H. HEESEMANN.

CHAPLET FOR METAL CASTING.

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1,043,102.

Patented Nov. 5, 1912.

Fig. 1

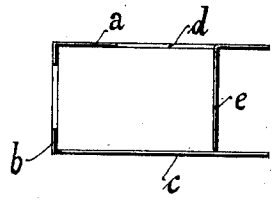


Fig. 2

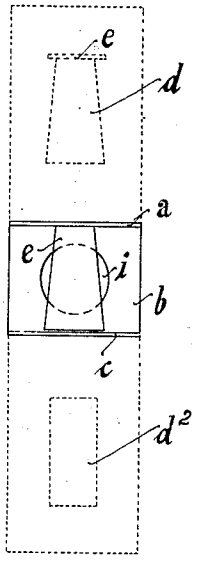


Fig. 3

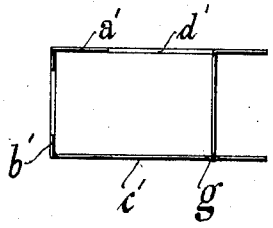
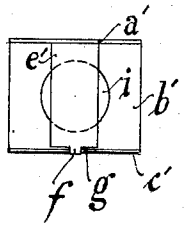


Fig. 4



Witnesses:

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UNITED STATES PATENT OFFICE.

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CHAPLET FOR METAL-CASTING.

1,043,102. Specification of Letters Patent. Patented Nov. 5, 1912.

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To all whom it may concern:

Be it known that I, HEINRICH HEESEMANN, a subject of the Emperor of Germany, residing at Herscheid-Friedrichsthal, Westphalia, Germany, have invented certain Improvements in Chaplets for Metal-Casting, of which the following is a specification.

It is usual in metal casting to employ a chaplet for supporting the core when the center of gravity of the latter is outside the line of the main support. Such chaplets are sometimes made out of a single metal plate which is cut and bent so as to form parallel sides distanced by stays.

The present invention relates to a chaplet of this kind and consists in the provision of a rectangular plate which is bent twice at right angles. Apertures are stamped out of the plate to serve as relief passages for the gases and prevent the formation of blisters, in known manner. One or more of these apertures, made in the center of the end members of the chaplet, are shaped so that the flaps stamped out therefrom can serve as stays for maintaining the outer bends of the plate parallel to one another, the flaps being for that purpose left connected at one end. A very simple and serviceable chaplet is obtained in this manner.

In the accompanying drawings the invention is illustrated, Figure 1 representing a longitudinal section of one form of construction, Fig. 2, an end view of the chaplet, showing the development of the plate by dotted lines, Fig. 3, a longitudinal section of another form of construction, and Fig. 4, a cross-section of Fig. 3, taken through the point of support.

The chaplet is formed of a rectangular metal plate which is bent twice at right angles so as to form a frame composed of the members *a b* and *c* and which has suitably shaped apertures *d*, *i* stamped therein. One of the stamped out flaps, either of the upper or the lower frame member (*a* or *c*), is left connected at one side and is bent at right angles to its original plane in order to serve as a supporting stay *e*.

Although the supporting stay is in itself sufficiently stable, and a slipping of the same is hardly to be feared, it is advisable to provide means for holding it in position. Such an arrangement is shown in Figs. 3 and 4 according to which the chaplet is formed of the members a^1 b^1 and c^1, the stay e^1 being made of the flap stamped out of the aperture d^1. In stamping the flap e^1 a tongue *f* is formed on its outer end, which tongue is put into engagement with a corresponding aperture *g* made in the member c^1 of the frame. In this manner a slipping of the stay is effectively prevented. If the chaplet is of considerable size, several stays *e* or e^1 may be provided.

The apertures made in the strip may be of different shape. The member *b* of the chaplet may for instance be provided with a round aperture *i*. The aperture in the member *a* may either be trapezoidal, as shown in Fig. 2, or rectangular. An aperture d^2, shown dotted in Fig. 2, may be made in the member *c*.

I claim:

1. A chaplet of the character described, comprising a rectangular metal strip bent twice at right angles, and flaps stamped out of the center of one end member of the chaplet thus formed and bent so as to bear against the opposite member, substantially as and for the purpose set forth.

2. A chaplet of the character described, comprising a rectangular metal strip bent twice at right angles, flaps stamped out of the center of one end member of the chaplet thus formed and bent so as to bear against the opposite member, and tongues formed on the outer ends of said flaps to take into apertures in said opposite member for securing the flaps in position.

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Witnesses:

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