W. W. Pullis.

Molding Sash Weights.

No. 101,504. Patented Apr. 5, 1870.

Fig. 1.

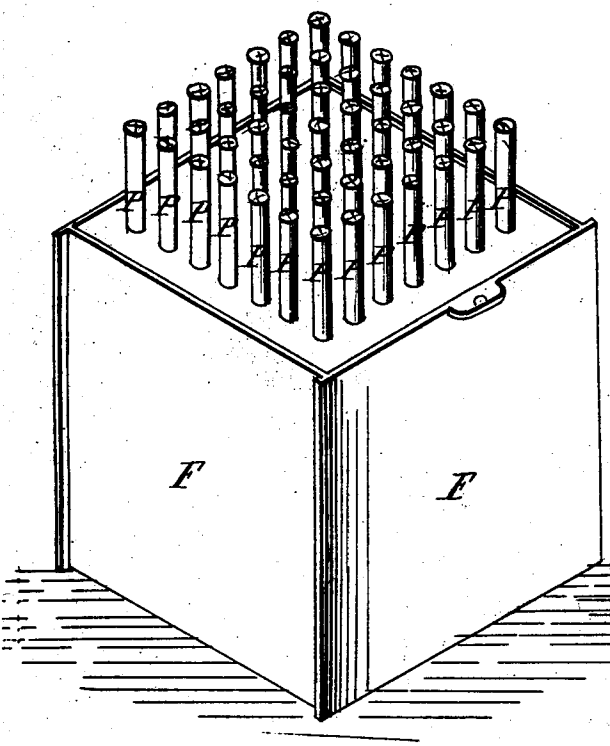
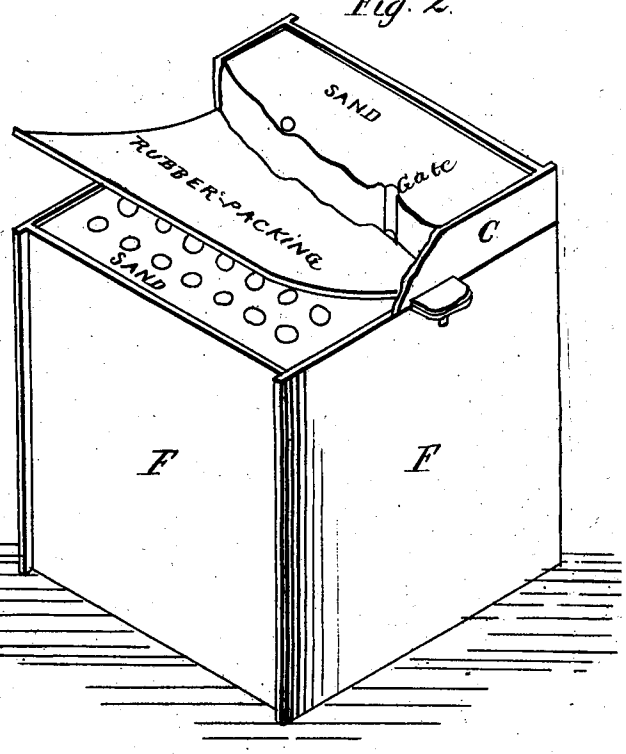


Fig. 2.



Flat Cap

Conical Cap

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WILLIAM W. PULLIS, OF ST. LOUIS, MISSOURI.

Letters Patent No. 101,504, *dated April* 5, 1870.

IMPROVEMENT IN MOLDING SASH-WEIGHTS.

The Schedule referred to in these Letters Patent and making part of the same.

To all whom it may concern:

Be it known that I, WILLIAM W. PULLIS, of the city and county of St. Louis, State of Missouri, have invented a new and improved Mode or Method of Molding Sash-Weights vertically; and I do hereby declare that that the following is a full and exact description thereof, reference being had to the accompanying drawings and the letters of reference marked thereon.

The nature of my invention consists in using plugs with flanges of metal or other suitable substance, to form a parting between the nowel and cope in molding sash-weights vertically, thereby forming sash-weights, of any length or weight, off of one set of patterns.

To enable others skilled in the art to make and use my invention, I will proceed to describe its construction and operation.

I construct my nowel F and cope C of either wood or iron, and of any desirable depth, using patterns P P P, &c., of any shape required. I ram them up in the sand in the nowel F, as shown in fig. 1; the loose sand then being brushed from between the patterns on the top of the nowel, I draw out the patterns; then, the top of sand in nowel being irregular and uneven, I insert in the molds the plugs H and K, with flanges of metal or other suitable substance; I then place on the cope, insert the gates, and ram the cope with sand, the flexible nature of the substance used as a parting allowing the sand of cope to follow the irregularities of sand in nowel. The operation is then in the condition as indicated in fig 2; I then withdraw my gates, lift off my cope, and withdraw from the molds the plugs H and K, cut my channels to conduct the metal, and the molds are ready to pour.

The advantages of this method over all others are as follows:

I secure a sash-weight, of any length or weight desirable, with a smooth clean end, of any desirable shape, molded off of one set of patterns. As in ramming the patterns vertically in the nowel, with their ends projecting above the top of the same, it is not practicable to obtain a plane surface parting, by using the device mentioned above, the sand in cope follows the irregularities of the sand in the nowel, thereby making a perfect part or joint between sand of cope and nowel after they are closed.

I pour any convenient number of sash-weights from one gate, and so simplify the old method that a common laborer can perform the work.

Claim

The plugs H and K, constructed and arranged in relation to the nowel and cope, as set forth.

W. W. PULLIS.

Witnesses:

ANDREW J. KENNEDY,

E. D. BALDWIN.