

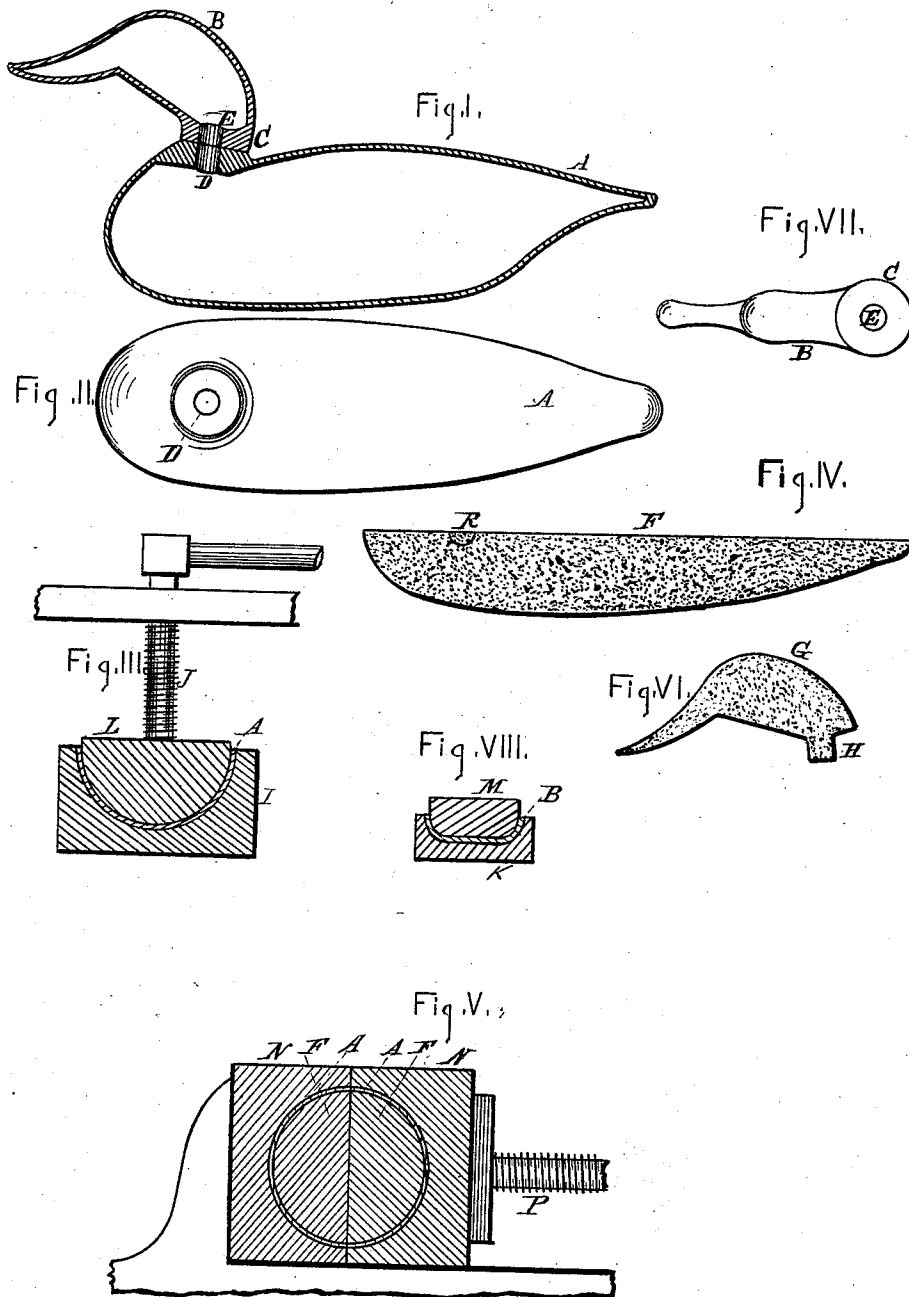
(No Model.)

G. H. NYE.

MANUFACTURE OF RUBBER DECOY DUCKS.

No. 349,315.

Patented Sept. 21, 1886.



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MANUFACTURE OF RUBBER DECOY-DUCKS.

SPECIFICATION forming part of Letters Patent No. 349,315, dated September 21, 1886.

Application filed February 2, 1886. Serial No. 190,609. (No model.)

To all whom it may concern:

Be it known that I, GEORGE H. NYE, a citizen of the United States, and a resident of Chicago, county of Cook, and State of Illinois, have invented new and useful Improvements in the Manufacture of Rubber Decoy-Ducks, of which the following is a specification, reference being had to the accompanying drawings, illustrating the invention, in which—

10 Figure I is a sectional elevation of one-half of the rubber shell of the body, neck, and head of a decoy-duck manufactured on my improved plan, the neck being shown in position with the body, but not attached; Fig. II, a plan or top view of the body of the decoy-duck complete, with the head and neck removed. Fig. III represents a cross-section of one-half of the shell of the duck as it is pressed into shape by dies. Fig. IV represents the form of the core for one half of the shell body of the duck. Fig. V is a transverse section of the two half-shells of the duck with the cores therein, and the dies in position, as when cementing the shells together. Fig. VI represents the core for one half of the neck and head of the duck. Fig. VII is an inverted view of the head and neck of the duck. Fig. VIII is a transverse section of one-half of the shell of the head in position in the dies as it is being pressed into shape.

This invention relates to the manufacture of decoy-ducks of rubber of such thickness that they will assume their original forms after having been put out of shape in the packing for shipment; and its nature consists, so far as this application is concerned, in the method of making the two half-shells of the body and those of the head and neck, and then uniting these half-shells to form the body and head part of the duck, as hereinafter fully described and shown.

A, Figs. I and III, represents a half-rubber shell of the duck after it has been pressed into shape, as follows: Two dies, I, are formed in reverse counterparts to fit the longitudinal exterior of the duck desired. The meeting faces of the dies being vertical on the middle of the duck, suitable inner forming-dies, L, are made to fit these reverse counterpart dies I, leaving spaces between them corresponding to the thickness of the sheet-rubber employed. The sheet-rubber is then cut in proper blanks and the blanks placed on the die I and pressed

into shape by the inner forming-dies, L, proper heat being employed, as is customary in the manufacture of rubber goods. The surplus rubber is then cut away level with the face of the die and the half-shell of the body of the duck removed. Reverse counterpart cores F R are formed of sand, by any well-known process, to correspond precisely with each reverse counterpart rubber shell, and placed inside thereof. The sections of rubber, with the cores therein, are placed together, with suitable cement between their edges, and then put in dies N N, Fig. V, which have the precise form of the die L and its reverse counterpart, and forced together with some proper power by a screw-press, P, or other power, and the rubber subjected to the usual heat for cementing the rubber together. The bodies of the ducks are then placed in water, which dissolves the cores, which are washed out through a hole, D, which is formed by the core projections R. The head B and neck C are formed in vertical longitudinal sections by dies, and cemented together over cores, in precisely the same manner as the body of the duck is made, and the two-part core run out at the hole E, which is formed by the projections H on them. A half-core, G H, for the head and neck, is shown at Fig. VI, and one section, B, of the rubber in the dies M K is shown at Fig. VIII.

There are other improvements in connection with perfecting this decoy-duck which are presented in a separate application of even date herewith.

I do not claim a rubber decoy-duck, but the method of manufacturing the same.

I claim as new and desire to secure by Letters Patent of the United States—

In the manufacture of the heads and necks and bodies of decoy-ducks from rubber, the reverse counterparts A B C, formed in dies having suitable contours, and the shells of rubber so formed filled with cores, respectively, and the rubber shells and cores subjected to pressure in a two-part die having the contour of the duck to be formed, and the two shells cemented together and the cores removed, substantially as specified.

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Witnesses:

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