Dec. 11, 1928. 1,695,087

E. L. CARLSON

METHOD OF PRODUCING GONG STANDS FOR CLOCKS

Filed Jan. 20, 1928

FIG. 1.

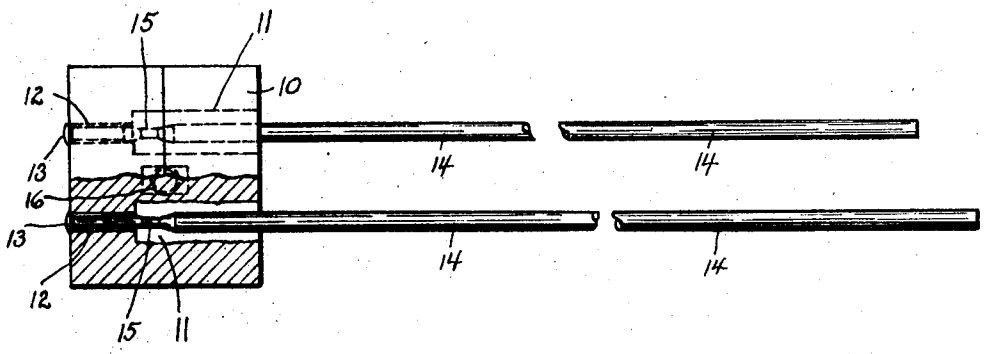


FIG. 2.

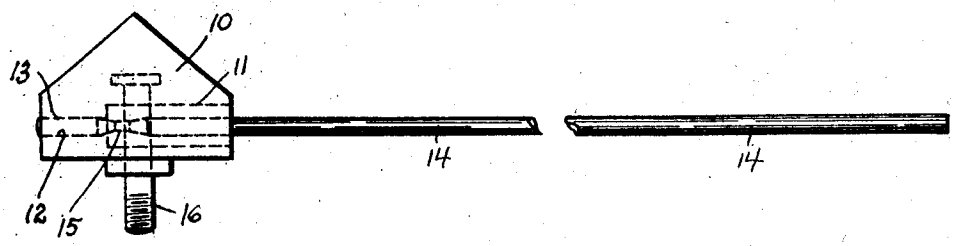


FIG. 4.

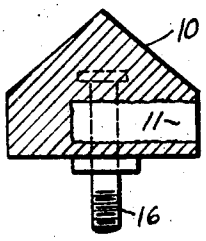


FIG. 3.

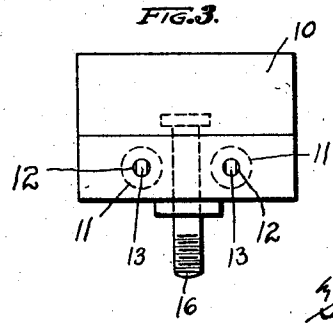
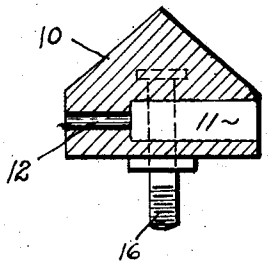


FIG. 5.



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UNITED STATES PATENT OFFICE.

ELOF L. CARLSON, OF BRISTOL, CONNECTICUT, ASSIGNOR TO THE E. INGRAHAM CO., OF BRISTOL, CONNECTICUT, A CORPORATION.

METHOD OF PRODUCING GONG STANDS FOR CLOCKS.

Application filed January 20, 1928. Serial No. 248,085.

My invention relates to an improved method of producing gong-stands for clocks, the object being to reduce the cost of producing the same to the minimum.

With these ends in view, my invention consists in a method of producing cast-metal gong-stands consisting in forming the clearance-chamber of the stand by coring the same concurrently with casting the stand and then subjecting the cored stand to a drilling operation for producing an anchoring-bore extending axially from the bottom of the clearance-chamber through the opposite wall of the stand to provide for the insertion of the anchoring-tang of the gong.

In the accompanying drawings:

Fig. 1 is a view partly in plan and partly in horizontal section of a gong-stand constructed in accordance with my invention, showing two rod-gongs installed therein;

Fig. 2 is a view thereof in side elevation;

Fig. 3 is a front face view of the stand;

Fig. 4 is a view of the stand in transverse section, showing the first step in my improved method, which consists in producing the clearance-chamber by coring; and

Fig. 5 is a corresponding view, showing the cored stand after it has been drilled for the production of its anchoring-bore, this being the second step in my improved method.

In carrying out my invention, a gong-stand 10 of any approved shape and size is cast with a cylindrical clearance-chamber 11 concurrently formed in it at the time of casting by coring in any approved manner. The stand is then subjected to a drilling operation to form an anchoring-bore 12 leading out of the center of the bottom of the clearance-chamber and extending through the opposite wall of the stand, the said anchoring-bore being considerably smaller in diameter than the clearance-chamber and designed for the drive-fit reception of the flattened anchoring-tang 13, which is separated from the rod-gong proper 14 by a doubly-beveled reduced portion 15, which prevents the vibrations of the rod from being dampened or modified by the mass of the stand into which a mounting-stud 16 is cast for the purpose of securing the stand to the clock-case. A marked economy in the mass production of such stands is effected by means of the method above described.

I claim:

A method of producing cast-metal gong-stands consisting in forming the clearance-chamber of the stand by coring the same concurrently with casting the stand and then subjecting the cored stand to a drilling operation for producing an anchoring-bore extending axially from the bottom of the clearance-chamber through the opposite wall of the stand to provide for the drive-fit insertion of the anchoring-tang of the said gong.

In testimony whereof, I have signed this specification.

ELOF L. CARLSON.