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COMBUSTIBLY-DESTRUCTIBLE MOLD CORE

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This invention relates to mold cores for use in casting hollow articles and specially water, gas and like pipes, and has been specially devised in order to expedite, cheapen and improve the manufacture of combustibly destructible or reducible cores, which will be more efficient in use than those as hitherto manufactured.

Mold cores are built up or formed upon hollow, solid or fluted barrels and consist of an inner, central, or first coat or layer of a combustibly destructible and reducible material and an external layer or covering of loam.

The improvement consists in producing the combustibly destructible or reducible inner or first layer of a material consisting of a mechanical mixture of paper, either waste paper or paper pulp, and sand whereby the cost of production is reduced and the combustibility of such layer is increased thus rendering the cores more efficient and expeditious in use.

The combustibly destructible or reducible material is produced by grinding paper, either waste paper or paper pulp, and a small proportion of sand with addition of requisite water, preferably in which clay has been puddled into a fine state in any suitable grinding mill until the resultant material is in a wet mash consistency such as will not flow but will permit the material to be readily spread and applied upon a core barrel and will be of sufficient clinginess, adhesiveness or stickiness to cling and remain and keep its imparted form upon said barrel as it is applied thereto.

The produced material is formed to requisite thickness upon the core barrel in any convenient and suitable manner and if necessary dried or partially dried in convenient manner, whereafter the core is built up to requisite diameter or cross sectional shape or thickness with known material such as foundry loam and then dried for subsequent use.

Cores for angular articles such as bends may be produced upon a core barrel of complementary contour, the improved material being applied thereon and formed to approximate dimensions, the loam covering being applied thereover and trued off in any convenient manner, the formed core then being dried for subsequent use.

I claim:—

A method of forming a mold core which consists in grinding paper, sand and requisite liquid into a moldable consistency, coating the core bar with this composition to form a combustible layer and then applying an external coating of loam.

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