amount of capital invested in the molds is much reduced; also, I provide a mold having sections of such design that they may be removed from the cast while it still contains a large per cent. of moisture, without danger of fracturing or defacing the article.

A further object is to enable a manufacturer by this improved mold to employ unskilled labor, and still produce a cement tub of superior strength, handsome appearance, and in such a complete condition that it can be attached in a building at once.

The invention consists of the parts and the construction and combination of parts as hereinafter more fully described and claimed, having reference to the accompanying drawings, in which—

Figure 1 is a perspective view of the assembled mold, with some sections removed. Fig. 2 is a longitudinal vertical section of the mold in filling position. Fig. 3 is a transverse section. Fig. 4 is a perspective showing the top section. Fig. 5 is a detail of a clamp-bar.

My invention, as embodied in practical, commercially successful molds now in use, comprises, in conjunction with one or more sectional knock-down core-boxes A, a top section 2, a bottom or bed-plate 3, an inclined front panel 4, to which are secured side stakes 5 insertible in holes provided for them in the top and bottom, and a back panel 6, secured to which are similar locking stakes 7; the core-boxes being spaced from the side and end panels by the strips 8 corresponding with the thickness of the tub to be molded, and the strips 8 serving to hold

the core-boxes in place. The inner smooth faces of the front panel 4 and back 6 are suitably recessed or slotted transversely, as at 9, to receive the end panels 10, these several panels, when assembled, forming the mold for the exterior of the article to be made.

When it is desired to form a double tub, or one having two compartments, I provide two removable, sectional core-boxes A which, as shown in Fig. 2, are assembled upon the bottom or bed section 3 and alined and temporarily held thereon by the spacing strips 8, and separated by the cross spacing strip 11.

The core-boxes are similar in form and comprise end panels 12, a vertical back panel 13, and an inclined front panel 14. The ends 12 and the back 13 preferably stand vertically upon the base 2 of the mold, while the core-front 14 inclines parallel with the front 4 of the mold, and the intersecting corners of the core-box panels are mitered so that a tight, perfect joint is obtained; and a core-bottom or cover-panel 15 is adapted to be placed upon and doweled to the edges of the core-sections, or otherwise held in place, as by the pins 17 in the end edges of the panels 12—13—14 engaging in perforations 18 in the bottom or cover-panel 15. The several corners 16 of the core-box are nicely rounded to give the proper form and strength to the intersecting walls inside of the tub.

The method of assembling and operation of the mold will then be as follows: The mold section 3 is inverted upon the floor of the mold room, with the strips 8—11 uppermost. The core-boxes are then set up, one on each side of the center strip 11; the mold back 6 is placed on its edge upon top, parallel with the core-boxes 10, the inner lower corner of the back 6 abutting snugly the space strip 8. The end sections 10 are inserted in the slots 9 of the back 6. The front 4 is then set up, the stakes 7 of the back 6 and front 4 passing through the slots in the panel 3, and keyed in place by removable pins or keys 19. The forward edges of the end sections are inclined so that the front 4 will stand at an angle to the top section 2 and parallel with the inclined fronts of the core-box; the several mold panels being set at the requisite distance from the core-boxes by the space strips 8, a space is provided which will give the desired thickness and

form to the walls of the tub to be cast. Clamp-bars 20 with side cam grooves 21 are applied to the projecting edges of the ends of sections 4 and 6 to lock them in position.

5 After the mold has been assembled, except as to the top panel 2, the operator stretches a fabric or other suitable cover 22 tightly over each core-box and proceeds to fill the mold space with plastic cementitious material having the desired ingredients, 10 tamping constantly to insure a compact homogeneous, monolithic structure, which may be reinforced, if desired.

When the filling has been completed, a 15 drain coupling 23 is then placed centrally upon the core-box cover 15, so as to bridge the central space. The cement is then tamped perfectly around the coupling, thereby hermetically and solidly embedding it in the bottom of the tub, following which 20 the cover or mold panel 2, having a central opening to clear the coupling 23, is fitted over the now filled mold, the upwardly projecting stakes 7 being long enough to receive keys 19 which lock the entire mold 25 rigidly and prevent the displacement of any of the members by expansion or contraction.

A most important and valuable function 30 of this invention is the provision of a device so constructed and arranged that as soon as the operation of filling has been completed and the cover pinned on, the mold is then turned over, as shown in Fig. 1, so that the 35 molded tubs stand upright, being supported for the time being on the narrower panel 2 of the mold.

I have found in manufacturing tubs with molds of this design, and by using the fabric 40 envelop 22 of cheese-cloth or the like, that it is unnecessary to wait for the cement filling to set, and I proceed to dismount the mold soon after securing the section 2 and turning the mold over, by driving out the 45 keys 19, removing the panel 3, and withdrawing the independent sections of the core-boxes one at a time, so as not to disturb or mar the still moist, soft cement.

The withdrawal of the core-boxes is 50 greatly facilitated by employing the envelop or fabric 22, as it prevents the cement from contacting with or adhering to the core sections, but primarily protects the filling from accidental injury by the laborer, while removing the core-boxes. After withdrawing 55 the core-boxes he pulls the wet cloth off the inner walls of the tub, and while these are yet moist applies a finishing white or other suitable coat of dry pulverized enameling 60 material which in this way becomes perfectly united with the main body of the walls of the tub.

Ordinarily the tubs are left in closed 65 "set", and the finishing coats are applied

to the dry hard surface, which results in an inferior article, since there is no close tie or bond between the two materials such as is obtained by the application of the coating before the cementitious action has ceased in 70 the material of the tub.

For the purpose of molding the walls of the tubs as nearly finished and ready for connection with the plumbing system of a building, the back panel of the mold may 75 be perforated to receive the plugs 24 which project into the mold and abut against the rear wall of the core-box or boxes, whereby any desired perforations, or the like, for the reception of faucets, drains, overflows, 80 etc., are formed in the tub walls, obviating the necessity of chipping or drilling after removal from the mold.

It is manifest that the mold may be made to accommodate one or any desired number 85 of core-boxes A.

Having thus described my invention, what I claim and desire to secure by Letters Patent is—

1. A mold for tubs and the like comprising 90 a bottom panel having a rectangular ledge on its upper surface, a sectional core-box with removable sides, ends and top resting on said bottom panel and supported within said ledge, side and end panels supported on said bottom panel and on the outside of said ledge and spaced from the core-box, and bars having notches in the end adapted to fit the projecting ends of the outside side panels for locking said outside 100 panels rigidly together.

2. A mold for tubs and the like comprising a bottom panel having a rectangular ledge on its upper surface, a sectional core-box with removable sides, ends and top resting 105 on said bottom panel and supported within said ledge, side and end panels supported on said bottom panel and on the outside of said ledge and spaced from the core-box, and means for locking said outside 110 panels rigidly together, said last-named means comprising clamp-bars having wedge notches fitting the projecting ends of said outside side panels.

3. A mold for plastic hollow articles of 115 trapezoidal shape comprising a bottom panel, on the upper surface of which is a surrounding ledge, a core-box supported inside the ledge, removable side panels supported on said bottom panel and on the outside of said ledge and spaced from the core-box, a removable fabric covering of cheese-cloth or the like placed over the core-box, and means for locking the side panels of the mold together. 125

4. In a mold, the combination of a bottom panel having a continuous ledge on its upper side, a removable core-box supported on said panel within said ledge, said core-box comprising side, end and top panels, said 130

side and end panels abutting loosely against each other and said side and end panels carrying pins on their upper side fitting perforations in said top panel whereby the core-box is held together in the space within said surrounding ledge, and said mold having removable, sectional side and end panels parallel with the sides and ends of the core-box.

10 5. A mold comprising a bottom panel, a removable, sectional core-box supported on said panel, said core-box comprising side and end panels and a top panel, means on the said bottom panel of the mold engaging
15 the bottom edges of the side and end panels of the core-box, and means on the upper edges of said side and end panels of the core-box interlocking with the top panel or cover of the core-box and cooperating with
20 said means on the base panel to hold the core-box together in assembled position, and said mold having sectional removable side and end panels spaced from the core-box,

with means for locking the side and end panels of the mold together.

25 6. A sectional mold comprising a base panel having a continuous ledge, a sectional core-box fitting within said ledge, side and end mold panels supported on the base panel and spaced from the core-box, said side
30 panels having cross braces with the ends projecting beyond the side edges of said side panels, one end of said braces fitting perforations in the bottom panel of the mold and outside of said continuous ledge, a cover
35 panel for the mold and having perforations for the other end of said braces, and clamps engaging the side panels to hold the mold together.

In testimony whereof I have hereunto set
40 my hand in presence of two subscribing witnesses.

THEODORE V. GALASSÉ.

Witnesses:

CHARLES A. PENTFIELD,
FREDERICK E. MAYNARD.